缺陷，建议采用后退前进法焊接。

3、宜采用[illegible]，如摆动运条，摆动幅度[illegible]

熔敷金属化[illegible]成份(wt%)

	C	Mn	Si	P	S	Ni	Cr
[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]

0.30

50-80 | 85-120 | 125-160