

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 прилегающей 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		С удаленной (съемной) подкладкой
1.2.2	$3 < t \leq 8$				$\delta \leq b \leq \delta$	-	-	13			
	≤ 15				$\leq t$	-	-	141 ^a			
					δ	-	-	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 (съемной) подкладкой
	$6^\circ \leq \alpha \leq 8^\circ$				-	-	-	52 ^d			

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Table of Contents Iso 9692 1

1. Understanding the eBook Iso 9692 1
 - The Rise of Digital Reading Iso 9692 1
 - Advantages of eBooks Over Traditional Books
2. Identifying Iso 9692 1
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Iso 9692 1
 - User-Friendly Interface
4. Exploring eBook Recommendations from Iso 9692 1
 - Personalized Recommendations
 - Iso 9692 1 User Reviews and Ratings
 - Iso 9692 1 and Bestseller Lists
5. Accessing Iso 9692 1 Free and Paid eBooks
 - Iso 9692 1 Public Domain eBooks
 - Iso 9692 1 eBook Subscription Services
 - Iso 9692 1 Budget-Friendly Options
6. Navigating Iso 9692 1 eBook Formats

- ePub, PDF, MOBI, and More
- Iso 9692 1 Compatibility with Devices
- Iso 9692 1 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Iso 9692 1
 - Highlighting and Note-Taking Iso 9692 1
 - Interactive Elements Iso 9692 1
- 8. Staying Engaged with Iso 9692 1
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Iso 9692 1
- 9. Balancing eBooks and Physical Books Iso 9692 1
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Iso 9692 1
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Iso 9692 1
 - Setting Reading Goals Iso 9692 1
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Iso 9692 1
 - Fact-Checking eBook Content of Iso 9692 1
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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