



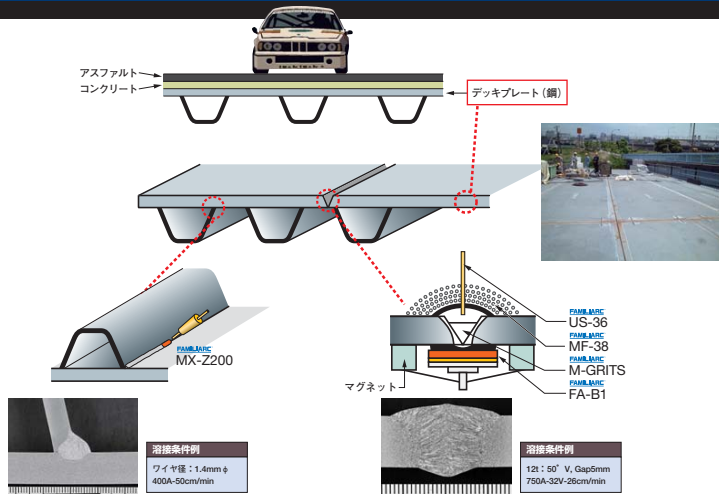
Carqueinez Bridge
写真提供：(株)H-I 愛知事業所



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橋梁の溶接材料

Welding Consumables for Bridges



一般鋼および耐候性鋼用溶接材料

Welding consumables for mild steel, 490MPa steel and atmospheric corrosion resisting steel

For mild steel and 490MPa steel

SMAW: LB-26, LB-52

FCAW: DW-Z100, MX-Z200

GMAW: MG-1, MG-50

SAW: US-36/MF-38

FAMILIARC US-36/MF-38/M-GRITS/FA-B1

For atmospheric corrosion resisting steel

SMAW: LB-W52B

FCAW: DW-50W, MX-50W

GMAW: MG-W50TB

SAW: US-W52B/MF-38

FAMILIARC US-W52B/MF-38/M-GRITSW/FA-B1

Ni系高耐候性鋼用溶接材料

Welding consumables for Ni-advanced weathering steel

Strength Class 400 ~ 490MPa

Ni-Cu-Ti type

SMAW: LB-50WT

FCAW: DW-50WT, MX-50WT

SAW: US-50WT/MF-38, US-50WT/MF-53

Ni-Cu type

SMAW: LB-W52CL

FCAW: DW-50WCL, MX-50WCL

SAW: US-W52CL/MF-38, US-W52CL/MF-53

BHS 鋼用溶接材料

Welding consumables for BHS steel

SMAW: LB-62UL

FCAW: DW-60, MX-60, MX-60F

GMAW: MG-60 (100%CO₂), MG-S63B (Ar+20%CO₂)

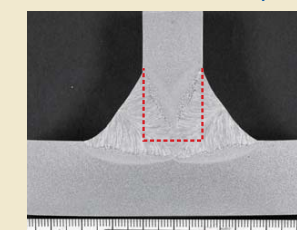
SAW: US-40/MF-38, US-40/MF-63

厚板ビルトH用溶接材料

Welding consumables for heavy built-up H-frames

T形継手の断面マクロ組織の一例

Cross sectional macrostructure of T-welded joint



US-36/PF-H60BS

溶接条件例 Welding condition
L: 1300A-32V
T: 1000A-42V
溶接速度: 35cm/min
Welding speed

ウェブ: 板厚 25mm (開先加工無)
フランジ: 板厚 32mm
鋼材: SM490A
Web: 25-mm thick. (without beveling)
Flanges: 32-mm thick
Steel grade: SM490A

