

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 | $3 < t \leq 8$ | | | | $\delta \leq b \leq \delta$ | - | - | 13 | | | |
| | | | | | $\approx t$ | - | - | 141 ^а | | | |
| | | | | | $\leq 1^{\text{в}}$ | - | - | 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 |
| | $6^\circ \leq \alpha \leq 8^\circ$ | | | | - | - | - | 52 ^д | | | |

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