

■ Aluminum 3003-O to A6N01-T5 Lap Joint weld test

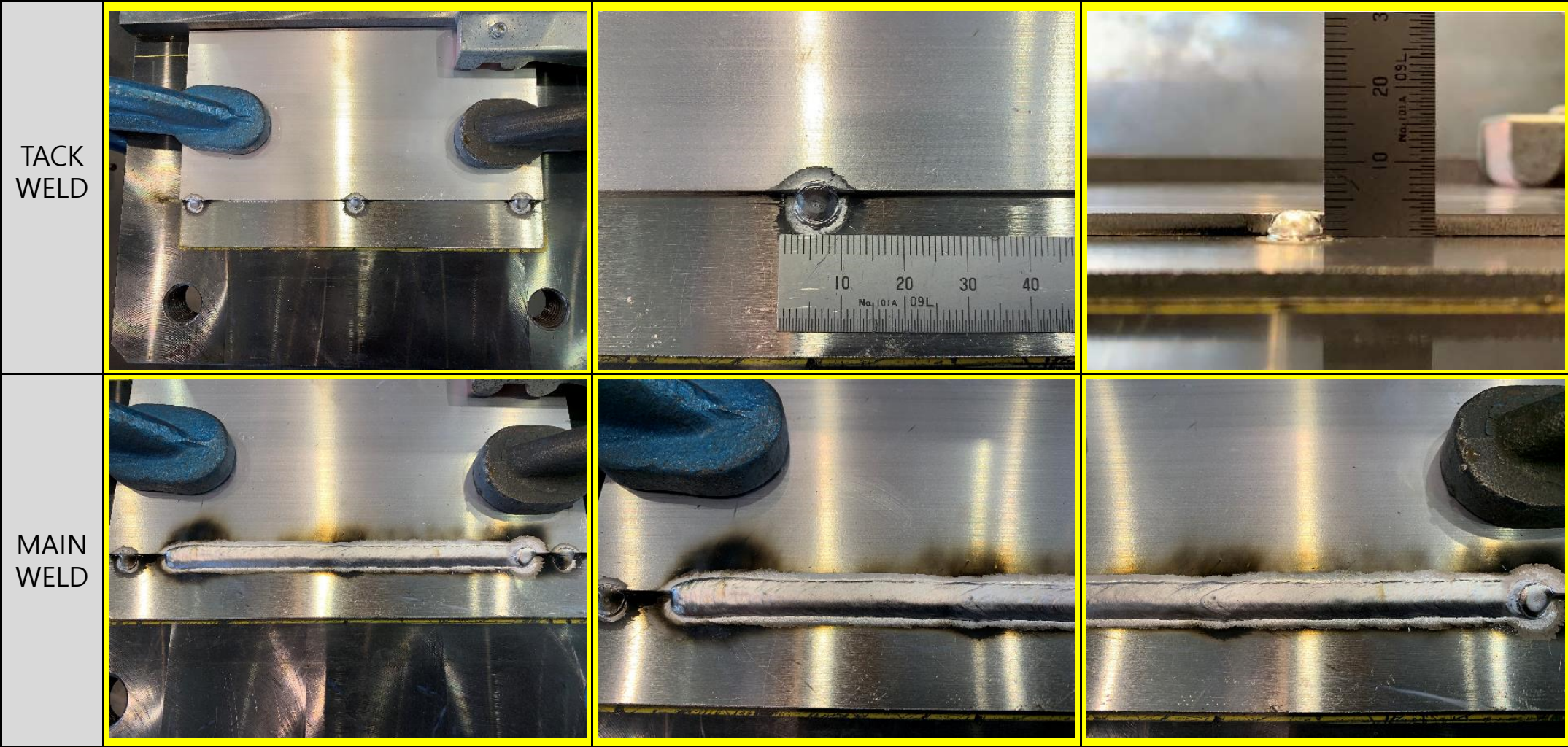
TEST Welding Condition

	TACK	WELD
WFS(CRATER)	760cpm	780cpm(400cpm)
Ultim. Arc	8.0	5.5
Trim	0.95(150A/20V)	0.98(0.85) (170A/20.5V, 150A/19.3V)
T <sub>tack</sub>	0.3sec	-
V <sub>weld</sub>	-	80cpm
T <sub>delay</sub>	-	1.2sec
A <sub>work</sub>	30deg.	30deg.
A <sub>prog.</sub>	-	25deg.
GAS flow	22ℓ/min	
GAS Nozzle Dia.	62mm	

※ Welding Power-source : LINCOLN Powerwave R450  
 Welding Robot : FANUC Arcmate 100iC

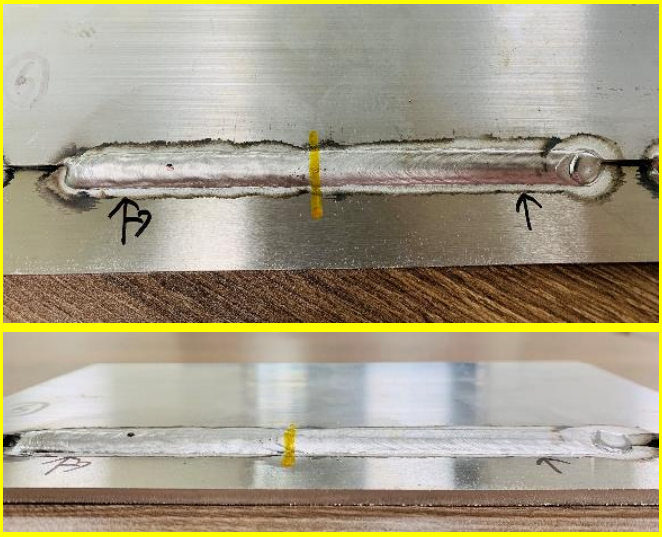
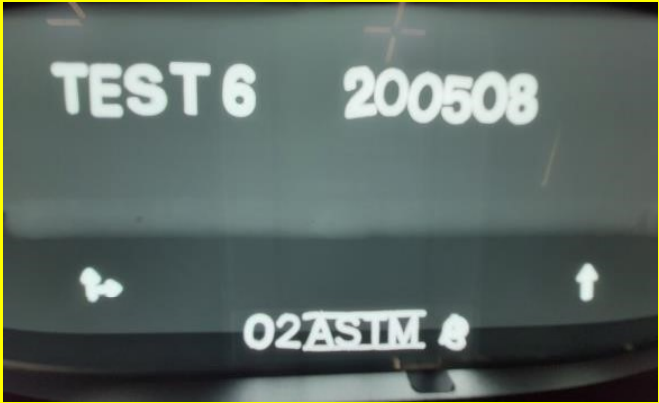
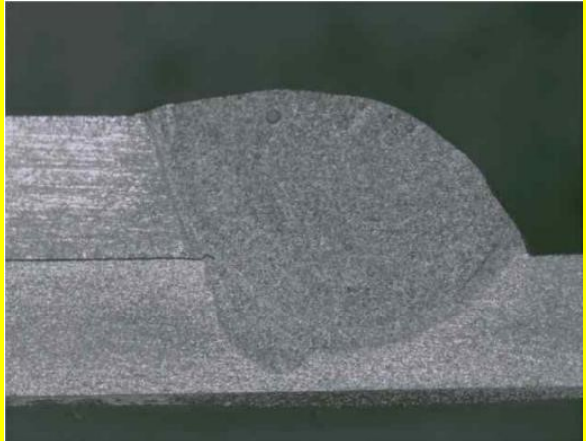
■ Aluminum 3003-O to A6N01-T5 Lap Joint weld test

Weld bead appearance



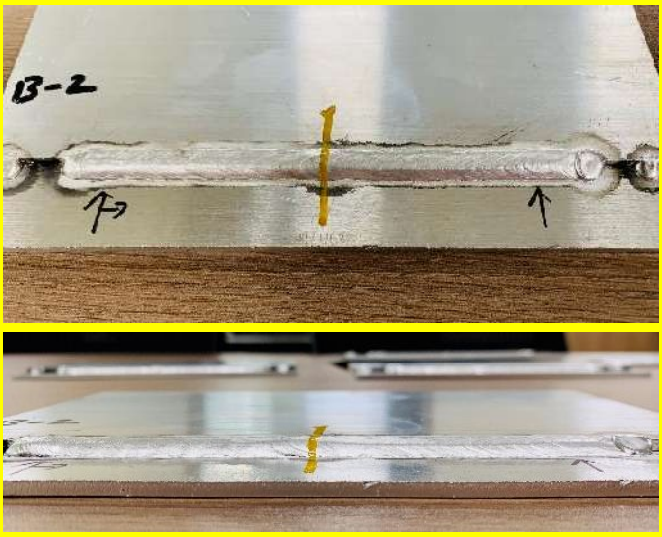

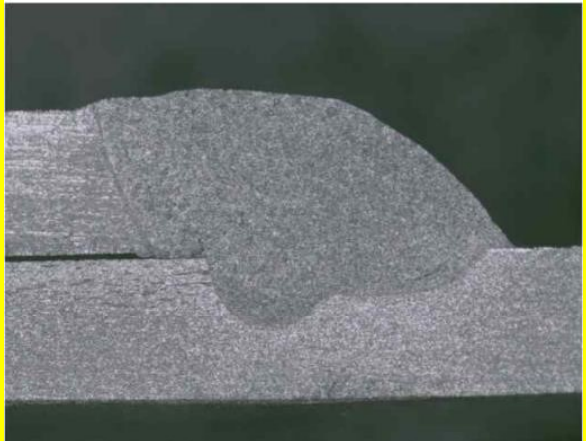
■ Aluminum 3003-O to A6N01-T5 Lap Joint weld test

Radiography & Macro test results

No.	Weld bead	Radiography	Macro
A			

■ Aluminum 3003-O to A6N01-T5 Lap Joint weld test

Radiography & Macro test results

No.	Weld bead	Radiography	Macro
B			

■ Aluminum 3003-O to A6N01-T5 Lap Joint weld test

Radiography & Macro test results

No.	Weld bead	Radiography	Macro
C	