
マヒドン大学・タイ国立金属材料技術研究センター（タイ） 研修報告書
GMAW における施工現象の解明

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Table5.2.1 Material components.

Table5.2.2 Shooting.

Table5.2.3 Experimental conditions.

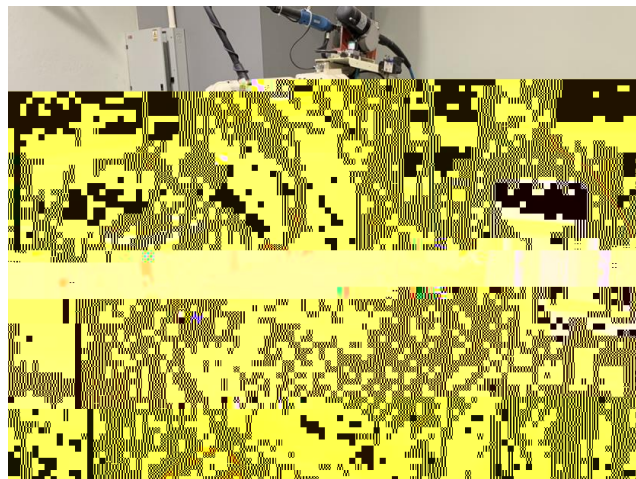


Fig5.2.1 Experimental appearance.

Table5.2.4 Material components.

Materials	Chemical composition, wt%								
	C	Si	Mn	P	S	Mo	Al	Cu	Ti + Zr
YGM1?	0.02~0.15	0.50~1.00	1.25~2.00	≤0.030	≤0.030			≤0.050	

Table5.2.5 Experimental conditions.

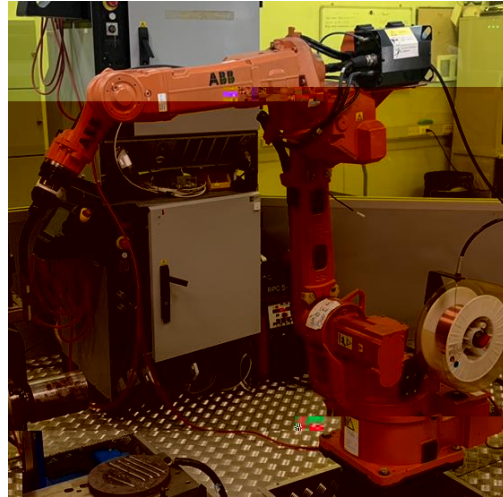
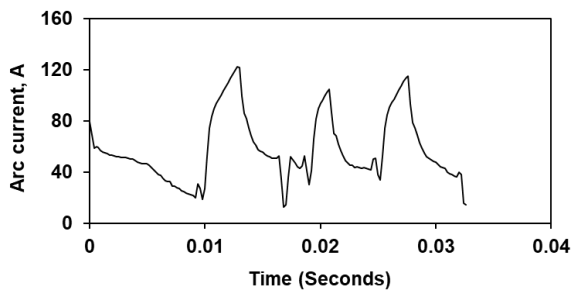
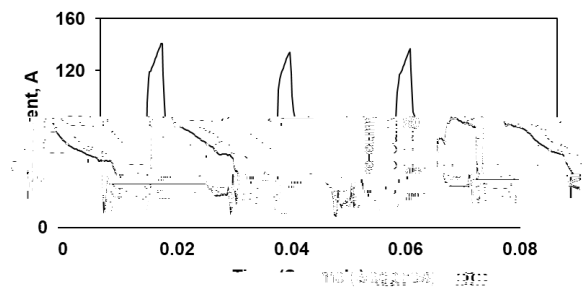


Fig5.2.2 Experimental appearance.

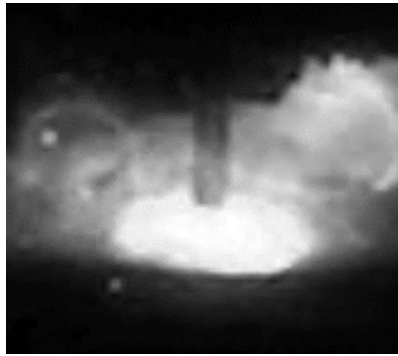


(a)Arc current 170A.



(b)Arc current 200A.

Fig5.3.1 Current measurement results.



(a) Arc current 170A.



(b) Arc current 200A.

Fig5.3.2 High-speed camera image.

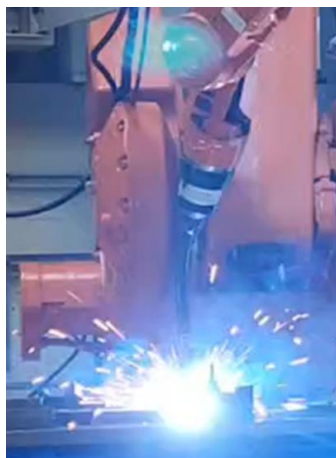


(a) Welding speed 1.5m/min.



(b) Welding speed 2.5m/min.

Fig5.3.3 Bead appearance.



(a) Welding speed 1.5m/min.

