

橋梁の溶接材料

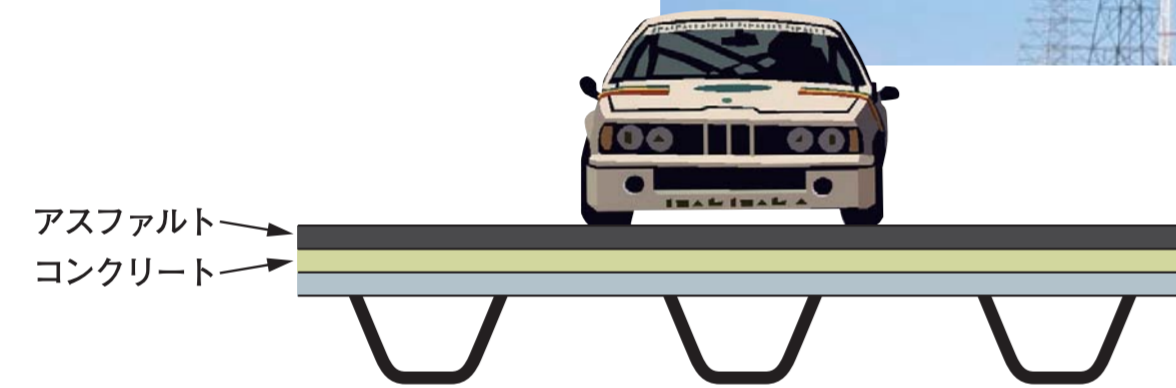
Welding consumables for Bridges



Carquinez Bridge
写真提供：(株)IHI 愛知事業所殿



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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	For atmospheric corrosion resisting steel
MAW: LB-26, LB-52	SMAW: LB-W52B
FCAW: DW-Z100, MX-Z200	FCAW: DW-50W, MX-50W
GMAW: MG-1, MG-50	GMAW: MG-W50TB
SAW: US-36/MF-38	SAW: US-W52B/MF-38
US-36/MF-38/M-GRITS/FA-B1	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

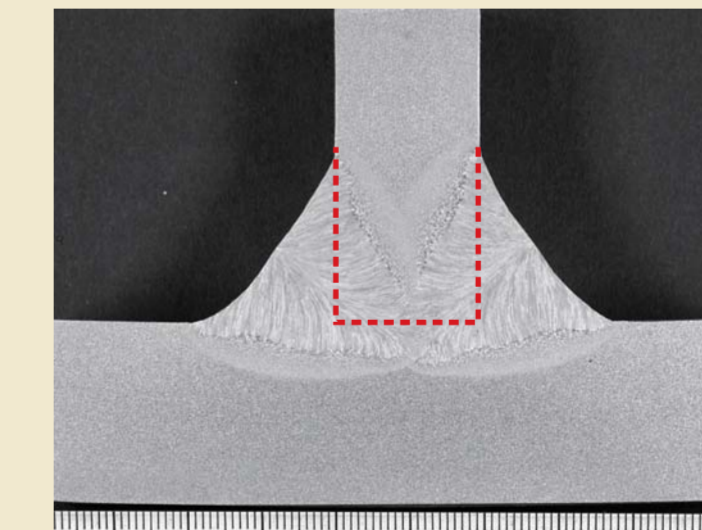
Ni-Cu-Ti type	Ni-Cu type
SMAW: LB-50WT	SMAW: LB-W52CL
FCAW: DW-50WT, MX-50WT	FCAW: DW-50WCL, MX-50WCL
SAW: US-50WT/MF-38, US-50WT/MF-53	SAW: US-W52CL/MF-38, US-W52CL/MF-53

BHS鋼用溶接材料
Welding consumables for BHS steel

SMAW: LB-62UL	GMAW: MG-60 (100%CO ₂), MG-S63B (Ar+20%CO ₂)
FCAW: DW-60, MX-60, MX-60F	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



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)
Flange: 32-mm thick
Steel grade: SM490A

溶接条件例 Welding condition
US-36/PF-H60BS
L: 1300A-32V
T: 1000A-42V
溶接速度: 35cm/min
Welding speed

