
































■CO<sub>2</sub>溶接条件例(メタル系フラックス入りワイヤ)

| ワイヤ径<br>(mm)  | 脚長<br>(mm)  | 下向すみ肉   |      |           |           |                | 水平すみ肉   |   |     |           |           |                |                 |
|---|---|---|------|-----------|-----------|----------------|---|---|-----|-----------|-----------|----------------|-----------------|
|   |   | 積層法   | 溶接条件 |           |           |                | 積層法   | 溶接条件  |     |           |           |                |                 |
|   |   |   | パス   | 電流<br>(A) | 電圧<br>(V) | 速度<br>(cm/min) |   | ガス流量<br>(ℓ/min)   | パス  | 電流<br>(A) | 電圧<br>(V) | 速度<br>(cm/min) | ガス流量<br>(ℓ/min) |
| 1.6   | 6   |    | 1    | 450       | 40        | 70             | 20~25   |    | 1   | 400       | 38        | 57             | 20~25           |
|   | 9   |    | 1    | 450       | 40        | 43             | 20~25   |    | 1   | 400       | 37        | 58             | 20~25           |
|   |   |   |      |           |           |                |   |    | 2   | 〃         | 36        | 62             |                 |
|   | 12  |    | 1    | 450       | 40        | 28             | 20~25   |    | 1   | 400       | 39        | 75             | 20~25           |
|   |   |   |      |           |           |                |   |    | 2   | 〃         | 〃         | 36             |                 |
|   |   |   |      |           |           |                |   |    | 3   | 〃         | 36        | 50             |                 |
|  |   |   |      |           |           |                |   | 1   | 400 | 39        | 35        | 20~25          |                 |
|  | 2   | 〃   | 36   | 67        |           |                |   |   |     |           |           |                |                 |
| 2.0   | 16  |  | 1    | 550       | 42        | 24             | 20~25   |  | 1   | 500       | 38        | 44             | 20~25           |
|   |   |   |      |           |           |                |   |  | 2   | 〃         | 〃         | 59             |                 |
|   |   |   |      |           |           |                |   |  | 3   | 〃         | 〃         | 52             |                 |
|   |   |   |      |           |           |                |   |  | 4   | 〃         | 〃         | 71             |                 |
|   | 19  |  | 1    | 600       | 43        | 25             | 20~25   |  | 1   | 550       | 40        | 56             | 20~25           |
|   |   |   |      |           |           |                |   |  | 2   | 〃         | 〃         | 60             |                 |
|   |   |   |      |           |           |                |   |  | 3   | 〃         | 〃         | 56             |                 |
|   |   |   |      |           |           |                |   |  | 4   | 〃         | 〃         | 77             |                 |
| 19  |  | 1   | 550  | 42        | 18        | 20~25          |  | 1   | 500 | 38        | 32        | 20~25          |                 |
|   |   |   |      |           |           |                |  | 2   | 〃   | 〃         | 42        |                |                 |
|   |   |   |      |           |           |                |  | 3   | 〃   | 〃         | 36        |                |                 |
|   |   |   |      |           |           |                |  | 4   | 〃   | 〃         | 51        |                |                 |
| 19  |  | 1   | 600  | 43        | 20        | 20~25          |  | 1   | 550 | 40        | 42        | 20~25          |                 |
|   |   |   |      |           |           |                |  | 2   | 〃   | 〃         | 53        |                |                 |
|   |   |   |      |           |           |                |  | 3   | 〃   | 〃         | 48        |                |                 |
|   |   |   |      |           |           |                |  | 4   | 〃   | 〃         | 78        |                |                 |