

LNG タンクの溶接材料

Welding Consumables for LNG Tanks



写真：(株)IHI 提供

サブマージアーク溶接例
Example of Submerged Arc Welding



PREMIARC
PF-N4/US-709S

被覆アーク溶接例
Example of Shielded Metal Arc Welding



PREMIARC
NI-C70S

PREMIARC
NI-C1S

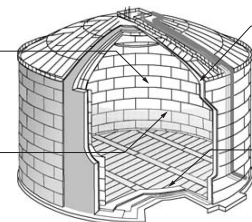
MAG 溶接 (フラックス入りワイヤ) 例
Example of Metal Active Gas Welding



PREMIARC
DW-N70S

側板の立向溶接
Vertical up weld of side plate
(GTAW, SMAW and GHAW)

側板の横向溶接
Horizontal weld of side plate
(SAW, GTAW)



屋根板のすみ肉溶接
Fillet weld of roof plate
(GMAW, SMAW)

底板の上向および下向溶接
Overhead weld of bottom plate
(GTAW, SAW and GMAW)

圧力容器の溶接材料

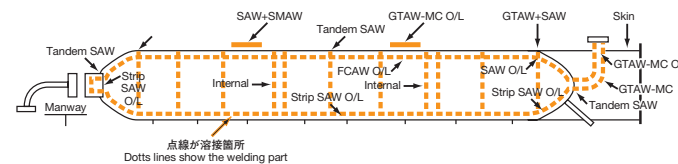
Welding Consumables for Pressure Vessels



2電極サブマージアーク溶接
Submerged arc welding by tandem method



内面の肉盛 (バンド溶接)
Strip submerged arc welding for overlay



鋼種 Steel type	溶接材料の一例 Example of welding consumables		
	SMAW 極性：AC	SAW (PF：フラックス) 極性：AC	GTAW 極性：DCEN
1.25Cr-0.5Mo 鋼 1.25Cr-0.5Mo steel	TRUSTARC CM-A96MB	TRUSTARC US-511N / PF-200	TRUSTARC TG-S1CM
2.25Cr-1Mo 鋼 2.25Cr-1Mo steel	TRUSTARC CM-A106N	TRUSTARC US-521S / PF-200	TRUSTARC TG-S2CM
2.25Cr-1Mo-V 鋼 2.25Cr-1Mo-V steel	TRUSTARC CM-A106H	TRUSTARC US-521H / PF-500	TRUSTARC TG-S2CMH
Type347 Stainless steel Overlay weld metal	PREMIARC NC-39L (1st) PREMIARC NC-37L (2nd ~)	PREMIARC US-B309Lcb / PF-B7FK* PREMIARC US-B347LP / PF-B1FP**	PREMIARC TG-S309L (1st) PREMIARC TG-S347 (2nd ~)

* : ESW (DCEP)
** : SAW (DCEP)