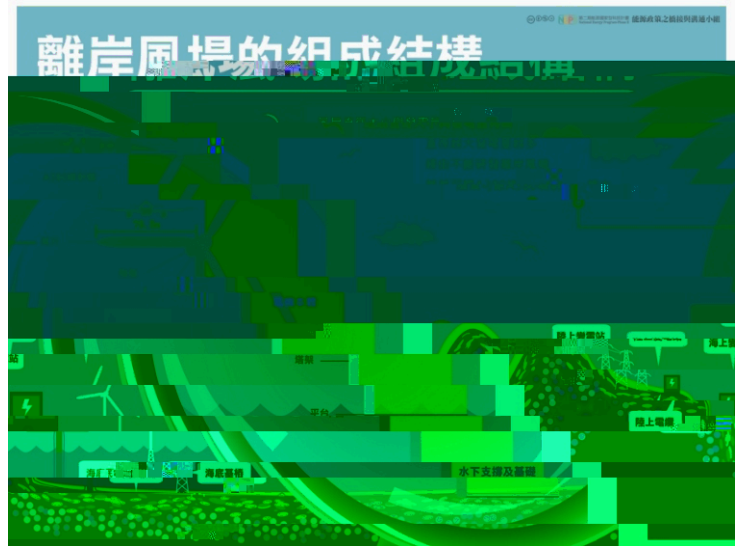




1.



2.



A 380

3.

基礎型式	重力式 Gravity	單樁式 Monopile	三樁式 Tripile	吸筒式 Suction	三腳管式 Tripod	套管式 Jacket	浮動式 Float
適用風速	12~15m/s	12~15m/s	12~15m/s	12~15m/s	12~15m/s	12~15m/s	12~15m/s
適用水深	0~25m	20~50m	20~50m	>80m	0~25m	0~25m	20~
強度需求	無	無	無	無	無	無	無
經濟水深	0	0.5~20m	0.5~20m	20~	0.5~20m	0.5~20m	20~

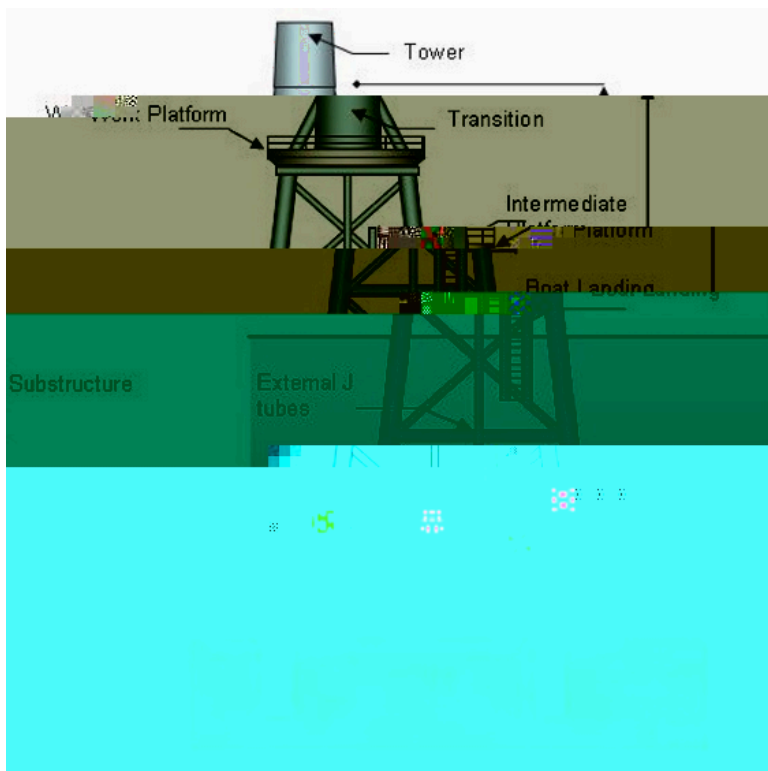
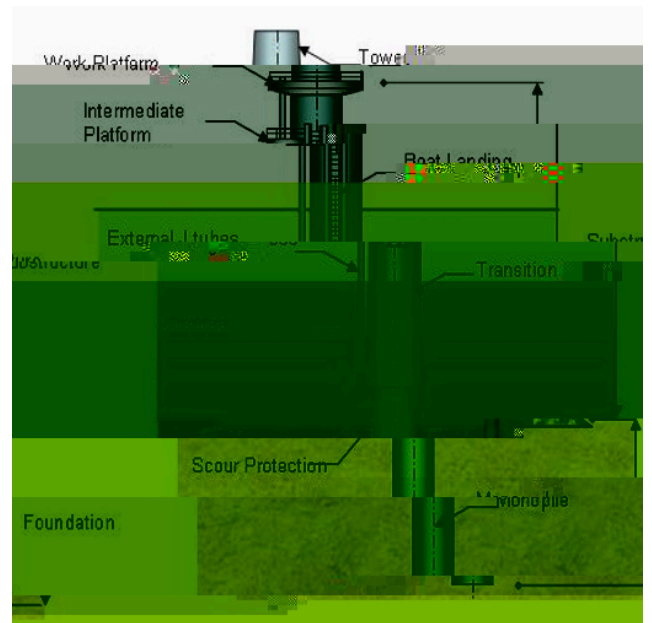


4.

(Monopile)-

4~ 6M

redundancy

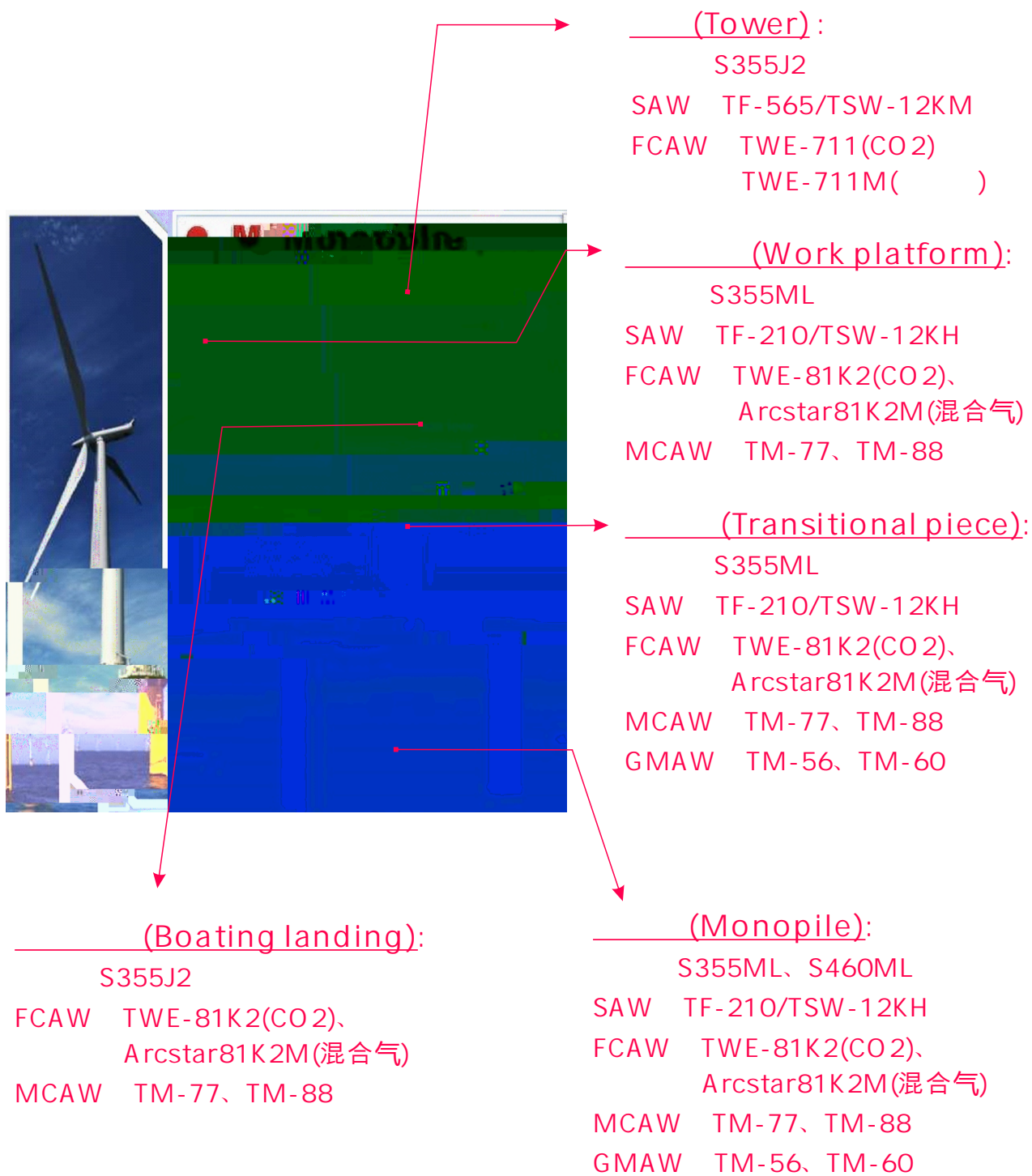


(Jacket)-

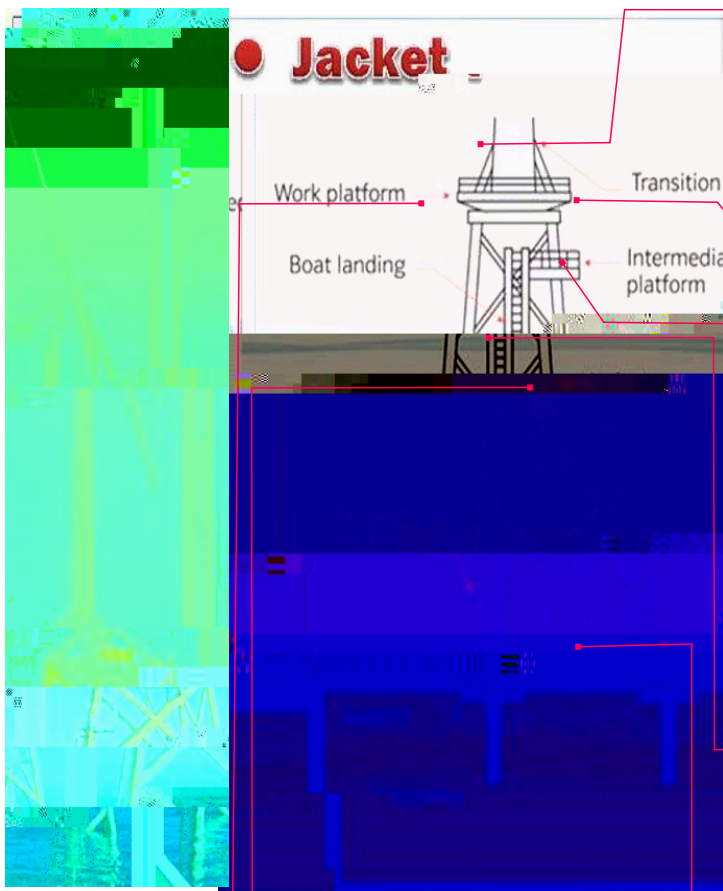
truss

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			520~680	420
S420NL	-50	27		
S420M	-20	40		
S420ML	-50	27		
S460N	550~720	460	-20	40
S460NL			-50	27
S460M			-20	40
S460ML			-50	27

W

		(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-811Ni1	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

1490

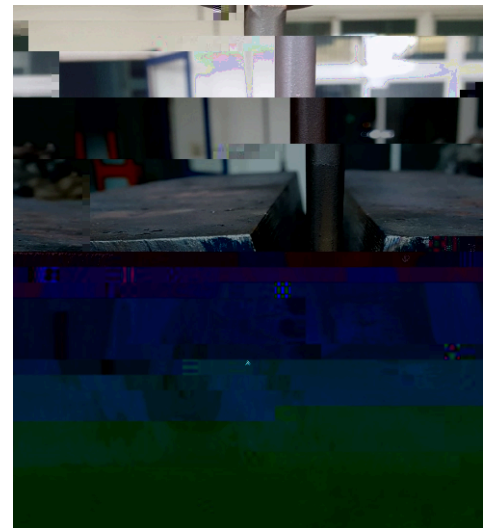
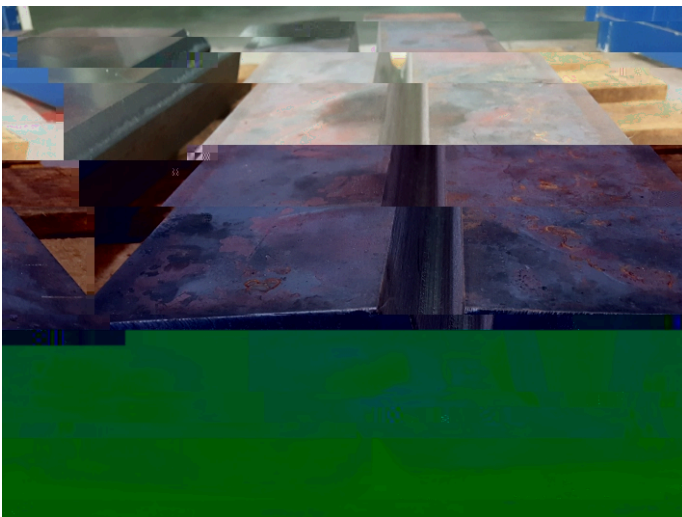
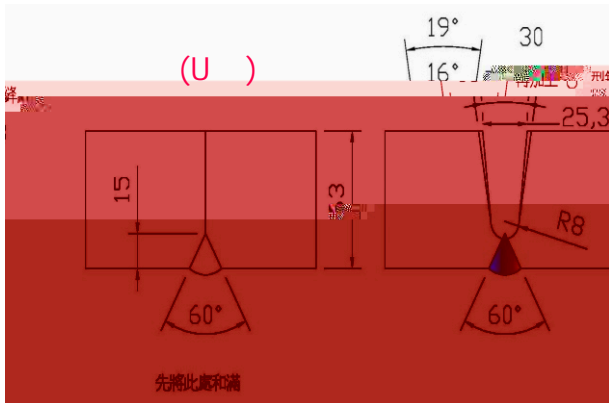
焊接方式	焊材品名	CE	DNV, GL		CTOD
SMAW	TLH-581			ABS	0°C(0.36mm)
	TN-28	V	5YH10	BV, NK	PWHT 605°Cx1hr
GMAW	TM-56				
	TM-60	V	IVYMSH5		
GTAW	TGA-56	V		ABS, LR	
	TGA-80Ni1				
	TWE-711	V	IIIYMSH10	ABS, BV, CR, D NVGL, LR, NK	-40 > 47J
	TWE-711M	V	IIIYMSH10	ABS, LR	
FCAW	TWE-711Ni	V	IVYMSH10	ABS, BV, LR, NK	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

力 接技 介 -SAW窄 (TF-210/TSW-12KH)

SAW

TF-210
(Narrow gap)

CTOD -10°C



(U)



TF-210+TSW-12KH

-Pro Heat 35 Continuum 500

Pro Heat 35 ()



Continuum 500

Continuum 500

MIG FCAW

C

Accu-Pulse :

MIG

Versa-Pulse :

6mm

High deposition MIG :

RMD :

: MIG FCAW

