**熔敷金属化学成分分析**

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| C | Mn | Si | Cr | others | Fe |
| 5.5 | 1.45 | 1.25 | 27.0 | ＜1.0 | Bal. |

**焊缝金属的机械性能（三层）**

 硬度：58-62HRC

**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] |
| 2.8 | 300-450 | 28-35 | 30-50 |
| 3.2 | 300-500 | 28-35 | 30-55 |