

中国第一重型机械集团公司标准

气体保护焊焊接接头基本型式及尺寸

YZB 240-89

本标准适用于气体保护焊焊接的碳钢和低合金钢焊接接头的基本型式和尺寸。

- 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	1~4 单面焊			<table border="1"> <tr> <td>δ</td> <td>1~4</td> </tr> <tr> <td>b</td> <td>1±1</td> </tr> </table>	δ	1~4	b	1±1					
	δ	1~4											
b	1±1												
>4~8 双面焊			<table border="1"> <tr> <td>δ</td> <td>>4~8</td> </tr> <tr> <td>b</td> <td>2±1</td> </tr> </table>	δ	>4~8	b	2±1						
δ	>4~8												
b	2±1												
2	8~26			<table border="1"> <tr> <td>δ</td> <td>8~26</td> </tr> <tr> <td>b</td> <td>1⁺²₋₁</td> </tr> <tr> <td>p</td> <td>3±1</td> </tr> </table>	δ	8~26	b	1 ⁺² ₋₁	p	3±1			
			δ	8~26									
b	1 ⁺² ₋₁												
p	3±1												
	<table border="1"> <tr> <td>α</td> <td>40°±5°</td> </tr> </table>	α	40°±5°										
α	40°±5°												
3	20~60			<table border="1"> <tr> <td>-1</td> <td>20~60</td> </tr> <tr> <td>b</td> <td>1⁺²₋₁</td> </tr> <tr> <td>p</td> <td>3±1</td> </tr> <tr> <td>α</td> <td>40°±5°</td> </tr> </table>	-1	20~60	b	1 ⁺² ₋₁	p	3±1	α	40°±5°	
-1	20~60												
b	1 ⁺² ₋₁												
p	3±1												
α	40°±5°												

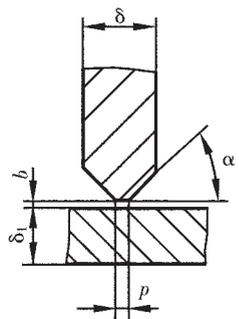
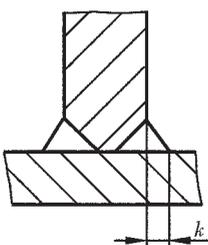
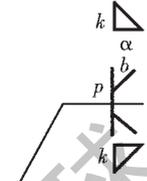
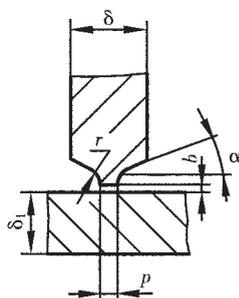
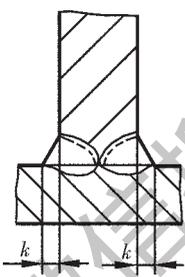
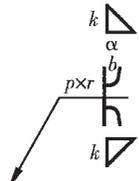
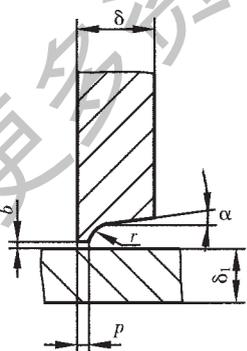
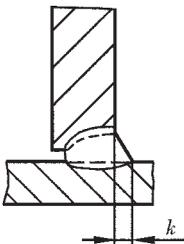
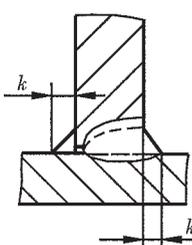
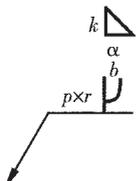
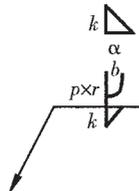
续表

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法										
4	20~60			<table border="1"> <tr><td>δ</td><td>20~60</td></tr> <tr><td>b</td><td>1_{-1}^{+2}</td></tr> <tr><td>p</td><td>3 ± 1</td></tr> <tr><td>r</td><td>7 ± 1</td></tr> <tr><td>α</td><td>$6^\circ\pm 1^\circ$</td></tr> </table>	δ	20~60	b	1_{-1}^{+2}	p	3 ± 1	r	7 ± 1	α	$6^\circ\pm 1^\circ$	
			δ	20~60											
b	1_{-1}^{+2}														
p	3 ± 1														
r	7 ± 1														
α	$6^\circ\pm 1^\circ$														
	<table border="1"> <tr><td>δ</td><td>30~60</td></tr> <tr><td>b</td><td>1_{-1}^{+2}</td></tr> <tr><td>p</td><td>3 ± 1</td></tr> <tr><td>r</td><td>7 ± 1</td></tr> <tr><td>α</td><td>$6^\circ\pm 1^\circ$</td></tr> </table>	δ	30~60	b	1_{-1}^{+2}	p	3 ± 1	r	7 ± 1	α	$6^\circ\pm 1^\circ$				
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5	30~60			<table border="1"> <tr><td>δ</td><td>30~60</td></tr> <tr><td>b</td><td>1_{-1}^{+2}</td></tr> <tr><td>p</td><td>3 ± 1</td></tr> <tr><td>r</td><td>7 ± 1</td></tr> <tr><td>α</td><td>$6^\circ\pm 1^\circ$</td></tr> </table>	δ	30~60	b	1_{-1}^{+2}	p	3 ± 1	r	7 ± 1	α	$6^\circ\pm 1^\circ$	
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	<table border="1"> <tr><td>δ</td><td>4~30</td></tr> <tr><td>b</td><td>1 ± 1</td></tr> <tr><td>k</td><td>$\geq 0.60\delta$</td></tr> <tr><td>k_1</td><td>0.42δ</td></tr> </table> <p>k, k_1 值适用于较小负荷或强度不必计算的情况</p>	δ	4~30	b	1 ± 1	k	$\geq 0.60\delta$	k_1	0.42δ						
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b	1 ± 1														
k	$\geq 0.60\delta$														
k_1	0.42δ														
<p>优先采用双面焊, 单面焊在不可避免时才允许采用</p>	<table border="1"> <tr><td>δ</td><td>20~60</td></tr> <tr><td>b</td><td>1 ± 1</td></tr> <tr><td>p</td><td>0.38, 0.1δ</td></tr> <tr><td>k, k_1</td><td>6~10</td></tr> <tr><td>α</td><td>$35^\circ\pm 5^\circ$</td></tr> </table> <p>p 值根据焊缝受力状况确定</p>	δ	20~60	b	1 ± 1	p	0.38, 0.1 δ	k, k_1	6~10	α	$35^\circ\pm 5^\circ$				
δ	20~60														
b	1 ± 1														
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k, k_1	6~10														
α	$35^\circ\pm 5^\circ$														
7	20~60			<table border="1"> <tr><td>δ</td><td>20~60</td></tr> <tr><td>b</td><td>1 ± 1</td></tr> <tr><td>p</td><td>0.38, 0.1δ</td></tr> <tr><td>k, k_1</td><td>6~10</td></tr> <tr><td>α</td><td>$35^\circ\pm 5^\circ$</td></tr> </table> <p>p 值根据焊缝受力状况确定</p>	δ	20~60	b	1 ± 1	p	0.38, 0.1 δ	k, k_1	6~10	α	$35^\circ\pm 5^\circ$	
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k, k_1	6~10														
α	$35^\circ\pm 5^\circ$														

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												
8	20~60			<table border="1"> <tr><td>δ</td><td>20~60</td></tr> <tr><td>b</td><td>1±1</td></tr> <tr><td>p</td><td>2±1</td></tr> <tr><td>k</td><td>6~10</td></tr> <tr><td>α</td><td>35°±5°</td></tr> </table>	δ	20~60	b	1±1	p	2±1	k	6~10	α	35°±5°			
δ	20~60																
b	1±1																
p	2±1																
k	6~10																
α	35°±5°																
9	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>3±1</td></tr> <tr><td>r</td><td>15±1</td></tr> <tr><td>k</td><td>6~10</td></tr> <tr><td>α</td><td>15°±2°</td></tr> </table>	δ	30~60	b	1±1	p	3±1	r	15±1	k	6~10	α	15°±2°	
δ	30~60																
b	1±1																
p	3±1																
r	15±1																
k	6~10																
α	15°±2°																
10	20~60		 	<table border="1"> <tr><td>δ</td><td>20~60</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>15±1</td></tr> <tr><td>k</td><td>6~10</td></tr> <tr><td>α</td><td>15°±2°</td></tr> </table>	δ	20~60	b	1±1	p	3±1	r	15±1	k	6~10	α	15°±2°	 
δ	20~60																
b	1±1																
p	3±1																
r	15±1																
k	6~10																
α	15°±2°																

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															
11	1~20			<table border="1"> <tr> <td>δ</td> <td>1~10</td> <td>>10~20</td> </tr> <tr> <td>b</td> <td colspan="2">1±1</td> </tr> <tr> <td>L</td> <td>1~6</td> <td>6~10</td> </tr> <tr> <td>k</td> <td>1~6</td> <td>6~10</td> </tr> <tr> <td>k_1</td> <td>1~3</td> <td>4~6</td> </tr> </table>	δ	1~10	>10~20	b	1±1		L	1~6	6~10	k	1~6	6~10	k_1	1~3	4~6	
			δ	1~10	>10~20															
b	1±1																			
L	1~6	6~10																		
k	1~6	6~10																		
k_1	1~3	4~6																		
12	20~60			<table border="1"> <tr> <td>δ</td> <td>20~40</td> <td>>40~60</td> </tr> <tr> <td>b</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>H</td> <td colspan="2">按需要</td> </tr> <tr> <td>k</td> <td colspan="2">4~8</td> </tr> <tr> <td>α</td> <td colspan="2">40°±5°</td> </tr> </table>	δ	20~40	>40~60	b	1±1	2±1	H	按需要		k	4~8		α	40°±5°		
			δ	20~40	>40~60															
b	1±1	2±1																		
H	按需要																			
k	4~8																			
α	40°±5°																			
13	20~60			<table border="1"> <tr> <td>δ</td> <td>20~60</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>15±1</td> </tr> <tr> <td>k</td> <td>6~10</td> </tr> <tr> <td>α</td> <td>15°±2°</td> </tr> </table>	δ	20~60	b	1±1	p	3±1	r	15±1	k	6~10	α	15°±2°				
			δ	20~60																
b	1±1																			
p	3±1																			
r	15±1																			
k	6~10																			
α	15°±2°																			

附录 A

手工电弧焊焊接接头基本型式和尺寸

(补充件)

A1 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。

A2 焊接接头的基本型式和尺寸按表 A 规定。

表 A

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法																
1	1~3			<table border="1"> <tr> <td>δ</td> <td>1~2</td> <td>>2~3</td> </tr> <tr> <td>b</td> <td>0^{+0.5}₀</td> <td>0⁺¹₀</td> </tr> </table>	δ	1~2	>2~3	b	0 ^{+0.5} ₀	0 ⁺¹ ₀											
δ	1~2	>2~3																			
b	0 ^{+0.5} ₀	0 ⁺¹ ₀																			
2	>3~6			<table border="1"> <tr> <td>δ</td> <td>>3~4</td> <td>>4~6</td> </tr> <tr> <td>b</td> <td>0⁺¹₀</td> <td>1±1</td> </tr> </table>	δ	>3~4	>4~6	b	0 ⁺¹ ₀	1±1											
δ	>3~4	>4~6																			
b	0 ⁺¹ ₀	1±1																			
3	2~4			<table border="1"> <tr> <td>δ</td> <td>2~4</td> </tr> <tr> <td>b</td> <td>2⁺¹₀</td> </tr> </table>	δ	2~4	b	2 ⁺¹ ₀													
δ	2~4																				
b	2 ⁺¹ ₀																				
4	6~26			<table border="1"> <tr> <td>δ</td> <td>6~10</td> <td>>10~15</td> <td>>15~26</td> </tr> <tr> <td>b</td> <td>3±1</td> <td>4±1</td> <td>5±1</td> </tr> <tr> <td>p</td> <td>1±1</td> <td>2±1</td> <td>2⁺¹₋₂</td> </tr> <tr> <td>α</td> <td colspan="3">40°±2°</td> </tr> </table>	δ	6~10	>10~15	>15~26	b	3±1	4±1	5±1	p	1±1	2±1	2 ⁺¹ ₋₂	α	40°±2°			
δ	6~10	>10~15	>15~26																		
b	3±1	4±1	5±1																		
p	1±1	2±1	2 ⁺¹ ₋₂																		
α	40°±2°																				
5	6~26			<table border="1"> <tr> <td>δ</td> <td>6~10</td> <td>>10~15</td> <td>>15~26</td> </tr> <tr> <td>b</td> <td>2±1</td> <td>2±1</td> <td>2±1</td> </tr> <tr> <td>p</td> <td>1±1</td> <td>2±1</td> <td>2±1</td> </tr> <tr> <td>α</td> <td>55°±5°</td> <td colspan="2">50°±5°</td> </tr> </table>	δ	6~10	>10~15	>15~26	b	2±1	2±1	2±1	p	1±1	2±1	2±1	α	55°±5°	50°±5°		
δ	6~10	>10~15	>15~26																		
b	2±1	2±1	2±1																		
p	1±1	2±1	2±1																		
α	55°±5°	50°±5°																			

续表 A

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法												
6	6~26			<table border="1"> <tr> <td>δ</td> <td>6~10</td> <td>>10~26</td> </tr> <tr> <td>b</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>p</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>α</td> <td>60°±5°</td> <td>55°±5°</td> </tr> </table>	δ	6~10	>10~26	b	1±1	2±1	p	1±1	2±1	α	60°±5°	55°±5°	
δ	6~10	>10~26															
b	1±1	2±1															
p	1±1	2±1															
α	60°±5°	55°±5°															
7	6~26			<table border="1"> <tr> <td>δ</td> <td>6~12</td> <td>>12~26</td> </tr> <tr> <td>b</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>p</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>α</td> <td>60°±5°</td> <td>55°±5°</td> </tr> </table>	δ	6~12	>12~26	b	1±1	2±1	p	1±1	2±1	α	60°±5°	55°±5°	
δ	6~12	>12~26															
b	1±1	2±1															
p	1±1	2±1															
α	60°±5°	55°±5°															
8	6~26		 $S_0=1_{+0.5}^{+1.5}$ 单面焊双面成型	<table border="1"> <tr> <td>δ</td> <td>6~26</td> </tr> <tr> <td>b</td> <td>2±1</td> </tr> <tr> <td>p</td> <td>1±0.5</td> </tr> <tr> <td>α</td> <td>50°</td> </tr> <tr> <td>r</td> <td>1~1.5</td> </tr> </table>	δ	6~26	b	2±1	p	1±0.5	α	50°	r	1~1.5			
δ	6~26																
b	2±1																
p	1±0.5																
α	50°																
r	1~1.5																
9	16~60			<table border="1"> <tr> <td>δ</td> <td>16~60</td> </tr> <tr> <td>b</td> <td>1₋₁⁺²</td> </tr> <tr> <td>p</td> <td>2±1</td> </tr> <tr> <td>α</td> <td>55°±5°</td> </tr> </table>	δ	16~60	b	1 ₋₁ ⁺²	p	2±1	α	55°±5°					
δ	16~60																
b	1 ₋₁ ⁺²																
p	2±1																
α	55°±5°																
10	6~26			<table border="1"> <tr> <td>δ</td> <td>6~26</td> </tr> <tr> <td>b</td> <td>2±1</td> </tr> <tr> <td>p</td> <td>2±1</td> </tr> <tr> <td>α</td> <td>45°±5°</td> </tr> </table>	δ	6~26	b	2±1	p	2±1	α	45°±5°					
			δ		6~26												
b	2±1																
p	2±1																
α	45°±5°																

续表 A

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法															
11	16~26			<table border="1"> <tr><td>δ</td><td>16~26</td></tr> <tr><td>b</td><td>2 ± 1</td></tr> <tr><td>p</td><td>2 ± 1</td></tr> <tr><td>r</td><td>6 ± 1</td></tr> <tr><td>α</td><td>$10^\circ\pm 2^\circ$</td></tr> </table>	δ	16~26	b	2 ± 1	p	2 ± 1	r	6 ± 1	α	$10^\circ\pm 2^\circ$						
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b	2 ± 1																			
p	2 ± 1																			
r	6 ± 1																			
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12	16~26			<table border="1"> <tr><td>δ</td><td>16~26</td></tr> <tr><td>b</td><td>2 ± 1</td></tr> <tr><td>p</td><td>2 ± 1</td></tr> <tr><td>r</td><td>7 ± 1</td></tr> <tr><td>α</td><td>$18^\circ\pm 2^\circ$</td></tr> </table>	δ	16~26	b	2 ± 1	p	2 ± 1	r	7 ± 1	α	$18^\circ\pm 2^\circ$						
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13	2~10			<table border="1"> <tr><td>δ</td><td>2~6</td><td>>6~10</td></tr> <tr><td>b</td><td colspan="2">1 ± 1</td></tr> <tr><td>k</td><td>3 ± 1</td><td>4 ± 1</td></tr> </table>	δ	2~6	>6~10	b	1 ± 1		k	3 ± 1	4 ± 1							
			δ	2~6	>6~10															
b	1 ± 1																			
k	3 ± 1	4 ± 1																		
14	4~30			<table border="1"> <tr><td>δ</td><td>4~18</td><td>>18~30</td></tr> <tr><td>b</td><td colspan="2">1 ± 1</td></tr> <tr><td>l</td><td>2~6</td><td>6~10</td></tr> <tr><td>k</td><td>2~10</td><td>10~15</td></tr> <tr><td>k_1</td><td>3 ± 1</td><td>4 ± 1</td></tr> </table>	δ	4~18	>18~30	b	1 ± 1		l	2~6	6~10	k	2~10	10~15	k_1	3 ± 1	4 ± 1	
			δ	4~18	>18~30															
b	1 ± 1																			
l	2~6	6~10																		
k	2~10	10~15																		
k_1	3 ± 1	4 ± 1																		

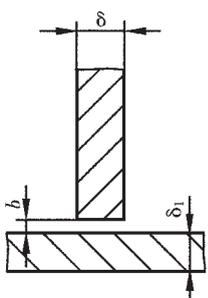
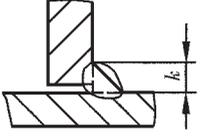
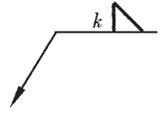
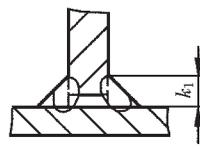
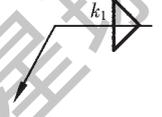
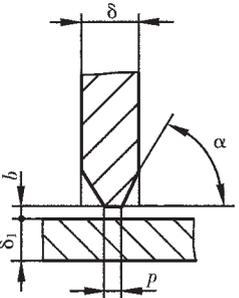
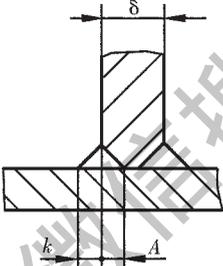
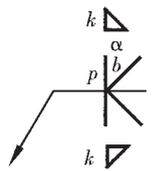
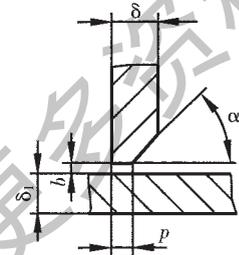
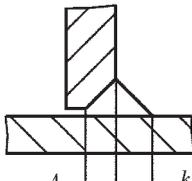
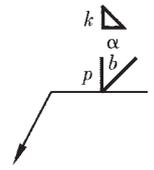
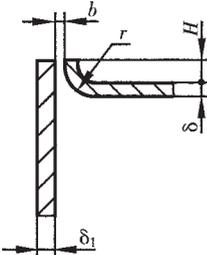
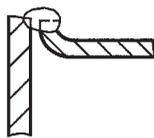
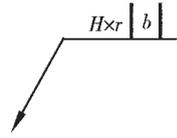
续表 A

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法																									
15	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">1±1</td> </tr> <tr> <td>p</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>k</td> <td>3</td> <td>4</td> </tr> <tr> <td>α</td> <td>50°±5°</td> <td>40°±5°</td> </tr> </table>	δ	10~20	>20~30	b	1±1		p	1±1	2±1	k	3	4	α	50°±5°	40°±5°											
			δ	10~20	>20~30																									
b	1±1																													
p	1±1	2±1																												
k	3	4																												
α	50°±5°	40°±5°																												
	<table border="1"> <tr> <td>δ</td> <td>20</td> <td>>30</td> <td>>40</td> </tr> <tr> <td></td> <td>~30</td> <td>~40</td> <td>~60</td> </tr> <tr> <td>b</td> <td colspan="2">1±1</td> <td>2±1</td> </tr> <tr> <td>p</td> <td>1±1</td> <td colspan="2">2±1</td> </tr> <tr> <td>r</td> <td>7</td> <td>9</td> <td>10</td> </tr> <tr> <td>k</td> <td>5</td> <td>6</td> <td>8</td> </tr> <tr> <td>α</td> <td>8°</td> <td>10°</td> <td>11°</td> </tr> </table>	δ	20	>30	>40		~30	~40	~60	b	1±1		2±1	p	1±1	2±1		r	7	9	10	k	5	6	8	α	8°	10°	11°	
δ	20	>30	>40																											
	~30	~40	~60																											
b	1±1		2±1																											
p	1±1	2±1																												
r	7	9	10																											
k	5	6	8																											
α	8°	10°	11°																											
17	20~60			<table border="1"> <tr> <td>δ</td> <td>20</td> <td>>40</td> </tr> <tr> <td></td> <td>~40</td> <td>~60</td> </tr> <tr> <td>b</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>H</td> <td colspan="2">按需要</td> </tr> <tr> <td>k</td> <td colspan="2">4~8</td> </tr> <tr> <td>α</td> <td colspan="2">35°~45°</td> </tr> </table>	δ	20	>40		~40	~60	b	1±1	2±1	H	按需要		k	4~8		α	35°~45°									
			δ	20	>40																									
	~40	~60																												
b	1±1	2±1																												
H	按需要																													
k	4~8																													
α	35°~45°																													
	<table border="1"> <tr> <td>δ</td> <td>20</td> <td>>40</td> </tr> <tr> <td></td> <td>~40</td> <td>~60</td> </tr> <tr> <td>b</td> <td>1±1</td> <td>2±1</td> </tr> <tr> <td>H</td> <td colspan="2">按需要</td> </tr> <tr> <td>k</td> <td colspan="2">4~8</td> </tr> <tr> <td>α</td> <td colspan="2">35°~45°</td> </tr> </table>	δ	20	>40		~40	~60	b	1±1	2±1	H	按需要		k	4~8		α	35°~45°												
δ	20	>40																												
	~40	~60																												
b	1±1	2±1																												
H	按需要																													
k	4~8																													
α	35°~45°																													

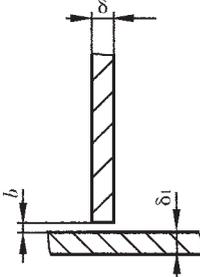
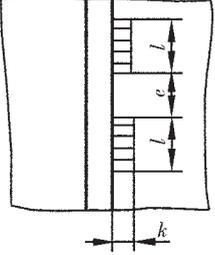
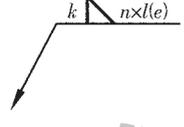
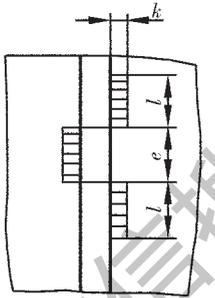
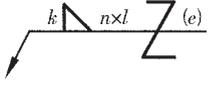
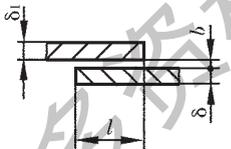
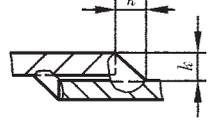
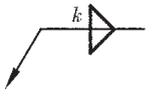
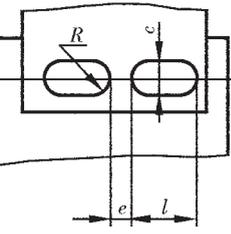
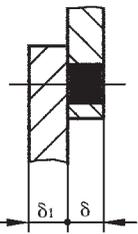
续表 A

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法																		
18	2~40			<table border="1"> <tr> <td>δ</td> <td>2~40</td> </tr> <tr> <td>b</td> <td>1±1</td> </tr> <tr> <td>k</td> <td>≈0.75δ</td> </tr> <tr> <td>k_1</td> <td>≈0.42δ</td> </tr> </table>	δ	2~40	b	1±1	k	≈0.75δ	k_1	≈0.42δ											
			δ		2~40																		
b	1±1																						
k	≈0.75δ																						
k_1	≈0.42δ																						
 <p>优先采用双面焊</p>																							
19	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>30°±2°</td> </tr> </table>	δ	20~100	b	1±1	A	≥0.4δ	k	≥0.15δ	p	≈0.2δ	α	30°±2°							
					δ	20~100																	
b	1±1																						
A	≥0.4δ																						
k	≥0.15δ																						
p	≈0.2δ																						
α	30°±2°																						
20	20~100			<table border="1"> <tr> <td>δ</td> <td>20~55</td> <td>>55~100</td> </tr> <tr> <td>b</td> <td colspan="2">1±1</td> </tr> <tr> <td>A</td> <td colspan="2">≥0.9δ</td> </tr> <tr> <td>k</td> <td>6</td> <td>8</td> </tr> <tr> <td>p</td> <td colspan="2">≈0.1δ</td> </tr> <tr> <td>α</td> <td colspan="2">30°+2°</td> </tr> </table>	δ	20~55	>55~100	b	1±1		A	≥0.9δ		k	6	8	p	≈0.1δ		α	30°+2°		
					δ	20~55	>55~100																
b	1±1																						
A	≥0.9δ																						
k	6	8																					
p	≈0.1δ																						
α	30°+2°																						
21	1~2			<table border="1"> <tr> <td>0</td> <td>1~2</td> </tr> <tr> <td>b</td> <td>0%</td> </tr> <tr> <td>r</td> <td>1~2</td> </tr> <tr> <td>H</td> <td>3%</td> </tr> </table>	0	1~2	b	0%	r	1~2	H	3%											
0	1~2																						
b	0%																						
r	1~2																						
H	3%																						

续表 A

mm

序号	适用厚度	基本型式	焊缝型式	基本尺寸	标注方法																		
22	2~60			<table border="1"> <tr> <td>>30~60</td> <td>12</td> </tr> <tr> <td>>23~30</td> <td>10</td> </tr> <tr> <td>>16~23</td> <td>8</td> </tr> <tr> <td>>12~16</td> <td>6</td> </tr> <tr> <td>>9~12</td> <td>5</td> </tr> <tr> <td>>6~9</td> <td>4</td> </tr> <tr> <td>>3~6</td> <td>3</td> </tr> <tr> <td>2~3</td> <td>2</td> </tr> <tr> <td>delta</td> <td>k_{min}</td> </tr> </table> <p><i>l, e 由设计给出, 一般 l=150; e=100~200</i></p>	>30~60	12	>23~30	10	>16~23	8	>12~16	6	>9~12	5	>6~9	4	>3~6	3	2~3	2	delta	k _{min}	 <p><i>n 为 l 段数</i></p>
			>30~60	12																			
>23~30	10																						
>16~23	8																						
>12~16	6																						
>9~12	5																						
>6~9	4																						
>3~6	3																						
2~3	2																						
delta	k _{min}																						
	 <p><i>n 为 l 段数</i></p>																						
23	2~30			<table border="1"> <tr> <td>delta</td> <td>2~30</td> </tr> <tr> <td>b</td> <td>0⁺¹₀</td> </tr> <tr> <td>l</td> <td>≥ 2 (delta + delta₁)</td> </tr> <tr> <td>k</td> <td>2~20</td> </tr> <tr> <td>k_{max}</td> <td>delta + b</td> </tr> </table>	delta	2~30	b	0 ⁺¹ ₀	l	≥ 2 (delta + delta ₁)	k	2~20	k _{max}	delta + b									
delta	2~30																						
b	0 ⁺¹ ₀																						
l	≥ 2 (delta + delta ₁)																						
k	2~20																						
k _{max}	delta + b																						
24	≥ 4			<p>delta ≥ 4 c ≥ 2delta R ≥ 0.5c l ≥ 2.5 e 由设计给定</p>	