


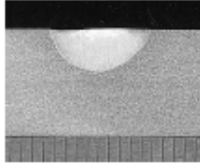
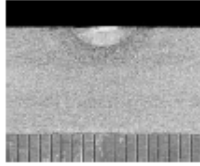


	$Q = 0.17 \text{ ml/s}$	$Q = 0.83 \text{ ml/s}$	$Q = 1.7 \text{ ml/s}$
Arc appearance			
Penetration			Not melted
Arc voltage	23.8 V	17.9 V	15.7 V

10 mm

Fig. 2 Effect of gas flow rate on arc appearance and penetration
(Anode : A1050, $I = 150 \text{ A}$, $L = 10 \text{ mm}$, $v = 5 \text{ mm/s}$).

Source:

Fumikazu MIYASAKA et al

„Characteristics of Hollow Cathode Arc as a Welding Heat Source - Measurement of Pressure in HCA Torch“

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