

手工焊坡口型式

<p>V-1</p> <p>$t_1 - t < 3$ $b = 2^{+1}$ $t = 6 - 13$ $h = p = +1$ $t = 14 - 24$ $p = 2^{+2}$ $60^\circ \pm 5^\circ$</p>	<p>V-1*</p> <p>$t_1 - t < 3$ $b = 2^{+1}$ $t = 6 - 13$ $h = p = +1$ $t = 14 - 24$ $p = 2^{+2}$ $60^\circ \pm 5^\circ$</p>	<p>V-1(1)</p> <p>$t_1 - t < 3$ $b = 2^{+1}$ $l = 4(t_1 - t)$ $t = 6 - 13$ $h = p = +1$ $t = 14 - 24$ $p = 2^{+2}$ $60^\circ \pm 5^\circ$</p>	<p>V-2</p> <p>$t \leq 45$ $P = 2^{+1}$ $b = 2^{+1}$ $35^\circ \pm 6^\circ$</p>	<p>V-2(2)</p> <p>$t \leq 45$ $t_1 - t \geq 1$ $P = 2^{+1}$ $b = 2^{+1}$ $l = 4(t_1 - t)$ $35^\circ \pm 6^\circ$</p>	<p>X-1</p> <p>$t > 24$ $b = 2^{+1}$ $t_1 - t < 3$ $P = 3^{+0}$ $h = l/3$ $60^\circ \pm 5^\circ$</p>
<p>X-1(1)</p> <p>$t > 24$ $t_1 - t \geq 3$ $b = 2^{+1}$ $P = 3^{+0}$ $h = l/3$ $60^\circ \pm 5^\circ$</p>	<p>K-1</p> <p>$17 \leq t \leq 45$ $b = 2^{+1}$ $p = 3^{+0}$ $h = l/3$</p>	<p>K-2</p> <p>$t \leq 16$ $b = 2^{+1}$ $t = l/3$</p>	<p>Y-3</p> <p>$30^\circ \pm 2^\circ$ $30^\circ \pm 2^\circ$ $P = 2^{+1}$</p>	<p>Y-4</p> <p>$25^\circ \pm 2^\circ$ $30^\circ \pm 2^\circ$ $P = 2^{+1}$ $h = t = p$</p>	<p>X-1</p> <p>$t > 24$ $b = 2^{+1}$ $t_1 - t < 3$ $P = 3^{+0}$ $h = l/3$ $60^\circ \pm 5^\circ$</p>

自动焊和半自动焊坡口型式

$\frac{A[-1]}{1}$ $\leq 1, t_1 - t_2 < 3, b = 0$ $L = 4(t_1 - t_2) \quad P = 6 \pm 2 \quad b = 0 \pm 2$ $h = t/3$	$\frac{A[-1]}{1}$ $\leq 1, t_1 - t_2 > 3$ $L = 4(t_1 - t_2) \quad b = 0 \pm 1$	$\frac{A[-1]}{1} \quad t_1 - t_2 < 3, b = 0 \pm 1$ $L = 12 \sim 18a \quad p = 7 \pm 1$ $L = 19 \sim 24a \quad p = 8 \pm 1$ $60^\circ \pm 5^\circ$	$\frac{A[-1]}{1} \quad b = 0 \pm 1$ $L = 12 \sim 18a \quad p = 7 \pm 1$ $L = 19 \sim 24a \quad p = 8 \pm 1$ $60^\circ \pm 5^\circ$	$\frac{A[-1]}{1} \quad t_1 - t_2 < 3, b = 0 \pm 1$ $L = 12 \sim 18a \quad p = 7 \pm 1$ $L = 19 \sim 24a \quad p = 8 \pm 1$ $60^\circ \pm 5^\circ$	$\frac{A[-1]}{1}$ $> 2 \frac{1}{2} \quad t_1 - t_2 < 3, b = 0 \pm 2$ $L = 12 \sim 18a \quad p = 7 \pm 1$ $L = 19 \sim 24a \quad p = 8 \pm 1$ $60^\circ \pm 5^\circ$
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CO₂气体保护焊坡口型式

<p>CV-1 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-1* $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-1(1) $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-1(1)* $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-1 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>	<p>CV-1(1) $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>
<p>CV-2 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-2* $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-2(1) $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-2(1)* $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-2 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>	<p>CV-2(1) $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>
<p>CV-3 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-3* $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-3(1) $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-3(1)* $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-3 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>	<p>CV-3(1) $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>
<p>CV-4 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-4* $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-4(1) $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-4(1)* $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-4 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>	<p>CV-4(1) $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>
<p>CV-5 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-5* $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{2}$</p>	<p>CV-5(1) $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-5(1)* $t \leq 2t_1, t_1 \geq 3, t_1 = (t_1 - 1), b = 6 \cdot \frac{1}{2}$</p>	<p>CV-5 $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>	<p>CV-5(1) $t \leq 2t_1, t_1 \leq k/3, b = 6 \cdot \frac{1}{3}$</p>