**角焊缝试验过程记录表**

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
|  | 试件编号 | 试验时间 | 备注 |  | 试件编号 | 试验时间 | 备注 |
|  |  |  |  |  |  |  |  |
|  | 承载力 | 时间 |  | 承载力 | 时间 |
| 1 |  |  | 1 |  |  |
| 2 |  |  | 2 |  |  |
| 3 |  |  | 3 |  |  |
| 4 |  |  | 4 |  |  |
| 5 |  |  | 5 |  |  |
| 6 |  |  | 6 |  |  |
| 7 |  |  | 7 |  |  |
| 8 |  |  | 8 |  |  |
| 9 |  |  | 9 |  |  |
|  | 极限荷载 | 总时间 |  | 极限荷载 | 总时间 |
|  |  |  |  |  |  |  |  |
|  | 试件编号 | 试验时间 | 备注 |  | 试件编号 | 试验时间 | 备注 |
|  |  |  |  |  |  |  |  |
|  | 承载力 | 时间 |  | 承载力 | 时间 |
| 1 |  |  | 1 |  |  |
| 2 |  |  | 2 |  |  |
| 3 |  |  | 3 |  |  |
| 4 |  |  | 4 |  |  |
| 5 |  |  | 5 |  |  |
| 6 |  |  | 6 |  |  |
| 7 |  |  | 7 |  |  |
| 8 |  |  | 8 |  |  |
| 9 |  |  | 9 |  |  |
|  | 极限荷载 | 总时间 |  | 极限荷载 | 总时间 |
|  |  |  |  |  |  |  |  |
|  | 试件编号 | 试验时间 | 备注 |  | 试件编号 | 试验时间 | 备注 |
|  |  |  |  |  |  |  |  |
|  | 承载力 | 时间 |  | 承载力 | 时间 |
| 1 |  |  | 1 |  |  |
| 2 |  |  | 2 |  |  |
| 3 |  |  | 3 |  |  |
| 4 |  |  | 4 |  |  |
| 5 |  |  | 5 |  |  |
| 6 |  |  | 6 |  |  |
| 7 |  |  | 7 |  |  |
| 8 |  |  | 8 |  |  |
| 9 |  |  | 9 |  |  |
|  | 极限荷载 | 总时间 |  | 极限荷载 | 总时间 |
|  |  |  |  |  |  |  |  |

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| --- | --- | --- | --- | --- | --- | --- |
| **焊接记录表** | | | | | | |
| 试验时间 |  | | 记录人 |  | 接头形式 | |
| 母材 | 890 |  |  |  |  | |
| 焊丝 | ER110S-G | ER120S-G |  |  |
| 角度 | 0 | 15 | 30 | 45D |
|  | 45S | 60 | 75 | 90 |
| 预热温度 |  |  |  |  |
| 备注 |  | | | |
| 焊接过程记录表 | | | | | | |
| 焊道 | 电流(A) | 电压(V) | 速度（cm/min） | t8/5(s) | 热输入（kJ/mm) | 道间温度(°C) |
| 1 |  |  |  |  |  |  |
| 2 |  |  |  |  |  |  |
| 3 |  |  |  |  |  |  |
| 4 |  |  |  |  |  |  |
| 5 |  |  |  |  |  |  |
| 6 |  |  |  |  |  |  |
| 7 |  |  |  |  |  |  |
| 8 |  |  |  |  |  |  |
| 9 |  |  |  |  |  |  |
| 10 |  |  |  |  |  |  |
| 11 |  |  |  |  |  |  |
| 12 |  |  |  |  |  |  |
| 13 |  |  |  |  |  |  |
| 14 |  |  |  |  |  |  |

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| --- | --- | --- | --- | --- |
| 备注 | 姓名 | 手机号 | 邮箱 | 地址 |
| 切板 | 边工 | 13310063200 | [niulishan@126.com](mailto:niulishan@126.com) |  |
| 机加工 | 顾师傅 | 13816171210 | [13816171210@163.com](mailto:13816171210@163.com) | 江苏省盐城市阜宁县阜城镇华山路35号 |
| 杨师傅 | 13641753866 | [408058440@qq.com](mailto:408058440@qq.com) | 上海市杨浦区军工路1300号上海卫雷机电设备有限公司 |
| 宝钢钢构 | 王衍 | 18930432367（18917448150） | [wangyan890716@163.com](mailto:wangyan890716@163.com) | 上海市宝山区宝杨路2001号 |
| 焊丝 | 潘老板 | 13701798297 |  |  |
| 焊接保护气体 | 邓先生 | 13701939935 |  |  |
| 焊丝（上海宝煊金属制品有限公司） | 龚晟亮 | 13641889054 | [1059914213@qq.com](mailto:1059914213@qq.com) | 江苏省昆山开发区蓬朗蓬钱路12号 |

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| **焊接记录表** | | | | | | |
| 试验时间 |  | | 记录人 |  | 接头形式 | |
| 母材 | 890 |  |  |  |  | |
| 焊丝 | ER110S-G | ER120S-G |  |  |
| 编号 | 7 | 8 | 9 | 10 |
|  | 11 | 12 | 13 | 14 |
| 预热温度 |  |  |  |  |
| 焊后消氢 |  | | | |
| 焊接过程记录表 | | | | | | |
| 序号 | 电流(A) | 电压(V) | 速度（cm/min） | t8/5(s) | 热输入（kJ/mm) | 道间温度(°C) |
| 1 |  |  |  |  |  |  |
| 2 |  |  |  |  |  |  |
| 3 |  |  |  |  |  |  |
| 4 |  |  |  |  |  |  |
| 5 |  |  |  |  |  |  |
| 6 |  |  |  |  |  |  |
| 7 |  |  |  |  |  |  |
| 8 |  |  |  |  |  |  |
| 9 |  |  |  |  |  |  |
| 10 |  |  |  |  |  |  |
| 11 |  |  |  |  |  |  |
| 12 |  |  |  |  |  |  |
| 13 |  |  |  |  |  |  |
| 14 |  |  |  |  |  |  |