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Automatic and semi-automatic welding with wire diameters of 2 mm and smaller	1,6	0,25	3584-83
Note: The bulk density of the flux should be 1.3-1.7 kg/dm ³ .			

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Название публикации: «PLASMA WITH CUTTING»

Abstract. Plasma cutting current at the time industry and in mechanical engineering wide Plasma cutting metal separation in the zone local heating and his/her next melting own inside takes . Such important heating special equipment using harvest was plasma jet using is provided . High with temperature plasma flow to take technology wide in scope is in use .

Keywords: Plasma cutting, electric arc, high electricity, technical oxygen, metal parts, plasmatron .

Plasma cutting metal separation in the zone local heating and his/her next melting own inside takes . Such important heating special equipment using harvest was plasma jet using is provided . High with temperature plasma flow to take technology as follows .

- Initially , electricity arc harvest is , it is the device electrode and his/her chest between or electrode and cut metal between lights up . Such of the arc The temperature is 5000 degrees .
- From this then , gas of the equipment chest to the cage delivery is given , this and of the arc temperature already 20,000 degrees increases .
- Electricity arc with mutual when exposed to gas ionizes , this his/her plasma to the flow to the cycle take comes , its temperature already 30,000 degrees .

Received plasma flow bright shine , high electricity conductivity and of the equipment from the nozzle exit with speed (500-1500 m/s) is described . Such jet again work in the zone metal local at the level warms and melts , then it is cut , this even such of the process in the video also clear it seems .

Special on devices plasma jet working release for various from gases use possible . To these the following includes :

- normal air ;

- technician oxygen ;
- nitrogen ;
- hydrogen ;
- argon ;
- boiling from water harvest steam .

Plasma using metal cutting technology of the equipment chest cage cooling and melted of the material particles processing to give from the zone take to throw own inside This requirements cutting done increaseable to the zone delivery given gas or liquid flow with provided . Special in equipment harvest was plasma jet's characteristics his/her help with thickness up to 200 mm was metal parts cutting opportunity gives .

Plasma cutting machines various in the fields in enterprises successful are used . Their help with not only metal parts , maybe plastic and natural stone products are also successful is cut off . Such unique opportunities and many edge because of this equipment mechanical engineering and shipbuilding in factories , advertising and repair in enterprises , state in the sector wide is used . Such from installations of use big advantage is that they very flat , thin and clear cutting opportunity gives , this many in cases important is a requirement .

Plasma cutting equipment :

Modern at the market two main kind of plasma using metal cutting for used devices offer is being done :

- indirectly impact tools - cutting contactless in a way done increased ;
- straight away impact tools - contact method with cutting

Metal not been products again work for electrode and torch chest between bow turned on first kind of equipment is used . Such installations mainly various in enterprises applies , you them house master in the workshop or repair master's in the garage find you won't get it .

Second kind of on devices electrode and part of himself/herself between electricity arc It burns , of course , only from metal preparation possible . Such on devices working gas whole in the gap (electrode and processing given part between) heated and ionizes

, because in them plasma flow high to power has . In hand plasma to cut done increase for usage possible was such equipment .

Contact principle according to any that work plasma out to leave car standard components from the collection consists of :

- power up source ;
- plasma torch ;
- plasma torch power to the source and working gas supply to the source connect for used cables and hoses ;
- necessary speed and pressure air flow to take for gas cylinder or compressor .

Such all of devices main element plasma torch is , it is like this equipment traditional from welding separate Plasmatrons or plasma cutters following from elements consists of :

- working nozzle ;
- electrode ;
- high to the temperature endurance with separated standing insulating element.
 - Plasma torch main purpose electricity of the bow energy plasma heat to the energy is to convert . Small diameter through the hole plasma torch chest from the cage outgoing gas or air-gas mixture electrode installed cylindrical from the camera This plasma cutter chest cage is , it works gas of the flow necessary speed and shape and accordingly accordingly plasma himself provides . Such cutter with all manipulations at hand done increased : equipment operator by .
 - Operator's plasma cutter weight according to hold to stand necessary into account if we take , high good quality metal to cut provision very difficult to be possible . Often at hand plasma with cutting applicable in parts irregularities , flow traces and swings There is such a thing . to the shortcomings road not to put for various kind devices used for : stands and stop places , this plasma torch cutting line along smooth movement , as well as the chest and part of surface between of the void permanence to provide opportunity gives . is being cut .
 - In hand working from equipment when using air or nitrogen working and cooling gas as usage possible . Such air-gas flow cut from the zone melted metal blow It is

also used for . From the air When using it, it uses a compressor , nitrogen and gas from the cylinder is coming .

Necessary power sources

All plasma cutter power sources are AC powered working although , some it to DC turn takes , others and him/her strengthen takes . But straight away in the stream working devices high to efficiency has . Variable vine machines aluminum and his/her based on alloys such as relatively low melting point was metals cutting for is used .

Plasma of the flow very high power not required in cases , simple from inverters power source as use possible . Exactly this devices high efficiency with separated stands and electricity arc of combustion high stability provides , small industry enterprises and house workshops equip for Of course , with an inverter working plasma torch using big thick metal part cutting doesn't work , but it has many problems solution to do for the most suitable comes . Inverters big advantage their compact are the dimensions , so for them easily you with take walk and to go difficult was in places work to perform for use possible .

Transformer type power sources high to power have , they plasma flow using metal at hand and mechanized cutting for usage possible . Such equipment not only high power , maybe high reliability also separated from They are other devices not working to remain possible was power from the voltage is not afraid .

Plasma of cutting advantages and disadvantages

1. Oxygen torch with compared to plasma cutter higher power , and accordingly respectively , productivity , and this in the parameter only industry scale laser lower than systems .
2. Plasma with cutting useful economical up to 60 mm was metal thickness for point of view Thickness more than 60 mm was materials cutting for oxygen-fuel from cutting use recommendation is being done .
3. Modern plasma cutters different high accuracy and high good quality processing to give metals . The cut is " clean " , with a minimum width , so for it is practical additional does not require grinding .

4. Also , plasma arc again work many edged , security and low environmental pollution with separated stands .

Of the shortcomings modest cut thickness (up to 100 mm), as well as two plasma cutter one of time in itself performance and cutting perpendicularity aside exit for strict to the requirements compliance to do possible that it is not highlight possible

Metal rental with related was almost no how industry working release metal without cutting done cannot be increased . Clearly holes cutting , figured decorative cutting , sheet forms fast cutting - of these all plasma torch using very fast execution possible. This of the method advantages of the following consists of :

1. **economy** - plasma method the material again of work standard methods in the background noticeable at the level victory wins. Only one restriction exists , this of the material thickness with related. Plasma torch using thickness more than 50 mm was steel cutting economic in terms of useless and practical it's not .
2. Plasma portable of devices mobility .
3. **High speed** the details again work and productivity . Traditional electrode from the method different as , work 5-12 times faster increases .
4. All kind of metals cutting (copper, aluminum, steel, stainless steel, titanium and others).
5. Security .
6. **Accuracy** - thermal from the load deformations almost imperceptible and later additional processing to give demand Plasma of cutting accuracy 0.24–0.34 mm .

But the advantages about when speaking , some negative thoughts highlight need :

1. To parts processing to give according to clear Requirements : Master Level 10-50 in the region cutter tendency to the corner strict compliance to do If this is necessary to the rule compliance If not done , structural of parts wear and tear accelerates and cutting the quality is also degraded .
2. Cutting thickness with related restrictions . Strong equipment with , again worked of the material the most high density not exceeding 10 cm need .
3. From this outside , working equipment very complicated , this one of time in itself two torch to use absolutely possible no , they one to unity connected .