



CO CO₂

4 7

1



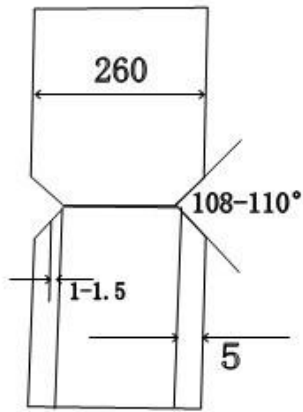
1

MIG
TIG
MIG MIG TIG
MIG
MIG

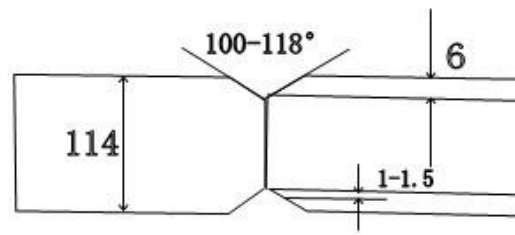
φ 260 φ 108 6

2

3-1 3-2

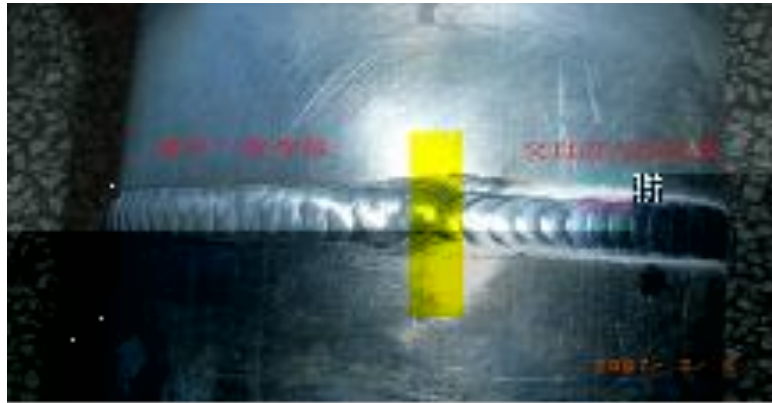


管对接垂直固定焊



管对接水平固定焊

2



3-1



3-2

3-1

3-2

15

100%

15

0

壁厚 (mm)	层次	钨极直径 (mm)	焊丝直径 (mm)	打底电流 (A)	余层电流 (A)	喷嘴直径 (mm)	氩气流量
2.5~5.0	1~2	2.5~3.2	2.5~3.2	130~170	150~220	10~12	10~12
5.0~8.0	2~3	3.2~4	3~4	170~220	200~240	12~16	12~14

4

99.5%

108 114mm,

4mm



4

δ 8mm

δ 8 16mm V

δ 16mm,

X

180-230A,

120-160A,

5

3



5