

→ Продолжение таблицы 1

№ п/п	Толщина материала t , мм	Тип подкладки	Обозначение (в соответствии с [2])	Поперечное сечение	Размеры				Рекомендуемый сварочный процесс (№ в соответствии с [2])	Исполнение сварного шва	Примечания
					Угол α , °	Запас δ , мм	Размер приуглубления c , мм	Глубина обработки кромок f , мм			
1.4	> 10	С U-образным видом кромок с увеличенным зазором			$0^\circ < \alpha < 20^\circ$	$5 < \delta < 15$	-	-	111 13		С подкладкой
1.5	$5 < t < 40$	С U-образным видом кромок с увеличенными приуглублениями			$\alpha = 60^\circ$	$1 < \delta < 4$	$2 < c < 4$	-	111 13 141		-
1.6	> 12	С U-образным видом кромок с U-образными корнями			$60^\circ < \alpha < 90^\circ$ $0^\circ < \beta < 12^\circ$	$1 < \delta < 3$	-	≈ 4	111 13 141		$0 < R < 0,5$
1.7	≈ 12	С U-образным видом кромок с U-образными корнями			$60^\circ < \alpha < 90^\circ$ $10^\circ < \beta < 15^\circ$	$2 < \delta < 4$	≤ 2	-	111 13 141		-
1.8	> 12	С U-образным видом кромок			$0^\circ < \beta < 12^\circ$	≤ 4	≤ 3	-	111 13 141		-

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Lingjun Ying



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