

中国第一重型机械集团公司标准

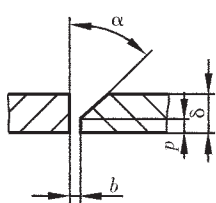

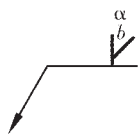
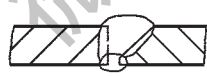
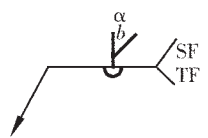
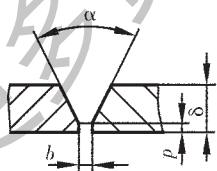

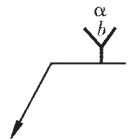
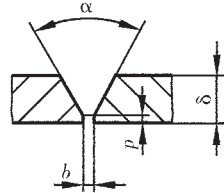

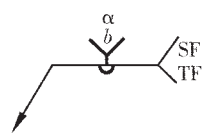
埋弧焊焊接接头基本型式及尺寸

YZB 242-89

本标准适用于埋弧焊焊接的碳钢和低合金钢焊接接头。

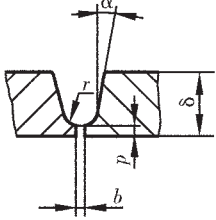
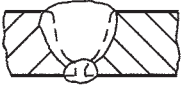
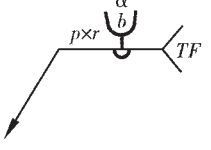
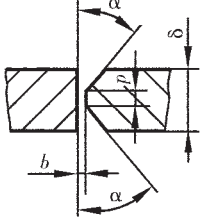

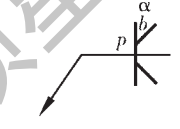
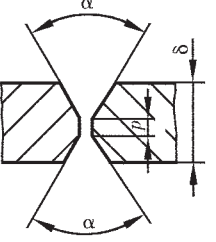

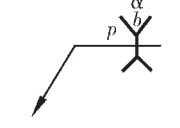
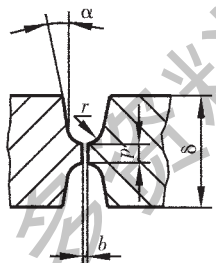
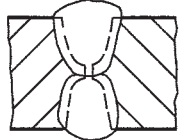
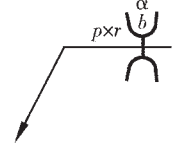
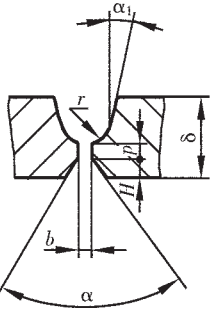

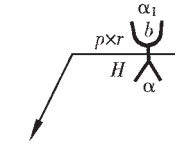
- 1 焊接接头的基本型式和尺寸在图样中的表示方法按 YZB 237-89 《焊缝代号》的规定。
- 2 焊接接头的基本型式和尺寸按下表规定。

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法												
1	10~20			<table border="1"> <tr> <td>δ</td> <td colspan="2">10~20</td> </tr> <tr> <td>b</td> <td colspan="2">2±1</td> </tr> <tr> <td>p</td> <td colspan="2">3~5</td> </tr> <tr> <td>α</td> <td colspan="2">35°±5°</td> </tr> </table>	δ	10~20		b	2±1		p	3~5		α	35°±5°		
			δ	10~20													
b	2±1																
p	3~5																
α	35°±5°																
	<table border="1"> <tr> <td>0</td> <td>10~16</td> <td>>16~20</td> </tr> <tr> <td>b</td> <td colspan="2">0⁺¹</td> </tr> <tr> <td>p</td> <td>5~7</td> <td>6~8</td> </tr> <tr> <td>α</td> <td colspan="2">35°±5°</td> </tr> </table>	0	10~16	>16~20	b	0 ⁺¹		p	5~7	6~8	α	35°±5°					
0	10~16	>16~20															
b	0 ⁺¹																
p	5~7	6~8															
α	35°±5°																
2	10~24			<table border="1"> <tr> <td>δ</td> <td>10~16</td> <td>>16~24</td> </tr> <tr> <td>b</td> <td>2±1</td> <td>3±1</td> </tr> <tr> <td>p</td> <td>3±1</td> <td>3±1</td> </tr> <tr> <td>α</td> <td colspan="2">45°±5°</td> </tr> </table>	δ	10~16	>16~24	b	2±1	3±1	p	3±1	3±1	α	45°±5°		
δ	10~16	>16~24															
b	2±1	3±1															
p	3±1	3±1															
α	45°±5°																
3	10~30			<table border="1"> <tr> <td>δ</td> <td>10~20</td> <td>>20~30</td> </tr> <tr> <td>b</td> <td colspan="2">3±1</td> </tr> <tr> <td>p</td> <td colspan="2">2±1</td> </tr> <tr> <td>α</td> <td colspan="2">50°±5°</td> </tr> </table>	δ	10~20	>20~30	b	3±1		p	2±1		α	50°±5°		
δ	10~20	>20~30															
b	3±1																
p	2±1																
α	50°±5°																

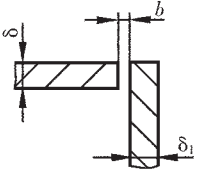
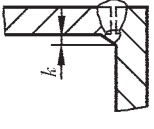
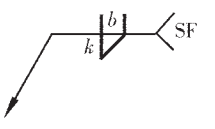
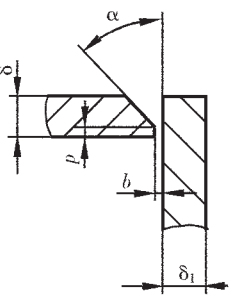
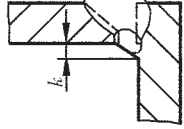
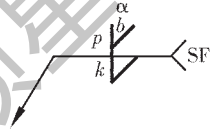
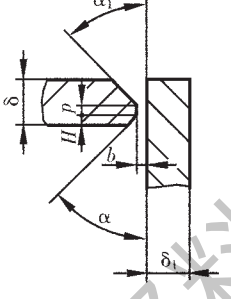

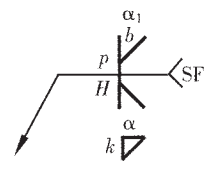
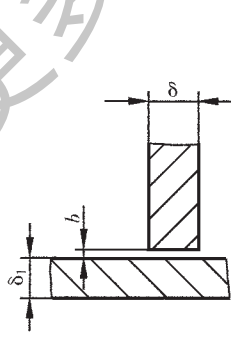
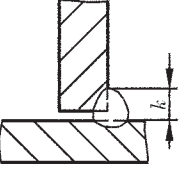
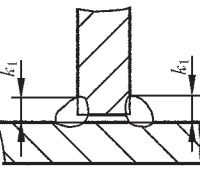
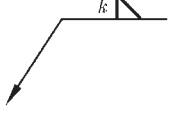
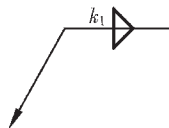
续表

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法														
4	30~60			<table border="1"> <tr><td>δ</td><td>30~60</td></tr> <tr><td>b</td><td>3±1</td></tr> <tr><td>p</td><td>2±1</td></tr> <tr><td>r</td><td>6~10</td></tr> <tr><td>α</td><td>9°±1°</td></tr> </table>	δ	30~60	b	3±1	p	2±1	r	6~10	α	9°±1°					
δ	30~60																		
b	3±1																		
p	2±1																		
r	6~10																		
α	9°±1°																		
5	20~30			<table border="1"> <tr><td>δ</td><td>20~30</td></tr> <tr><td>b</td><td>0_b</td></tr> <tr><td>p</td><td>2~4</td></tr> <tr><td>α</td><td>35°±5°</td></tr> </table>	δ	20~30	b	0 _b	p	2~4	α	35°±5°							
δ	20~30																		
b	0 _b																		
p	2~4																		
α	35°±5°																		
6	20~40			<table border="1"> <tr><td>δ</td><td>20~40</td></tr> <tr><td>b</td><td>1±1</td></tr> <tr><td>p</td><td>3±1</td></tr> <tr><td>α</td><td>55°±5°</td></tr> </table>	δ	20~40	b	1±1	p	3±1	α	55°±5°							
δ	20~40																		
b	1±1																		
p	3±1																		
α	55°±5°																		
7	30~60			<table border="1"> <tr><td>δ</td><td>30~60</td></tr> <tr><td>b</td><td>1±1</td></tr> <tr><td>p</td><td>4±1</td></tr> <tr><td>r</td><td>9~11</td></tr> <tr><td>α</td><td>9°±1°</td></tr> </table>	δ	30~60	b	1±1	p	4±1	r	9~11	α	9°±1°					
δ	30~60																		
b	1±1																		
p	4±1																		
r	9~11																		
α	9°±1°																		
8	30~60			<table border="1"> <tr><td>δ</td><td>30~60</td></tr> <tr><td>α_1</td><td>6°~10°</td></tr> <tr><td>b</td><td>1±1</td></tr> <tr><td>p</td><td>3±1</td></tr> <tr><td>r</td><td>9~11</td></tr> <tr><td>H</td><td>11~13</td></tr> <tr><td>α</td><td>55°±5°</td></tr> </table>	δ	30~60	α_1	6°~10°	b	1±1	p	3±1	r	9~11	H	11~13	α	55°±5°	
δ	30~60																		
α_1	6°~10°																		
b	1±1																		
p	3±1																		
r	9~11																		
H	11~13																		
α	55°±5°																		

续表

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法																																								
9	6~14			<table border="1"> <tr> <td>δ</td> <td>6~9</td> <td>>9~14</td> </tr> <tr> <td>b</td> <td colspan="2">1±1</td> </tr> <tr> <td>k_{min}</td> <td>3</td> <td>4</td> </tr> </table>	δ	6~9	>9~14	b	1±1		k_{min}	3	4																																
δ	6~9	>9~14																																											
b	1±1																																												
k_{min}	3	4																																											
10	10~20			<table border="1"> <tr> <td>δ</td> <td>10~15</td> <td>>15~20</td> </tr> <tr> <td>b</td> <td colspan="2">1±1</td> </tr> <tr> <td>p</td> <td colspan="2">2±1</td> </tr> <tr> <td>k_{min}</td> <td>4</td> <td>6</td> </tr> <tr> <td>α</td> <td colspan="2">35°±5°</td> </tr> </table>	δ	10~15	>15~20	b	1±1		p	2±1		k_{min}	4	6	α	35°±5°																											
δ	10~15	>15~20																																											
b	1±1																																												
p	2±1																																												
k_{min}	4	6																																											
α	35°±5°																																												
11	20~40			<table border="1"> <tr> <td>δ</td> <td>20~40</td> </tr> <tr> <td>b</td> <td>1±1</td> </tr> <tr> <td>p</td> <td>2±1</td> </tr> <tr> <td>H</td> <td>7~9</td> </tr> <tr> <td>k_{min}</td> <td>4</td> </tr> <tr> <td>α_1</td> <td>35°±5°</td> </tr> <tr> <td>α</td> <td>40°±5°</td> </tr> </table>	δ	20~40	b	1±1	p	2±1	H	7~9	k_{min}	4	α_1	35°±5°	α	40°±5°																											
δ	20~40																																												
b	1±1																																												
p	2±1																																												
H	7~9																																												
k_{min}	4																																												
α_1	35°±5°																																												
α	40°±5°																																												
12	4~60		 	<table border="1"> <tr> <td>δ</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>b</td> <td></td> <td>0~2</td> <td></td> <td></td> </tr> <tr> <td>k_{min}</td> <td></td> <td></td> <td>12</td> <td>8</td> </tr> <tr> <td>k_{min}</td> <td></td> <td></td> <td>10</td> <td>7</td> </tr> <tr> <td></td> <td></td> <td></td> <td>8</td> <td>6</td> </tr> <tr> <td></td> <td></td> <td></td> <td>6</td> <td>4</td> </tr> <tr> <td></td> <td>0~1</td> <td></td> <td>4</td> <td>3</td> </tr> <tr> <td></td> <td></td> <td></td> <td>3</td> <td>2</td> </tr> </table>	δ					b		0~2			k_{min}			12	8	k_{min}			10	7				8	6				6	4		0~1		4	3				3	2	 
δ																																													
b		0~2																																											
k_{min}			12	8																																									
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			8	6																																									
			6	4																																									
	0~1		4	3																																									
			3	2																																									

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mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法																					
13	20~100			<table border="1"> <tr><td>δ</td><td>20~100</td></tr> <tr><td>b</td><td>1±1</td></tr> <tr><td>A</td><td>≥0.4δ</td></tr> <tr><td>k</td><td>≥0.15δ</td></tr> <tr><td>p</td><td>≈0.2δ</td></tr> <tr><td>α</td><td>35°±3°</td></tr> </table>	δ	20~100	b	1±1	A	≥0.4δ	k	≥0.15δ	p	≈0.2δ	α	35°±3°										
δ	20~100																									
b	1±1																									
A	≥0.4δ																									
k	≥0.15δ																									
p	≈0.2δ																									
α	35°±3°																									
14	30~60			<table border="1"> <tr><td>δ</td><td>30~60</td></tr> <tr><td>b</td><td>1±1</td></tr> <tr><td>p</td><td>6±1</td></tr> <tr><td>r</td><td>9~11</td></tr> <tr><td>α</td><td>19°±1°</td></tr> </table>	δ	30~60	b	1±1	p	6±1	r	9~11	α	19°±1°												
δ	30~60																									
b	1±1																									
p	6±1																									
r	9~11																									
α	19°±1°																									
15	30~100			<table border="1"> <tr><td>δ</td><td>30~60</td><td>>60~100</td></tr> <tr><td>α</td><td>40°~45°</td><td>30°~40°</td></tr> <tr><td>b</td><td>1±1</td><td>2±1</td></tr> <tr><td>p</td><td colspan="2">≈0.2δ</td></tr> <tr><td>A</td><td colspan="2">≥0.8δ</td></tr> <tr><td>k</td><td colspan="2">≥0.15δ</td></tr> <tr><td>k_1</td><td colspan="2">6~8</td></tr> </table>	δ	30~60	>60~100	α	40°~45°	30°~40°	b	1±1	2±1	p	≈0.2δ		A	≥0.8δ		k	≥0.15δ		k_1	6~8		
		δ	30~60		>60~100																					
α	40°~45°	30°~40°																								
b	1±1	2±1																								
p	≈0.2δ																									
A	≥0.8δ																									
k	≥0.15δ																									
k_1	6~8																									

- 注：① HD—表示采用焊剂垫。
 ② TD—表示采用铜垫板。
 ③ TF—表示手工氩弧焊封底。
 ④ SF—表示手工焊封底。