

Таблица 1 — Подготовка соединений для односторонних стыковых сварных швов

№ п/п	Толщина материала t , мм	Тип подготовки	Обозначение (в соответствии с [2])	Поперечное сечение	Размеры				Рекомендуемый сварочный процесс (№ в соответствии с [2])	Способ сварки	Примечания
					Угол α , °	Зазор b , мм	Размер припускаемой c , мм	Глубина обей-ботки кромок d , мм			
1.1	≤ 2	С отбортовкой кромок			-	-	-	-	3 111 141 512		Обычно без присадочного металла
1.2.1	≤ 4	Без скоса кромок			-	-	-	-	3 111 141		-
1.2.2	$3 < t \leq 8$								13		
	≤ 15								141 ^a		
									52		
1.2.3	≤ 100	Без скоса кромок с подкладкой	-		-	-	-	-	51		-
1.2.4		Без скоса кромок с центрирующим выступом (ланкой)	-								
1.3	$3 < t \leq 10$	С V-образным скосом кромок	V		$40^\circ \leq \alpha \leq 60^\circ$	≤ 4	≤ 2	-	3 111 13 141		С удаленной (слезной) подкладкой
	$8 < t \leq 12$				$6^\circ \leq \alpha \leq 8^\circ$	-	-	-	52 ^d		

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