

: , , ,
.

1.

[1]

- [2, 3]

:

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, , ,
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. , ,

,
.[4, 5]

2.

250, 350, 400, 450 200 12, , :

[1],

[6, 7]. 150 50 10 .

1

HRC [1, 8], 2, 3, 4 5

- R.

, Arc251i ESAB ().

0,01 g.

.1, 2, 3, 4 , R, ,

.1. , %

		, %				, HRC
		C	Si	Cr	Mn	
1	250	0,15	0,60	1,00	1,60	22÷23
2	350	0,20	1,00	1,80	1,60	36÷37
3	400	0,20	0,50	2,90	1,10	37÷42
4	550	0,50	2,40	9,00	0,40	54÷56
5	200 12	2,00	0,40	14,0	0,60	40÷56

.2.

		d_e , mm	d_0/d_e	I , A	t , s	l_0 , mm	l , mm	S , mm	G , g	g/Ah
1	250	4,0	1,69	170	79,75	450	123	12,56	32,20	8,55
2	350	4,0	1,73	170	95,46	450	74	12,56	37,09	8,22
3	400	5,0	1,64	192	121,05	450	71	19,62	37,33	5,78
4	550	4,0	1,78	170	106,83	450	78	12,56	36,72	7,27
5	200 12	4,0	1,73	170	112,92	450	121	12,56	32,48	6,09

d_0 -

.3.

-

		$d_0, \text{ mm}$	$I, \text{ A}$	$G_1, \text{ g}$	$G_2, \text{ g}$	$G, \text{ g}$	g/Ah
1	250	4,0	170	860	900	40,0	10,62
2	350	4,0	170	855	900	45,0	9,98
3	400	5,0	192	850	915	65,0	10,07
4	550	4,0	170	845	890	45,0	8,92
5	200 12	4,0	170	815	850	35,0	8,43

.4.

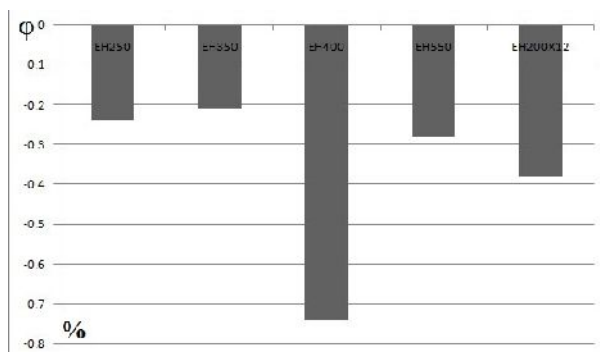
-

		$d_0, \text{ mm}$	g/Ah	g/Ah	, , \%
1	250	4,0	8,55	10,62	-0,24
2	350	4,0	8,22	9,98	-0,21
3	400	5,0	5,78	10,07	-0,74
4	550	4,0	7,27	8,92	-0,28
5	200 12	4,0	6,09	8,43	-0,38

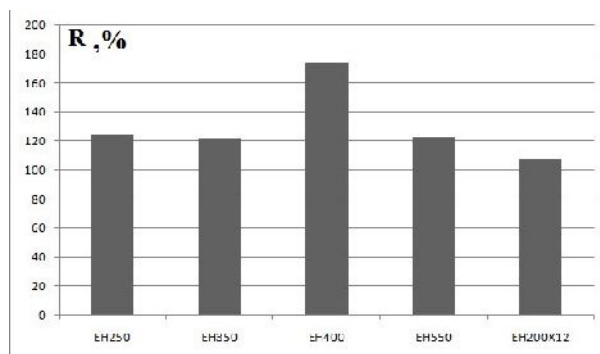
.5.

- R

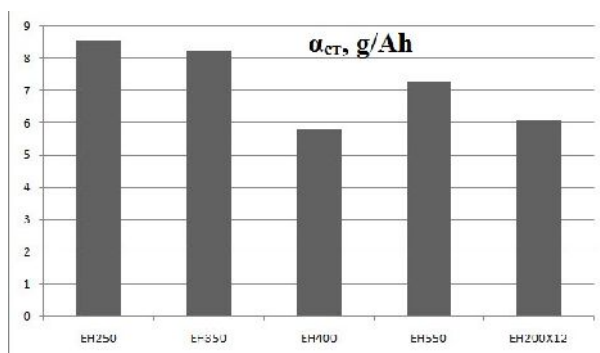
		$d_0, \text{ mm}$	$G, \text{ g}$	$G, \text{ g}$, R, \%
1	250	4,0	40,0	32,20	124,2
2	350	4,0	45,0	37,09	121,3
3	400	5,0	65,0	37,33	174,1
4	550	4,0	45,0	36,72	122,6
5	200 12	4,0	35,0	32,48	107,8



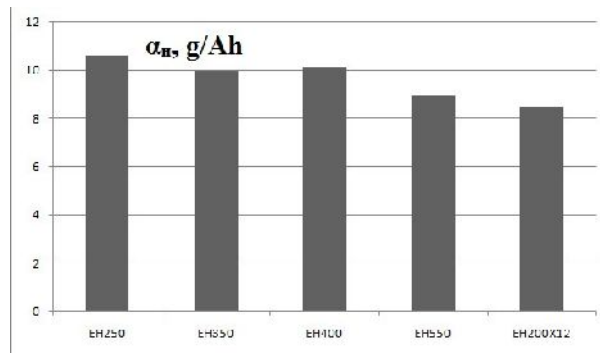
.1. ()
 (250, 350, 400, 550, 200 12)



.2. (R)
 (250, 350, 400, 550, 200 12)



.3. ()
 (250, 350, 400, 550, 200 12)



4. ()
 (250, 350, 400, 550, 200 12)

3.

1.

2.

3.

400 (= - 0,74%)

4.

(107,8 – 174,1)% -

400.

1. – , , 2002 – 2003 – 93 .

2. . ,, . ,,

, , – , 2016, 34

-39 .

3. . ,, . ,, . ,,
 , , , 2004, 54 – 57 .

4. . . . , , ,
1973 – 173 .
5. . . . - . . .
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2011, . 19-23
6. . . . , -
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