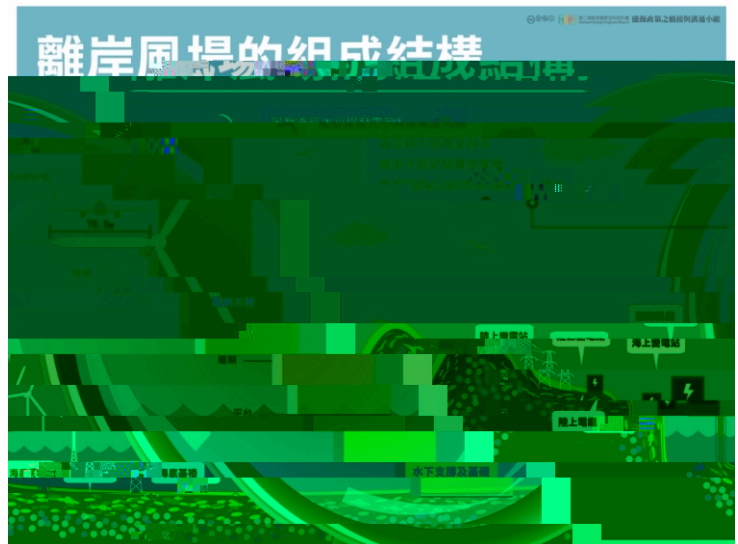


1.



2.



A 380

3.

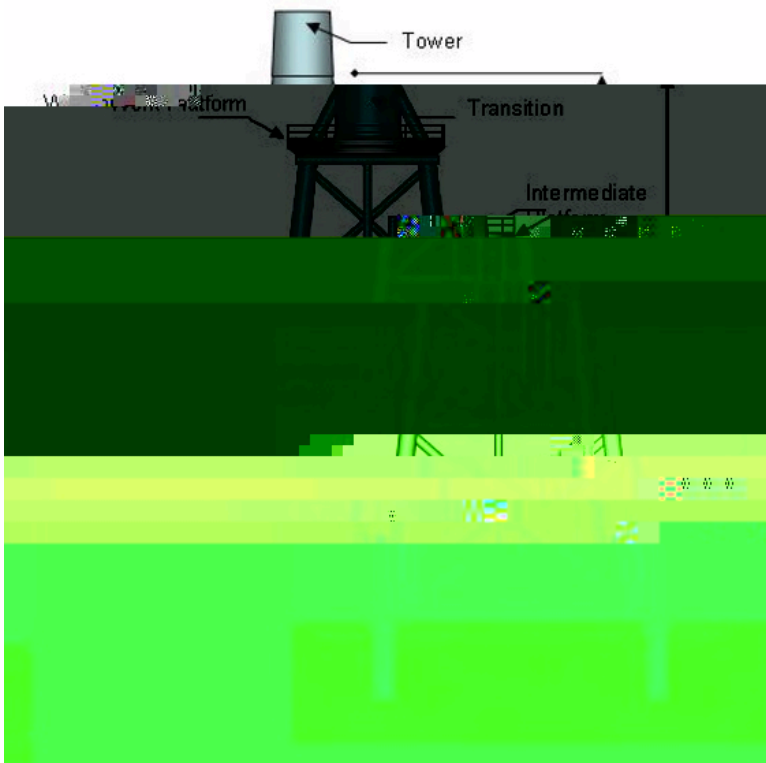
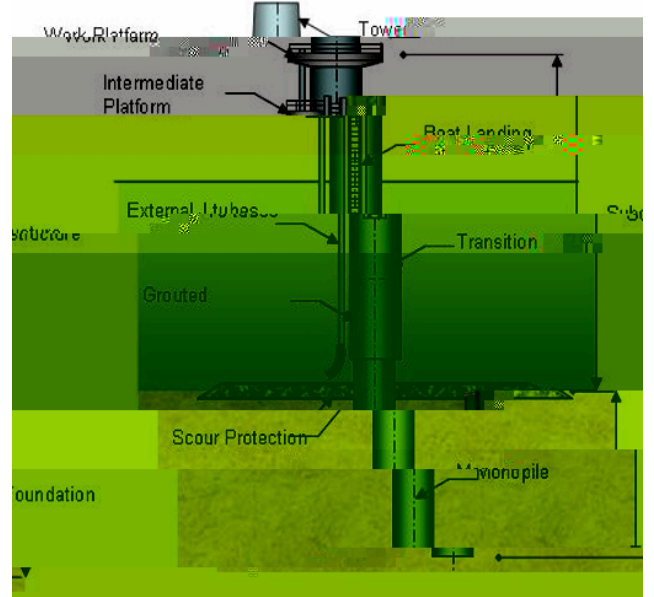


4.

(Monopile)-

4~6M

redundancy

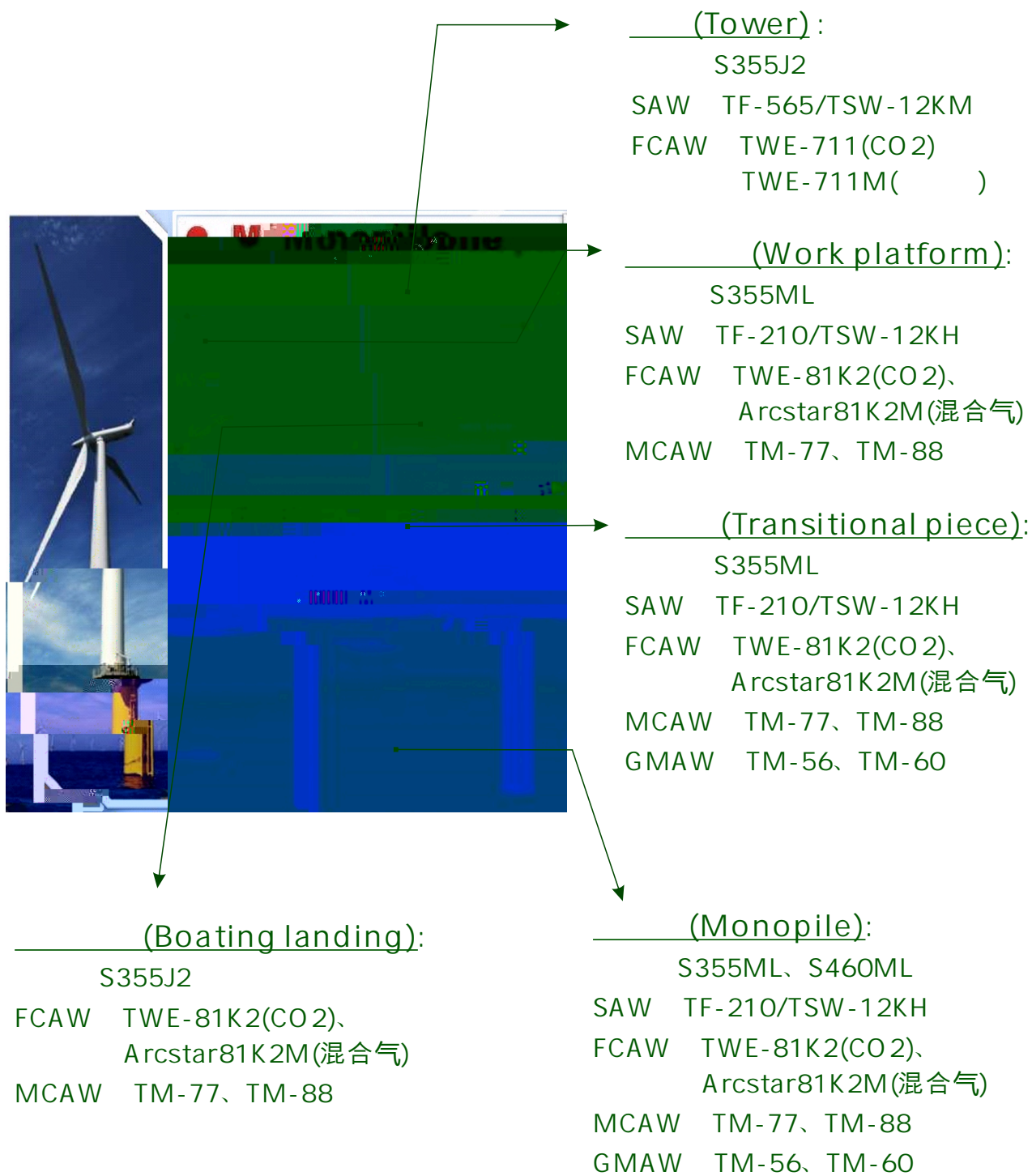


(Jacket)-

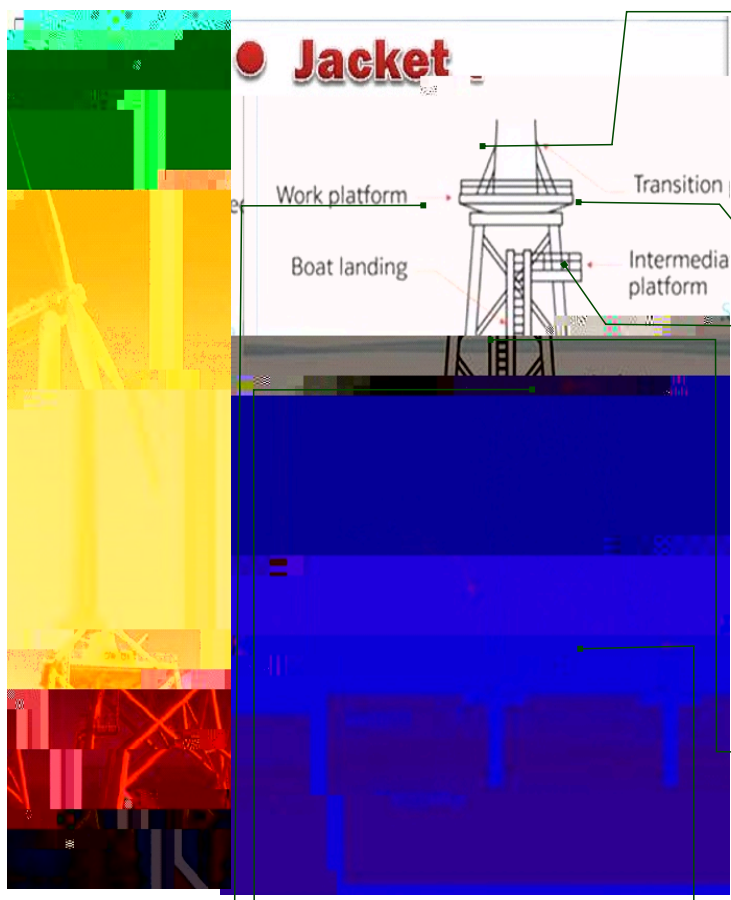
truss

2%

5.



5.



(Tower):

S355J2
 SAW TF-565/TSW-12KM
 FCAW TWE-711(CO2)
 TWE-711M(混合气)

(Transitional piece):

S355ML
 SAW TF-210/TSW-12KH
 FCAW TWE-81K2(CO2)、
 Arcstar81K2M(混合气)
 MCAW TM-77、TM-88
 GMAW TM-56、TM-60

(Boating landing):

S355J2
 FCAW TWE-81K2(CO2)、
 Arcstar81K2M(混合气)
 MCAW TM-77、TM-88

(Work platform):

S355ML
 SAW TF-210/TSW-12KH
 FCAW TWE-81K2(CO2)、
 Arcstar81K2M(混合气)
 MCAW TM-77、TM-88

(Internal Platforms):

S355ML、S355J2
 SAW TF-210/TSW-12KH
 FCAW TWE-81K2(CO2)、
 Arcstar81K2M(混合气)
 MCAW TM-77、TM-88

(Jacket):

S355ML、S355J2
 SAW TF-210/TSW-12KH
 FCAW TWE-81K2(CO2)、
 Arcstar81K2M(混合气)
 MCAW TM-77、TM-88

(Pile sleeve):

S355ML
 SAW TF-210/TSW-12KH
 FCAW TWE-81K2(CO2)、
 Arcstar81K2M(混合气)
 MCAW TM-77、TM-88

EN 10025-04'

| | Mpa | Mpa | IV(J)min |
|--------|---------|-----|----------|
| S355J0 | | | 0 27 |
| S355J2 | | | -20 27 |
| S355N | 470~630 | 355 | -20 40 |
| S355NL | | | -50 27 |
| S355M | | | -20 40 |
| S355ML | | | -50 27 |
| S420N | | | -20 40 |
| S420NL | 520~680 | 420 | -50 27 |
| S420M | | | -20 40 |
| S420ML | | | -50 27 |
| S460N | | | -20 40 |
| S460NL | 550~720 | 460 | -50 27 |
| S460M | | | -20 40 |
| S460ML | | | -50 27 |

| | (Mpa) | (Mpa) | | | | | | | | |
|--------|---------|-------|-----|-------|-------|-----------|---------|-------|--|-----------------|
| | | | () | IV(J) | GMAW | GTAW | SMAW | MCAW | FCAW | SAW |
| S355J0 | 470-630 | 355 | 0 | 27 | TM-56 | TGA-56 | TLH-581 | TM-77 | TWE-711 TWE-711M | TF-565+TSW-12KM |
| S355J2 | | | -20 | 27 | TM-56 | TGA-56 | TLH-581 | TM-77 | TWE-711 TWE-711M TWE-711Ni Arcstar711Ni | TF-565+TSW-12KM |
| S355N | | | -20 | 40 | TM-56 | TGA-56 | TLH-581 | TM-77 | TWE-711 TWE-711M TWE-711Ni Arcstar711Ni | TF-565+TSW-12KM |
| S355NL | | | -50 | 27 | TM-60 | TGA-80Ni1 | TN-28 | TM-88 | Arcstar T12 | TF-210+TSW-12KH |
| S355M | | | -50 | 40 | TM-56 | TGA-56 | TLH-581 | TM-77 | TWE-711 TWE-711M | TF-565+TSW-12KM |
| S355ML | | | -20 | 27 | TM-60 | TGA-80Ni1 | TN-28 | TM-88 | Arcstar T12 | TF-210+TSW-12KH |
| S420N | 520-680 | 420 | -50 | 40 | TM-56 | TGA-56 | TLH-581 | TM-88 | TWE-811Ni11 | TF-565+TSW-60G |
| S420NL | | | -20 | 27 | TM-60 | TGA-80Ni1 | TN-28 | TM-88 | TWE-81K2 Arcstar81K2M | TF-210+TSW-12KH |
| S420M | | | -20 | 40 | TM-56 | TGA-56 | TLH-581 | TM-88 | TWE-811Ni1 | TF-565+TSW-60G |
| S420ML | | | -50 | 27 | TM-60 | TGA-80Ni1 | TN-28 | TM-88 | TWE-81K2 Arcstar81K2M | TF-210+TSW-12KH |
| S460N | 550-720 | 460 | -20 | 40 | TM-56 | TGA-56 | TN-28 | TM-88 | TWE-811Ni1 | TF-565+TSW-60G |
| S460NL | | | -50 | 27 | TM-60 | TGA-80Ni1 | TN-28 | TM-88 | TWE-81K2 Arcstar81K2M | TF-210+TSW-E40 |
| S460M | | | -20 | 40 | TM-56 | TGA-56 | TN-28 | TM-88 | TWE-811Ni1 | TF-565+TSW-60G |
| S460ML | | | -50 | 27 | TM-60 | TGA-80Ni1 | TN-28 | TM-88 | TWE-81K2 Arcstar81K2M | TF-210+TSW-E40 |

AWS

EN ISO

YP

TS

EL

IV

TLH-581

A5.1 E7018-1 H4 EN ISO 2560-A E46 4 B 1 2 H5

>460 550-620

SMAW

| 焊接方式 | 焊材品名 | | | | CTOD |
|------|------------------|----|-----------|--------------------------------|-------------------------------|
| | | CE | DNV, GL | | |
| SMAW | TLH-581 | | | ABS | 0°C(0.36mm) PWHT 605°Cx1hr |
| | TN-28 | V | 5YH10 | BV, NK | |
| GMAW | TM-56 | | | | |
| | TM-60 | V | IVYMSH5 | | |
| GTAW | TGA-56 | V | | ABS, LR | |
| | TGA-80Ni1 | | | | |
| FCAW | TWE-711 | V | IIIYMSH10 | ABS, BV, CR, D NVGL, LR, NK | -40 > 47J |
| | TWE-711M | V | IIIYMSH10 | ABS, LR | |
| | TWE-711Ni | V | IVYMSH10 | ABS, BV, LR, NK | |
| | ArcStar 711NiM | | | | |
| | ArcStar T12 | V | | | PWHT -45 > 70J |
| | TWE-811Ni1 | | | | -40 > 47J |
| MCAW | TWE-81K2 | V | VY46MSH5 | LR, NK | |
| | ArcStar 81K2M | V | VY46MSH5 | | |
| | TM-77 | V | | LR | |
| SAW | TM-88 | V | VY46MSH5 | | |
| | TF-565+ TSW-12KM | | IIIYMH5 | ABS, BV | |
| | TF-565+ TSW-60G | | | | |
| | TF-210+ TSW-12KH | V | VY42MH5 | ABS, NK | -10°C (1.24mm) |
| | TF-210+ TSW-E40 | V | | ABS | |

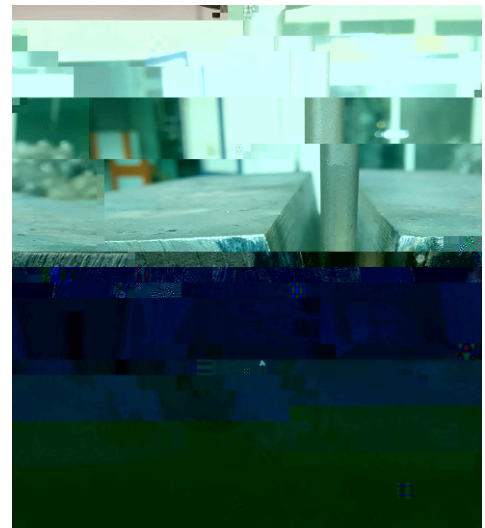
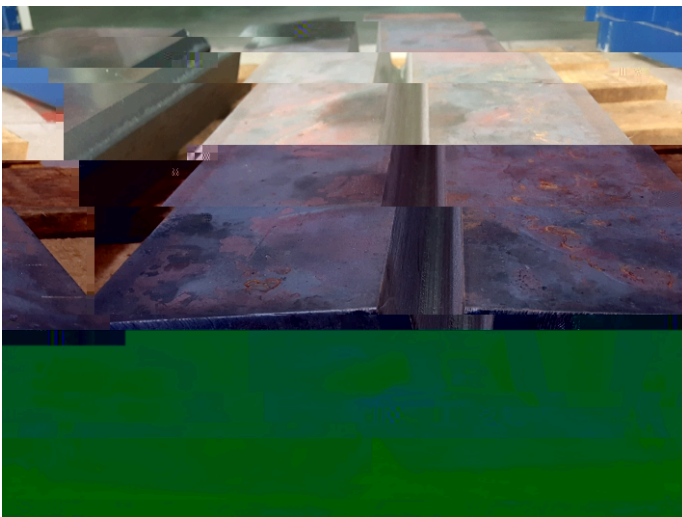
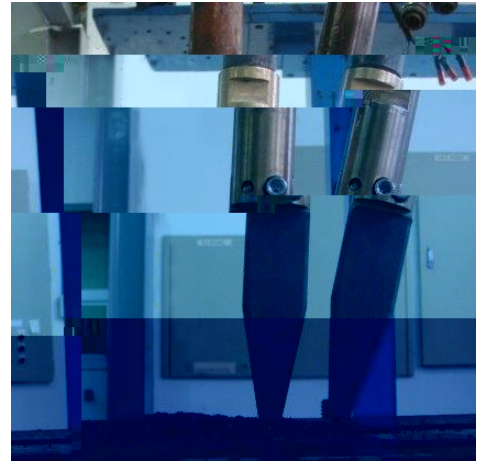
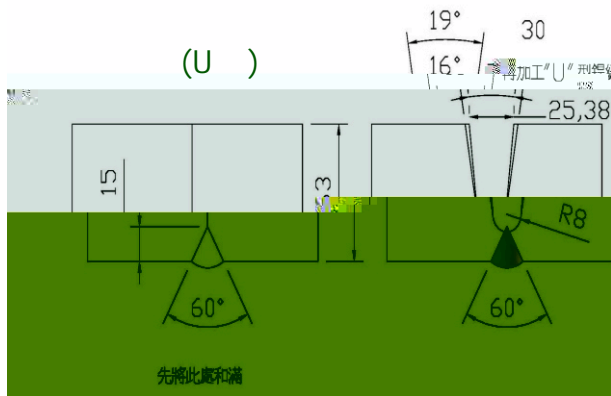
TIENTAI ELECTRODE CO., LTD.

力 接技 介 -SAW窄 (TF-210/TSW-12KH)

SAW

TF-210
(Narrowgap)

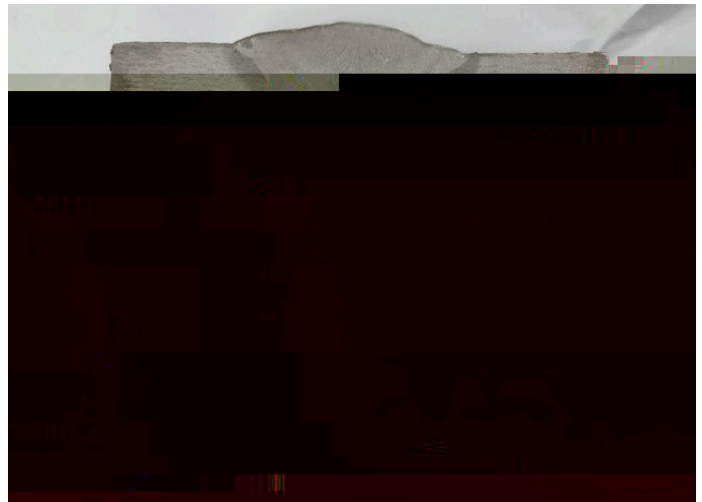
CTOD -10°C



(U)

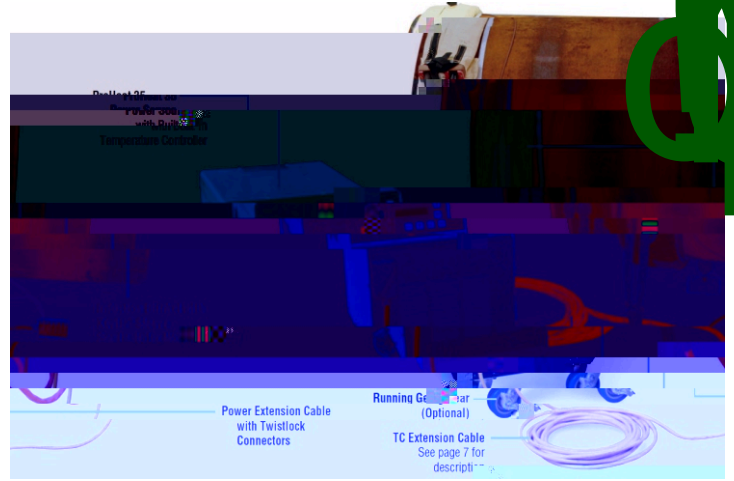


TF-210+ TSW-12KH



Pro

#



Continuum 500

Continuum 500

MIG FCAW

