



(9466-75
6568-89)

9466—75
(6568—89)

Covered metal electrodes for manual arc welding of steels
and deposition Classification and general specifications

12 7200, 12 7300

01.01.76

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1.2.

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1.3. 10051 10052. — 9467,

1.4. —

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$$1,20 < \tilde{D} < 1,45 ;$$

$$1,45 < \hat{D} < 1,80 - ;$$

$$\tilde{v} > 1,80 (D$$

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	90	±5	8
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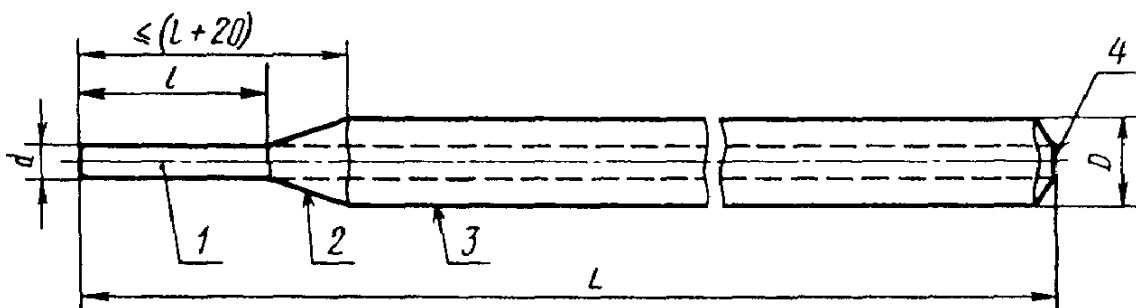
0

2.

2.1.

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1 — стержень, 2 — участок перехода, 3 — покрытие; 4 — контактный
торец без покрытия

Черт. 1

2.2, 2.3. (, , 1).
 2.4.
 (. 2).

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i,6	200 250	150 200 (250)	20
2,0	250 (300)	200 250 (300)	20
2,5	250 300 (350)	250 (300)	
3,0	300 350 (450)	300 350	25
4,0	350 450	350 (450)	
5,0 6,0 8,0	450	350 450	
10,0 12,0			30

1. , , .
 2. 3.15;
 3 25, 6.3 12,5 .
 3.
 4. / .
 5 6. (, . 1).
 7. 10 % , -
 ±4 .

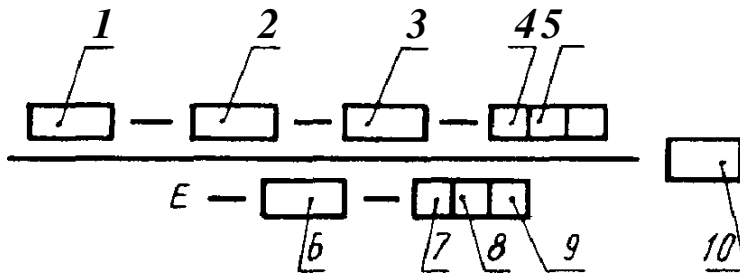
8.

9.

10 %

10.

(, . 1, 2).



1 — , 2 — , 3 — ; 4 — , 5 —
 6 — 9467, 10051, 10052,
 7 — ; 8 —
 9 —
 ; 11 — 50 , 10 —

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1. 10051, 10052, 9467,

2.

60 / 2

2.5.

. 2.4

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-13/45,

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9467

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9466-75>

9467-75

~~-13/45-3,0~~

9466-75 -

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4,0

9467

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9467-75

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9466-75 -

-10 25 13 2

10052,

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4,0 ,  
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, 300/33-1, , -  
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~~300/33-1- 40~~

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3.1.

10052 9467, 10051 -  
10051 , 10052, 9467, -  
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3.2.

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2246.

3.3.

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3.4.

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50 %

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2,4

3.7.

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25 %

3.5—3.7. (

3.8. (

3.9.

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| 1,6       | 0,08 (0,12) | 0,12 (0,16) |
| 2,0       | 0,10 (0,14) | 0,15 (0,20) |
| 2,5       | 0,12 (0,16) | 0,18 (0,24) |
| 3,0; 3,15 | 0,15 (0,20) | 0,23 (0,28) |
| 4,0       | 0,20 (0,26) | 0,28 (0,34) |
| 5,0       | 0,24 (0,32) | 0,32 (0,40) |
| 6,0; 6,3  | 0,28 (0,36) | 0,36 (0,45) |
| 6,3       | 0,30 (0,40) | 0,40 (0,50) |

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|               | -     | 3,15   | 5     |
|               |       | . 3,15 | 10    |
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|               |       | 3,15   | 3     |
|               |       | . 3,15 | 5     |
|               |       |        |       |
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| 4.4.          |       |        | 2.1,  |
| 3.3—3.7, 3.13 |       |        | ,     |
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| 4.5. (        |       | 1).    |       |
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| 4.7.          |       |        | 3 11, |
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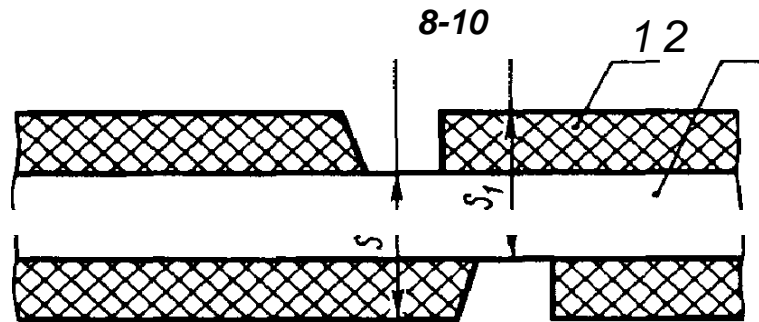
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(180± 10) ° —

(110±5) ° —



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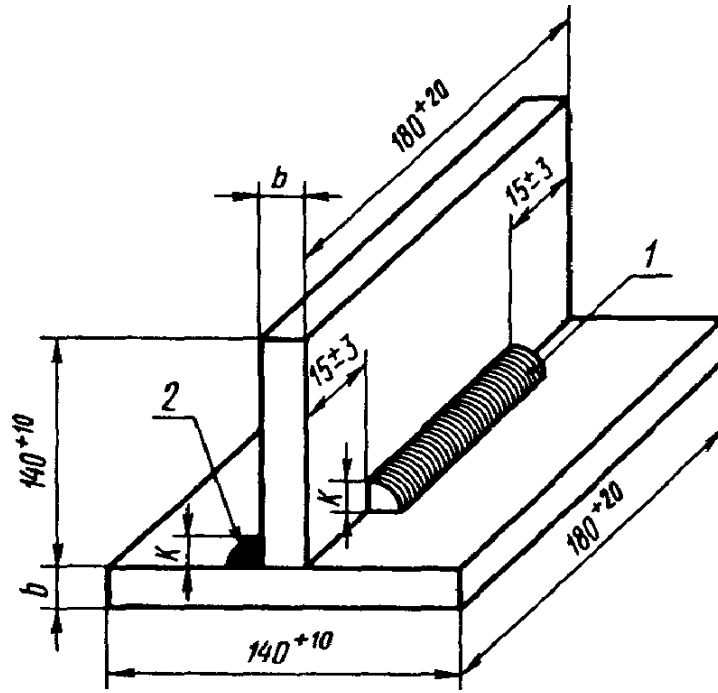
20 1050. 380

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5.10. . 4 . 7.



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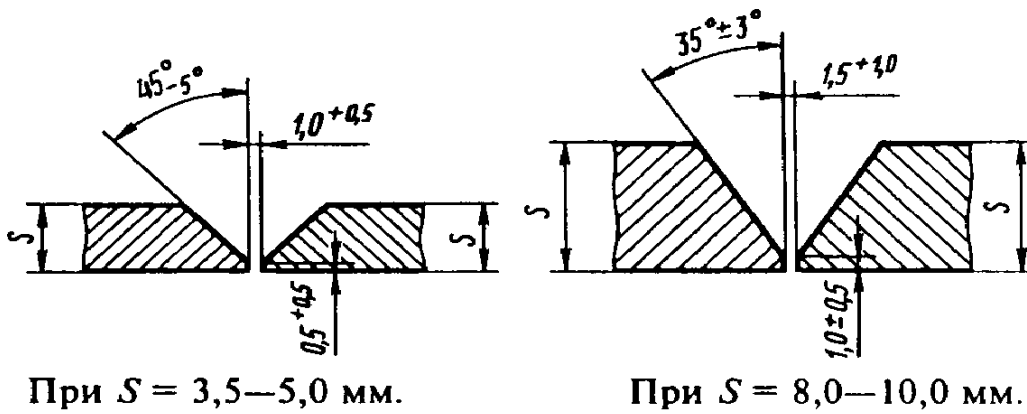
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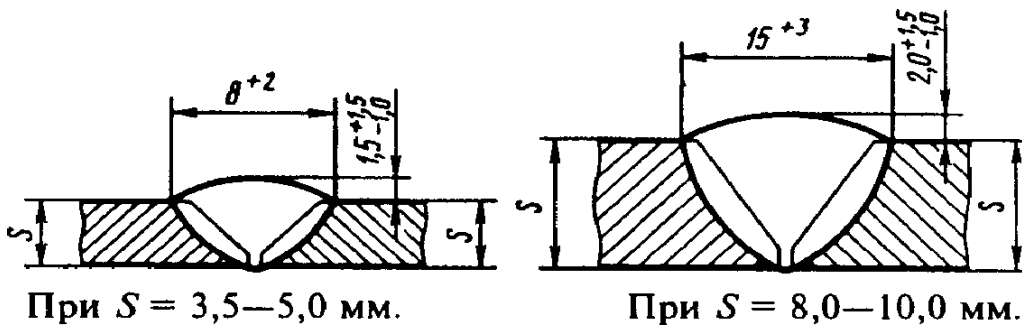
7

|                    | <i>b</i> |     |
|--------------------|----------|-----|
| 1,6<br>2,0         | 3—5      | 2—3 |
| 2,5<br>3,0<br>3,15 | 6-10     | 4-5 |
| 4,0                | 10-16    | 6-8 |

|                      |                  |                     |            |
|----------------------|------------------|---------------------|------------|
|                      |                  | <i>b</i>            |            |
| 5,0<br>6,0<br>6,3    |                  | 14-20               | 8—10       |
| 8,0                  |                  | 20-25               | 10-12      |
| 10,0<br>12,0<br>12,5 |                  | 25-30               | 12-14      |
|                      |                  |                     | 8          |
|                      |                  | <i>S</i>            |            |
| 2,5<br>.2,5          | 32—42<br>108—133 | 3,5-5,0<br>8,0—10,0 | 100<br>120 |



Черт. 5



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22536.12

HRC<sub>3</sub> < 42,

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| 4,0                  |        | 100      |      |
| 5,0<br>6,0<br>6,3    |        | 120      |      |
| 8,0                  |        | 150      |      |
| 10,0<br>12,0<br>12,5 |        | 180      |      |

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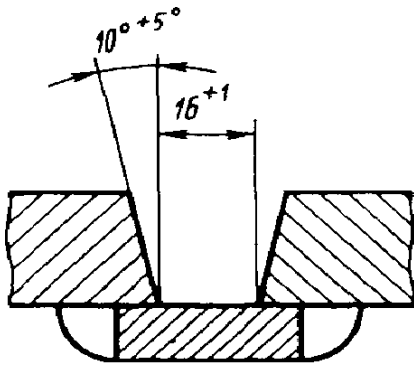
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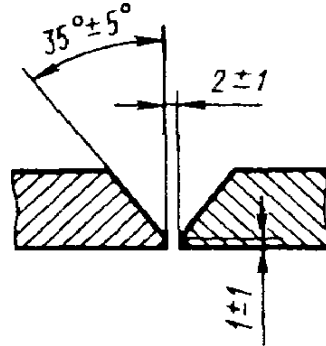
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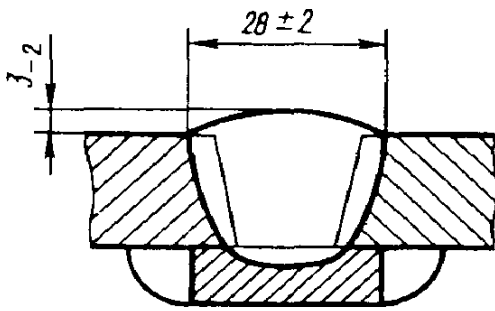


Вариант А

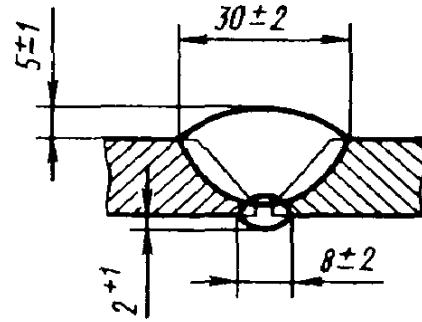


Вариант Б

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Вариант А



Вариант Б

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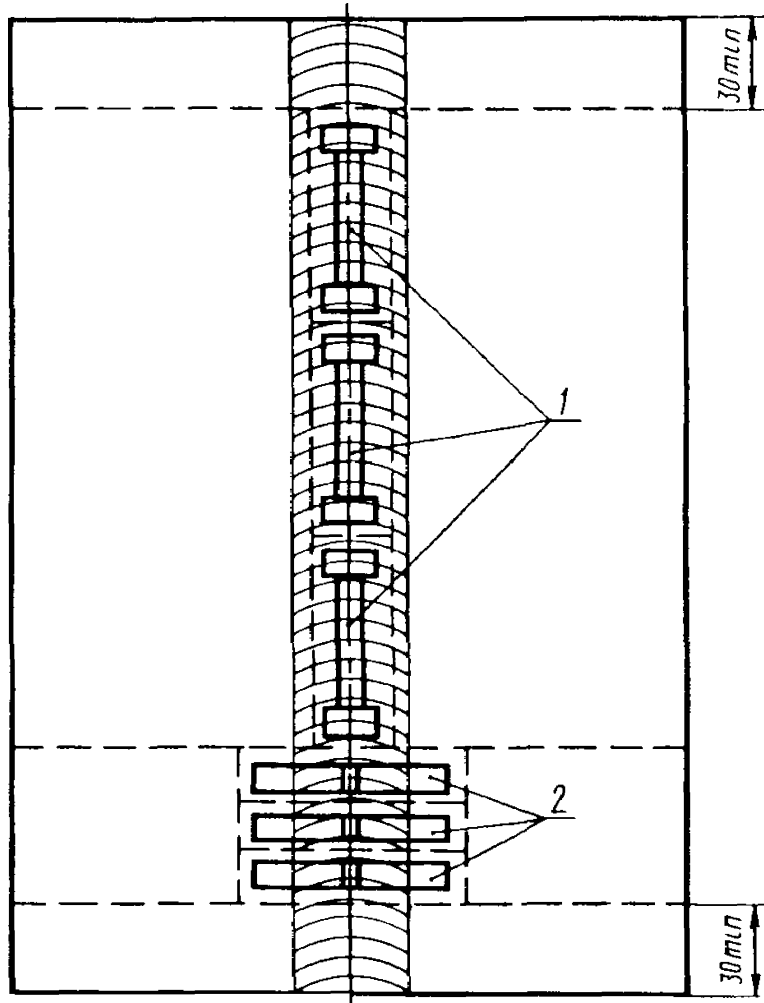
5.30. -  
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5.29, 5.30. ( , . 1, 2).  
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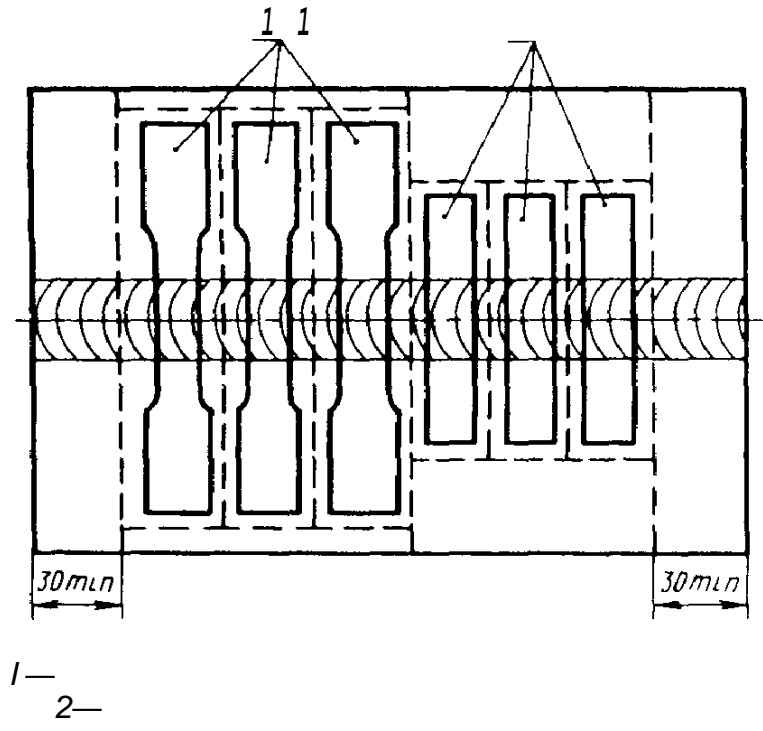
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| 5.32, 5.33. ( |               | 1, 2).      |   |
| 5.34.         |               |             | - |
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|               | <b>XXVIII</b> | <b>XIII</b> |   |
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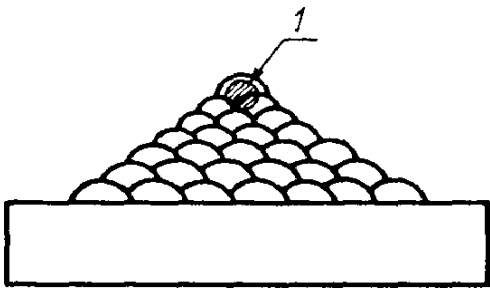
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 5.34—5.39. ( , . 1).  
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 8273  
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 7933  
 0,7 -  
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 10354 0,1—0,2  
 25951;  
 8273 -  
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 7933  
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 -70, -80 , -80 8828,  
 -70 -78 2228,  
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 6.2 ( 1).  
 6.3. :  
 3 — 2,5 ;  
 5 — 3,0—4,0 ;  
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 6.4. :  
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 4 4598; 18617 15623 -  
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**27.03.75 779**

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4. **9466-60**

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|          |                                        |
| 380-88   | 5,8, 5.9, 5.13, 5 22, 5.25, 5.31, 5.38 |
| 1050—88  | 5.8                                    |
| 2228—81  | 6.1                                    |
| 2246—70  | 3.2, 4.2                               |
| 2789-73  | 5 18, 5.19                             |
| 4598-86  | 6.4                                    |
| 5632-72  | 5.22, 5.38                             |
| 6032—89  | 5.39                                   |
| 6996—66  | 5.30, 5.35, 5.37                       |
| 7376-89  | 6.4                                    |
| 7512-82  | 5.18, 5.19                             |
| 7933—89  | 6.1                                    |
| 8273-75  | 6.1                                    |
| 8828—89  | 6.1                                    |
| 9421-80  | 6.4                                    |
| 9467-75  | 1.3, 2.4, 2.5, 3.1, 5.30               |
| 10051—75 | 1.3, 2.4, 2.5, 3.1, 5.23               |
| 10052-75 | 1.3, 2.4, 2.5, 3.1, 5.30               |
| 10198-91 | 6.4                                    |
| 10354-82 | 6.1                                    |
| 11878—66 | 5.38                                   |
| 12344—88 | 5.23                                   |
| 12345-88 | 5.23                                   |
| 12346-78 | 5.23                                   |
| 12347—77 | 5.23                                   |
| 12348—78 | 5.23                                   |
| 12349-83 | 5.23                                   |
| 12350—78 | 5.23                                   |
| 12351—81 | 5.23                                   |

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| 12352-81    | 5.23 |
| 12353-78    | 5.23 |
| 12354-81    | 5.23 |
| 12355-78    | 5.23 |
| 12356—81    | 5.23 |
| 12357-84    | 5 23 |
| 12358-82    | 5 23 |
| 12359-81    | 5 23 |
| 12360—82    | 5 23 |
| 12361-82    | 5 23 |
| 12362-79    | 5 23 |
| 3 2363-79   | 5 23 |
| 12364—84    | 5.23 |
| 12365-84    | 5.23 |
| 14192—77    | 6.8  |
| 15623-84    | 64   |
| 15846-79    | 6.4  |
| 18617—83    | 6.4  |
| 18895—81    | 5.23 |
| 22536 0-87  | 5.23 |
| 22536.1-88  | 5.23 |
| 22536.2-87  | 5.23 |
| 22536.3—88  | 5.23 |
| 22536.4-88  | 5 23 |
| 22536.5—87  | 5.23 |
| 22536.6—88  | 5.23 |
| 22536 7—88  | 5 23 |
| 22536 8—87  | 5 23 |
| 22536.9-88  | 5.23 |
| 22536.10-88 | 5.23 |
| 22536.11-87 | 5.23 |
| 22536.12—88 | 5.23 |
| 25591—83    | 6.1  |
| 26381—84    | 6.10 |
| 26663-85    | 6.10 |
| 28473—90    | 5.23 |

6. 3—93 -

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7. ( 1988 ., 1996 .) 1, 2, -  
12—88, 10—90)





9466—75

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