

ABSTRACT

One object of the present invention is to provide a plasma welding method capable of performing plasma welding while restraining initial investment in a welding device, and the present invention provide a plasma welding method includes a pilot arc generation step in which a pilot arc is generated between the electrode (42) and the insert chip (43) by supplying a first pilot gas which is easily converted into a plasma state between the electrode (42) and the insert chip (43) while supplying a shield gas between the insert chip (43) and the shield cap (47); and a first welding step in which, after the pilot arc generation step, a main arc is generated between the electrode and the workpiece by electrically disconnecting the plus terminal (14A) and the insert chip (43) by the first selector switch (18) while supplying the first pilot gas and the shield gas.