[illegible]碳[illegible]高强钢用手焊条

[illegible](J427)

药皮类型：低[illegible]

适用于低碳[illegible]、490MPa级高强度钢[illegible]船舶、

1、焊[illegible]接前焊[illegible]烘干[illegible]

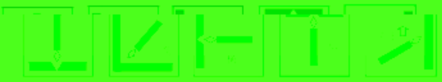
2、为防止起弧发生缺陷，建议采用后退前进法焊接。

3、宜采用短弧焊接，如摆动运条，摆[illegible]动幅度不超过焊条直径的3倍。

熔敷金属化学成份(wt[illegible]

[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	560	25	-20℃/82	AW

适用焊接位置



推[illegible]参数(DCEP、AC)

[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
90-130	140-190	1[illegible]	[illegible]	平焊