

超过500A的大电域也能实现安定射流过渡、高能率&低飞溅的新焊接工序

# 大电流MAG Process

## Ultra High Current MAG Welding Process

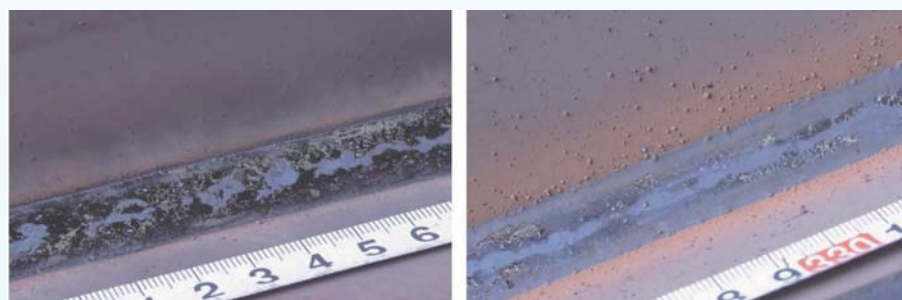
### 射流过度及低飞溅 / Spray arc & Low spatter

即使在大电域用实芯焊丝会产生旋转熔滴过渡，但是只要使用我公司专用的药芯焊丝即可保证安定的射流过渡。飞溅发生量与以前相比大幅度减少。



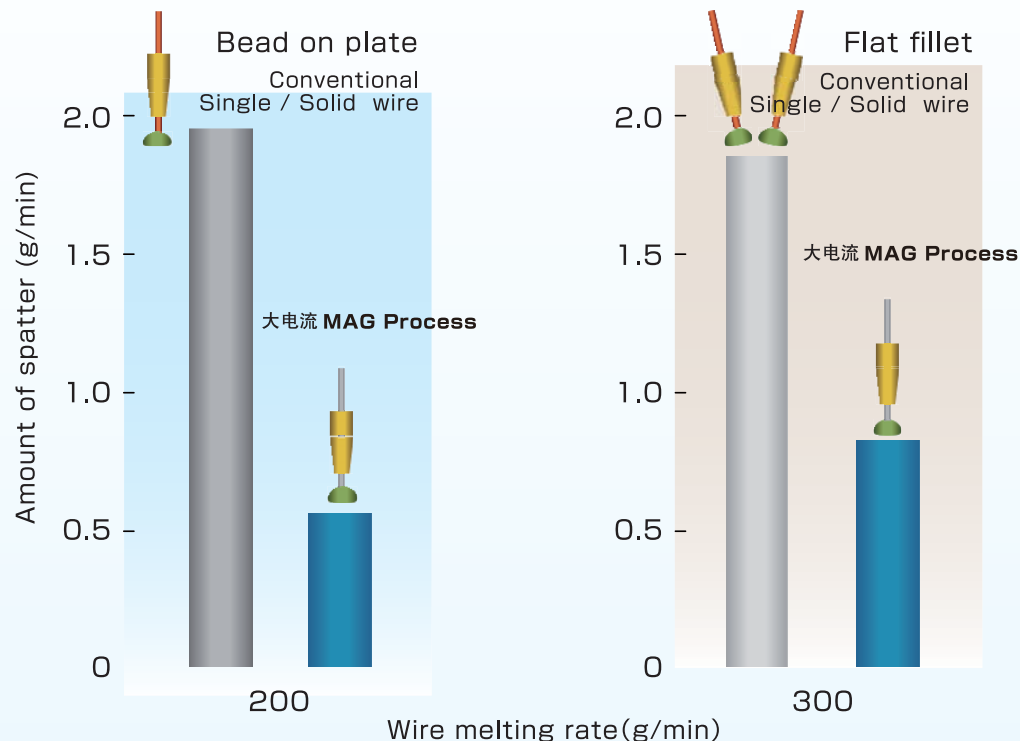
大电流 MAG Process

Conventional process



大电流 MAG Process

Conventional process

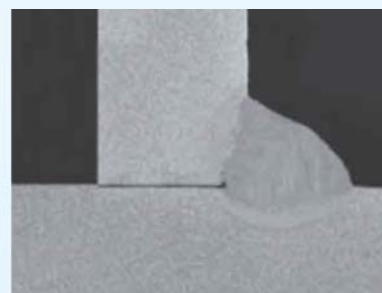
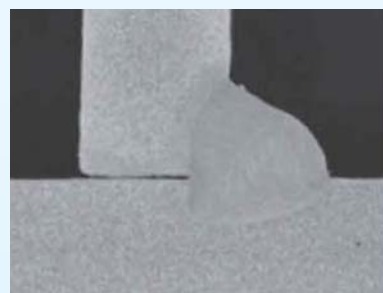


### 高熔深 / Deep penetration

大电流 MAG Process 与现在的高能率双丝焊接相比、可以得到更高的熔深。

Penetration depth : 3.0mm

大电流 MAG Process  
485A Speed : 60cm / min



Penetration depth : 2.0mm

Conventional : Tandem Process / Solid wire  
L : 310A T : 285A Speed : 85cm / min

Horizontal fillet welding (Leg length : 7 ~ 8mm)

### 大电流MAG process与双丝焊接各自的优势 / Benefits of Ultra High Current MAG Welding Process and Tandem process

### 大电流MAG process的构成 / Composition of Ultra High Current MAG Welding Process

高能率焊接法大电流 MAG Process 以及双丝焊接法各有各的优点。大电流 MAG Process 为单丝,所以在示教上更为方便、焊接残留更少等优势。

焊接机器人 / Welding robot

ARC MAN™  
-MP

专用焊丝 / Welding wire

FAMILIARC™  
MX-A100D  
1.4mm φ

焊接电源 / Power source

SENSARC™  
AB500  
Parallel running system

	大电流 MAG Process	Tandem process Solid wire
熔透速度 Deposition rate	◎	◎
飞溅(电弧干涉) Spatter	◎	△
最大焊接速度 Maximum welding speed	○	◎
熔深 Depth of penetration	◎	△
操作性 Operation ability	◎	△
保护气费用 Shielding gas cost	◎	△
焊丝费用 Welding wire cost	△	◎

FAMILIARC™  
MX-A100D  
1.4mm φ

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AB500  
Parallel running system

