**熔敷金属化学成分分析**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| C | Mn | Si | Cr | Fe |
| 0.05 | 0.8 | 0.6 | 17.5 | Bal. |

**焊缝金属的机械性能（三层）**

 硬度： 220HB

**使用条件**

 电流类型：DC(+)

 防护措施：自保护或埋弧焊

**工作条件**

|  |  |  |  |
| --- | --- | --- | --- |
| 直径[mm] | 电流[A] | 电压[A] | 干伸长[mm] |
| 2.4 | 250-400 | 26-35 | 25-40 |
| 2.8 | 250-450 | 28-35 | 25-45 |