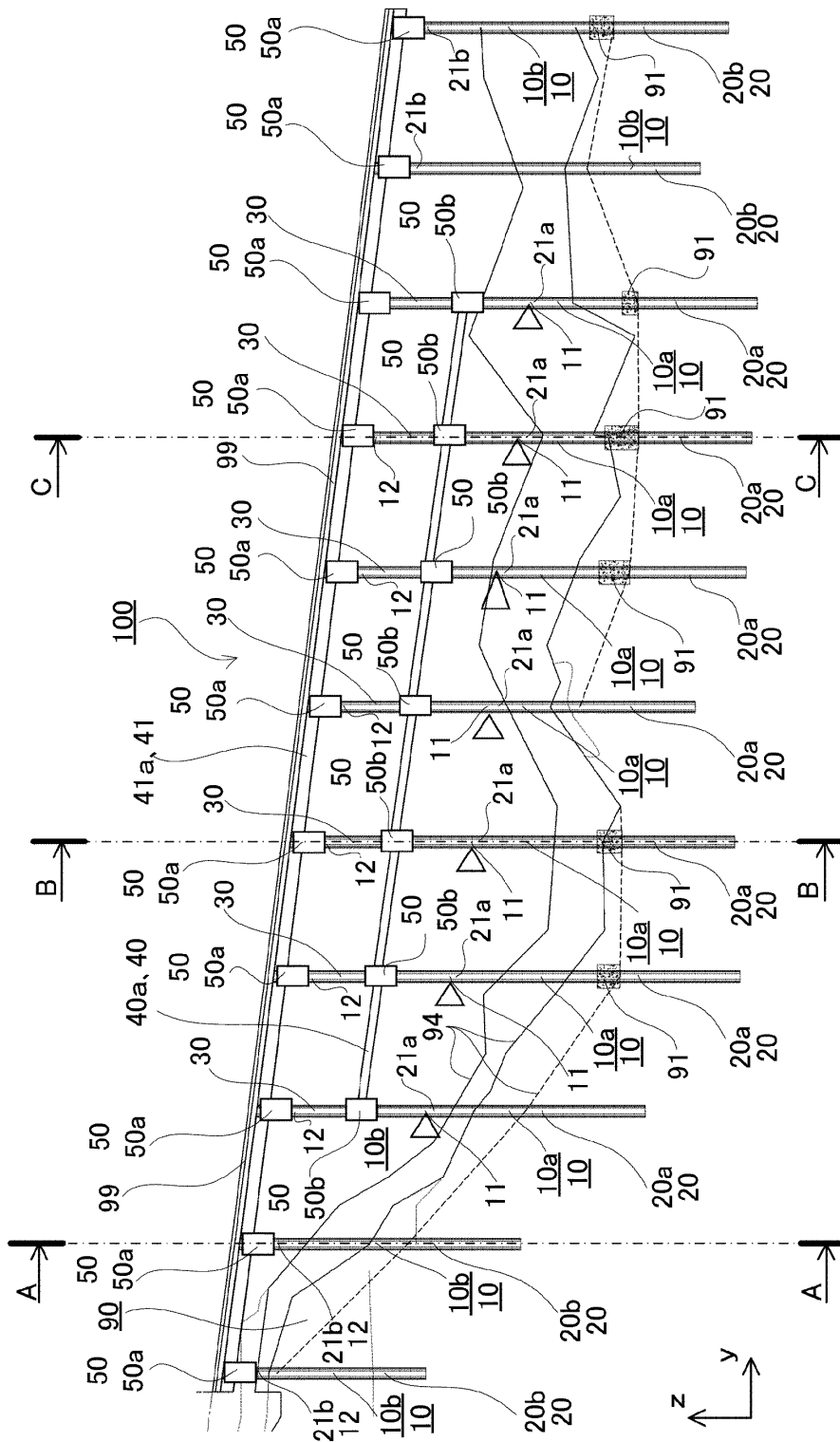
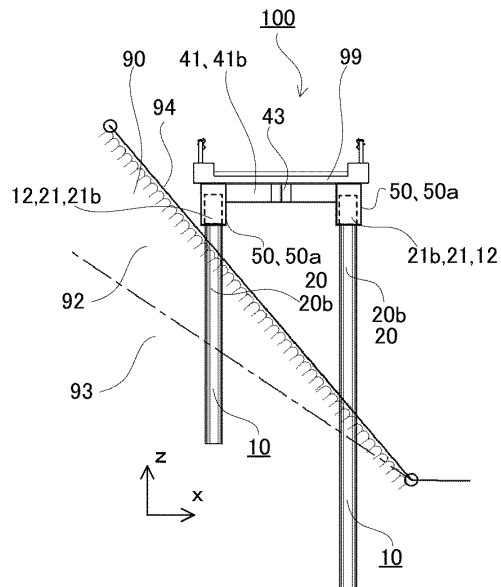


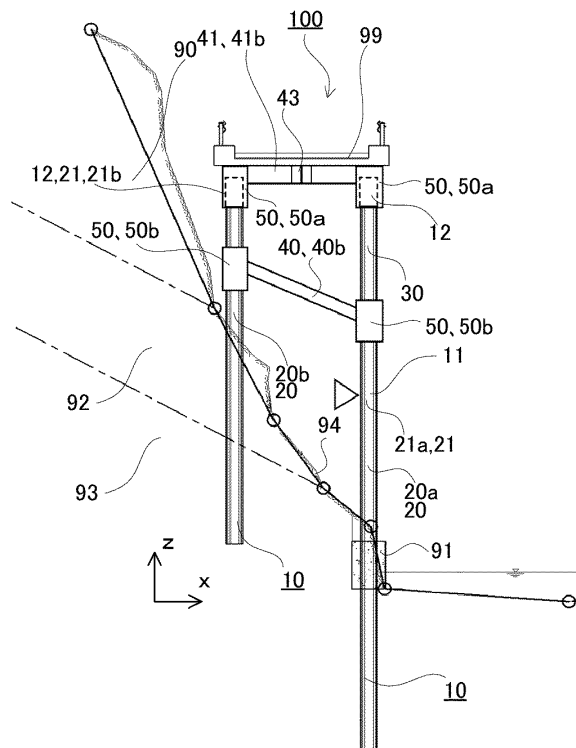
[図1]



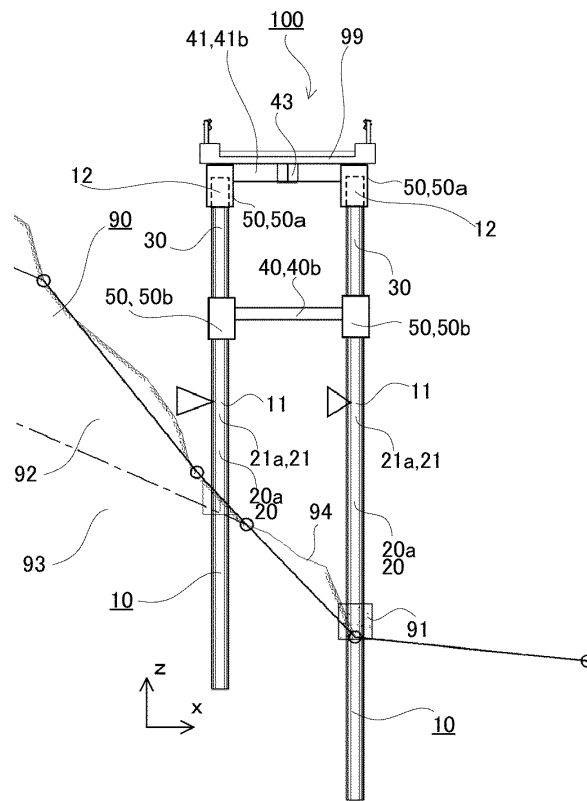
[図2]



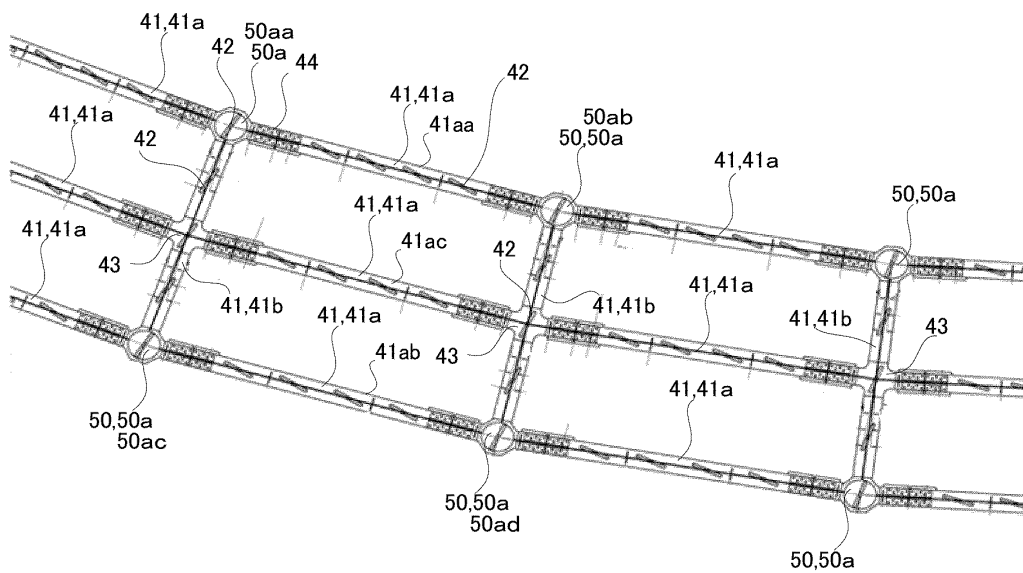
[図3]



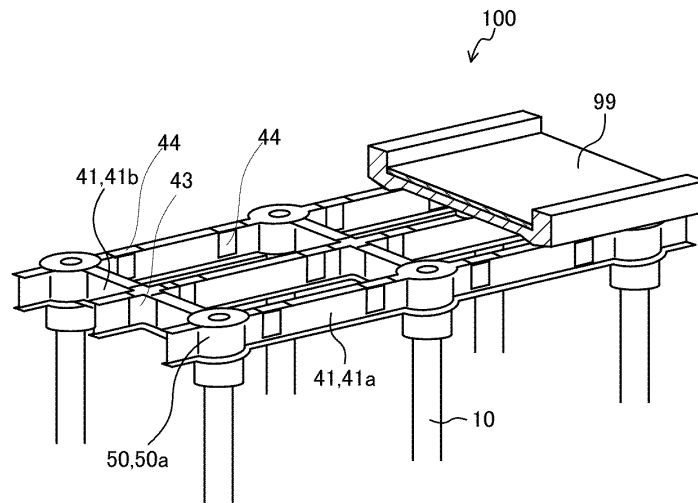
[図4]



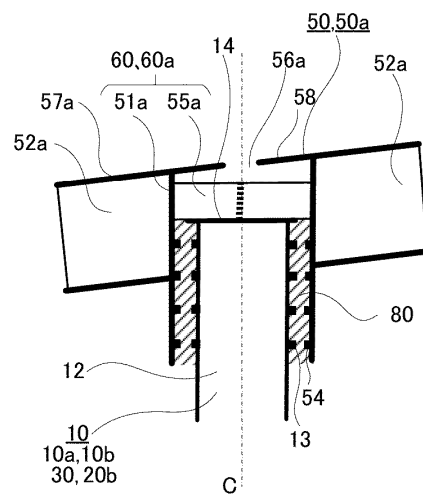
[図5]



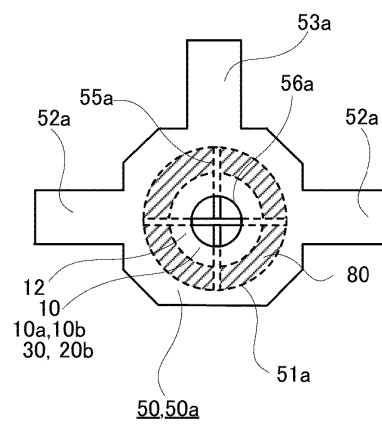
[図6]



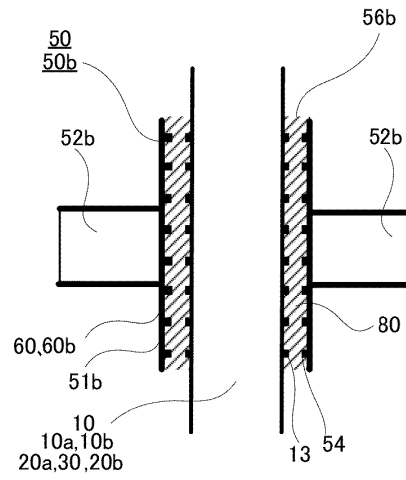
[図7]



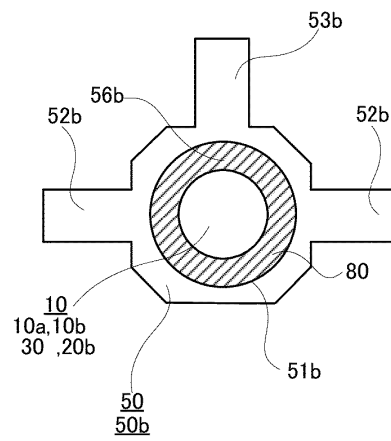
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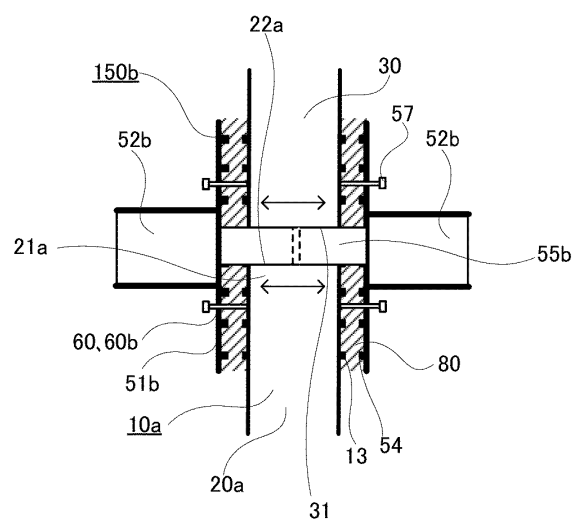
[図9]



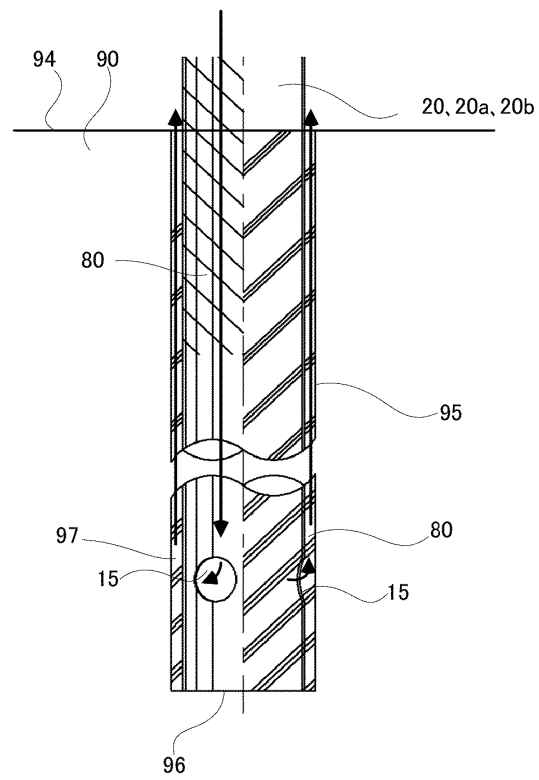
[図10]



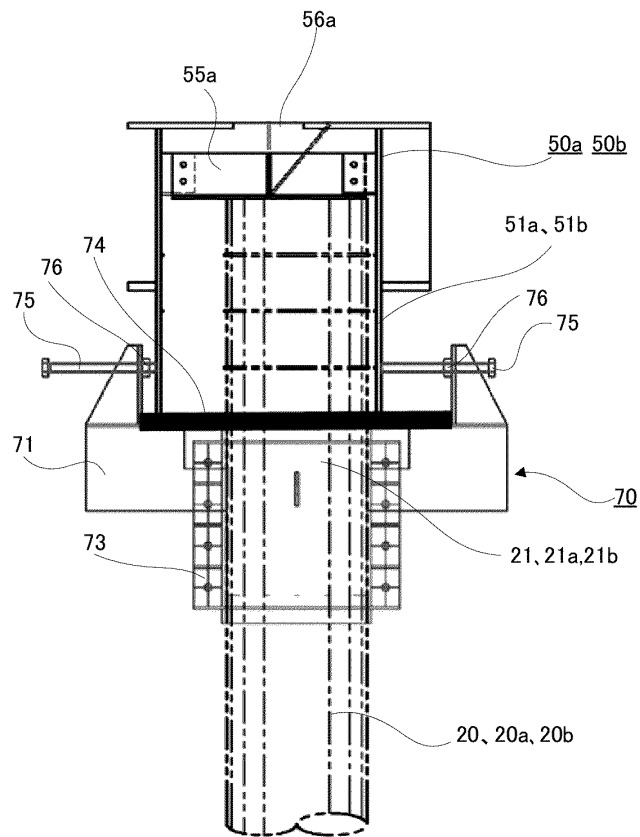
[図11]



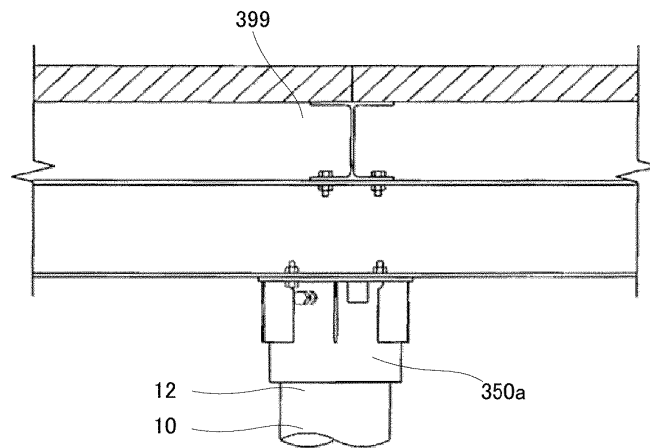
[図12]



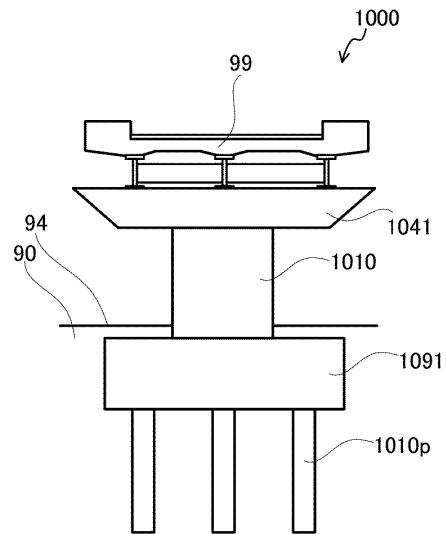
[図13]



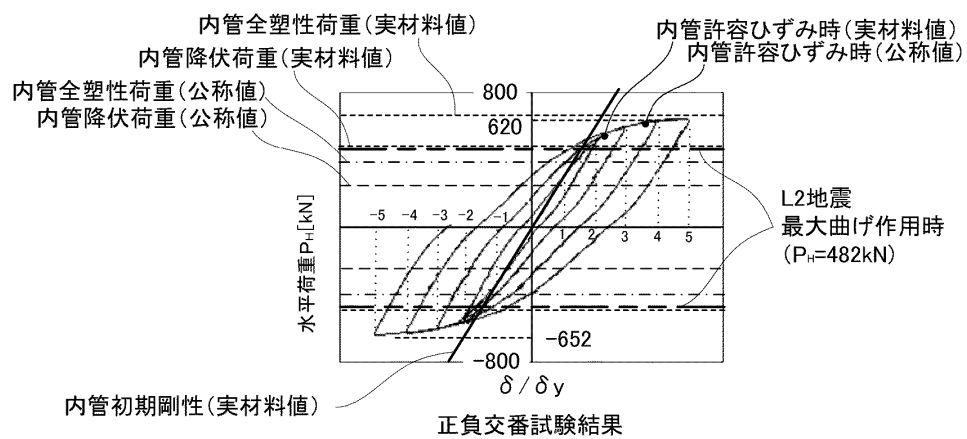
[図14]



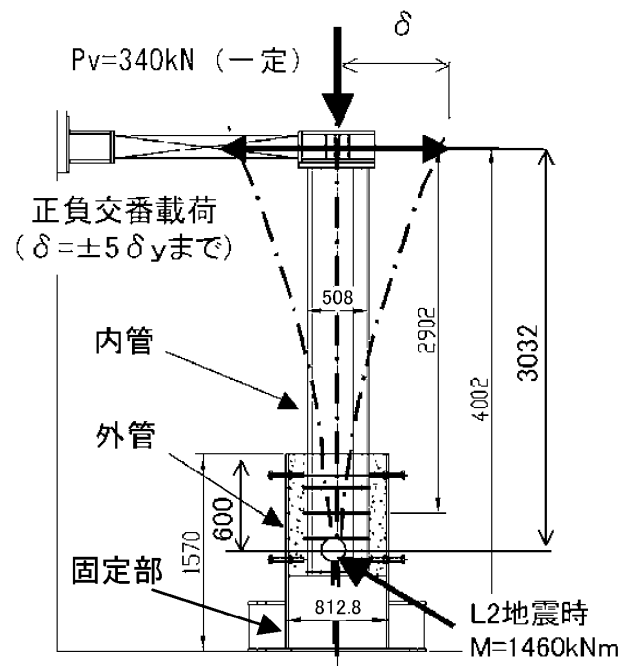
[図15]



[図16]

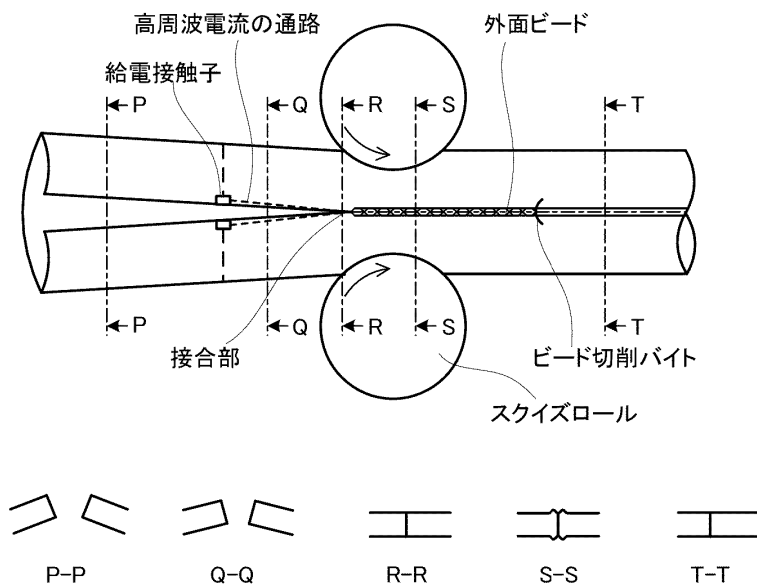


[図17]

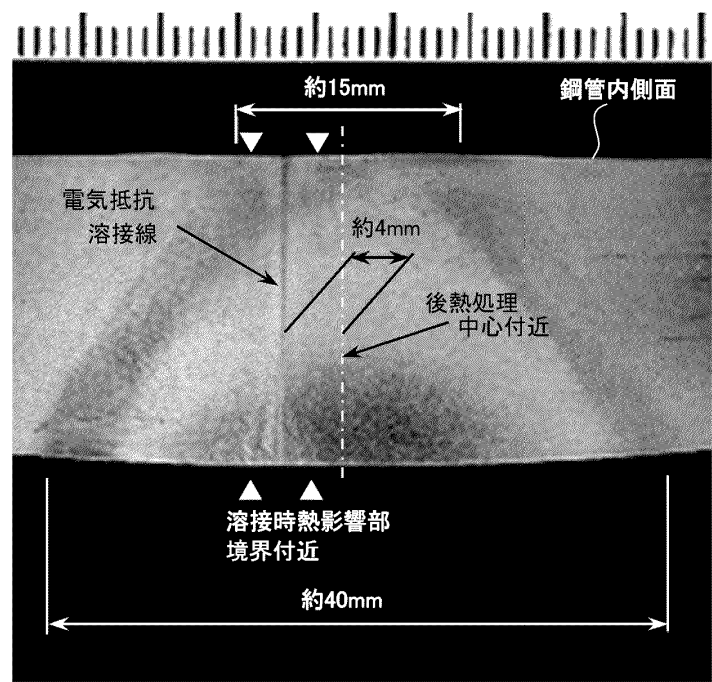


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[図18]



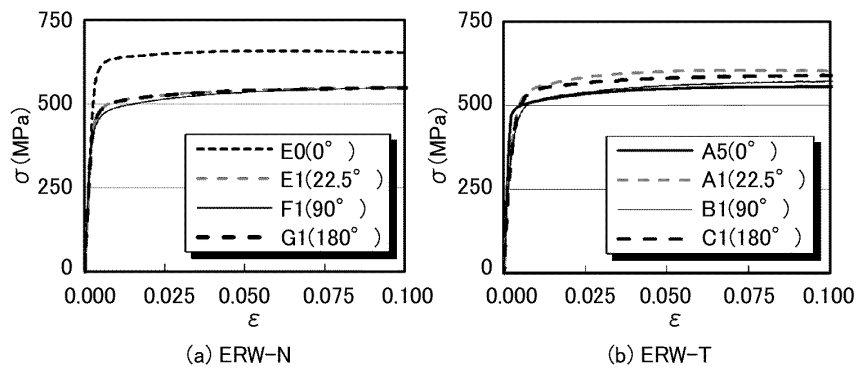
[図19]



[図20]

試験鋼管	外径,板厚	C	Si	Mn	P	S	備考
SKK490	$\phi=508$, $t=19$	0.16	0.19	0.83	0.022	0.004	溶接後熱処理-有 (ERW-T)
SKK490	$\phi=508$, $t=19$	0.16	0.19	0.82	0.014	0.005	溶接後熱処理-無 (ERW-N)

[図21]

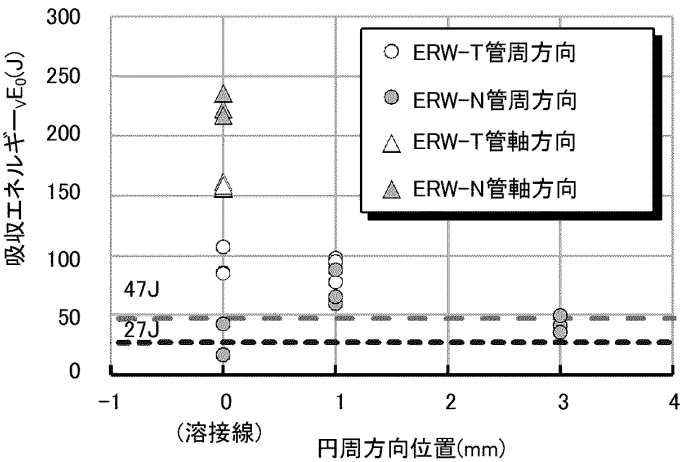


[図22]

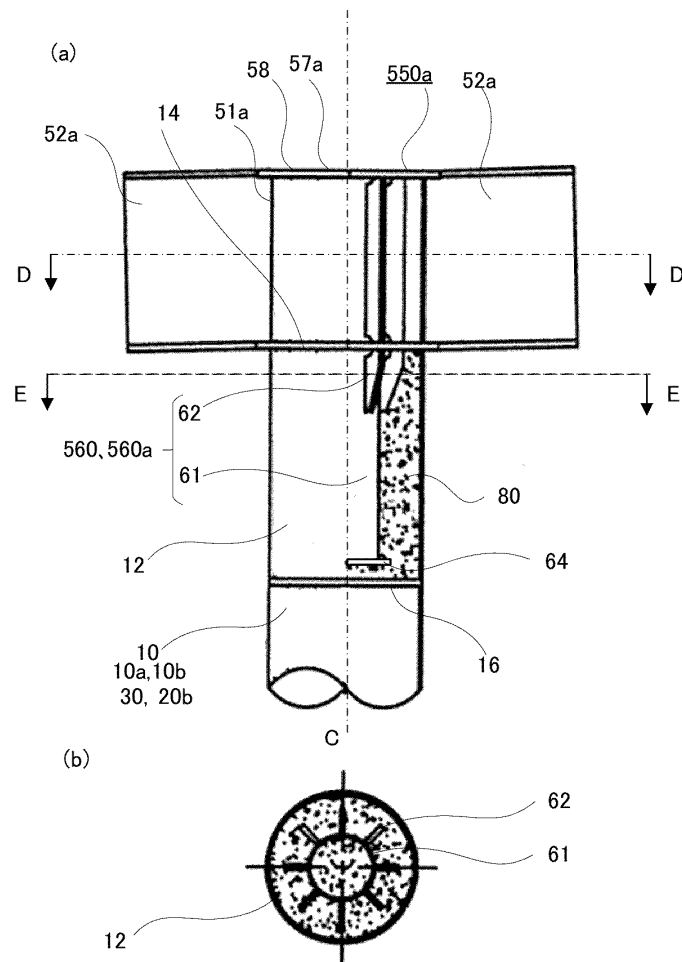
採取方向	採取位置		ERW-N (溶接部後処理-無)				ERW-N (溶接部後処理-有)			
		円周位置		σ_y (MPa)	σ_u (MPa)	YR		σ_y (MPa)	σ_u (MPa)	YR
	溶接部	0°	E0-T	617	657	0.94	A5-T	474	556	0.85
管軸	母材部	22.5°	E1-T	476	551	0.86	A1-T	497	604	0.82
		90°	F1-T	451	551	0.82	B1-T	464	572	0.81
		180°	G1-T	473	549	0.86	C1-T	481	589	0.82
	母材部		MS値	407	542	0.75	MS値	423	575	0.74

*MS値(ミルシート値)

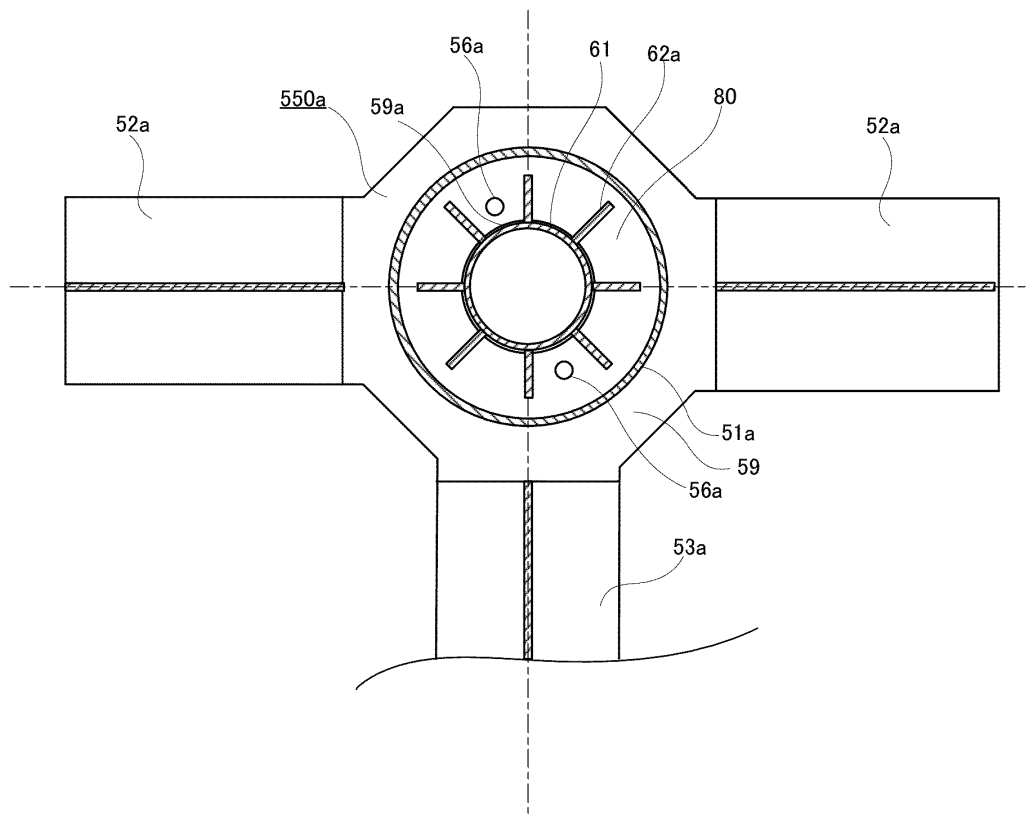
[図23]



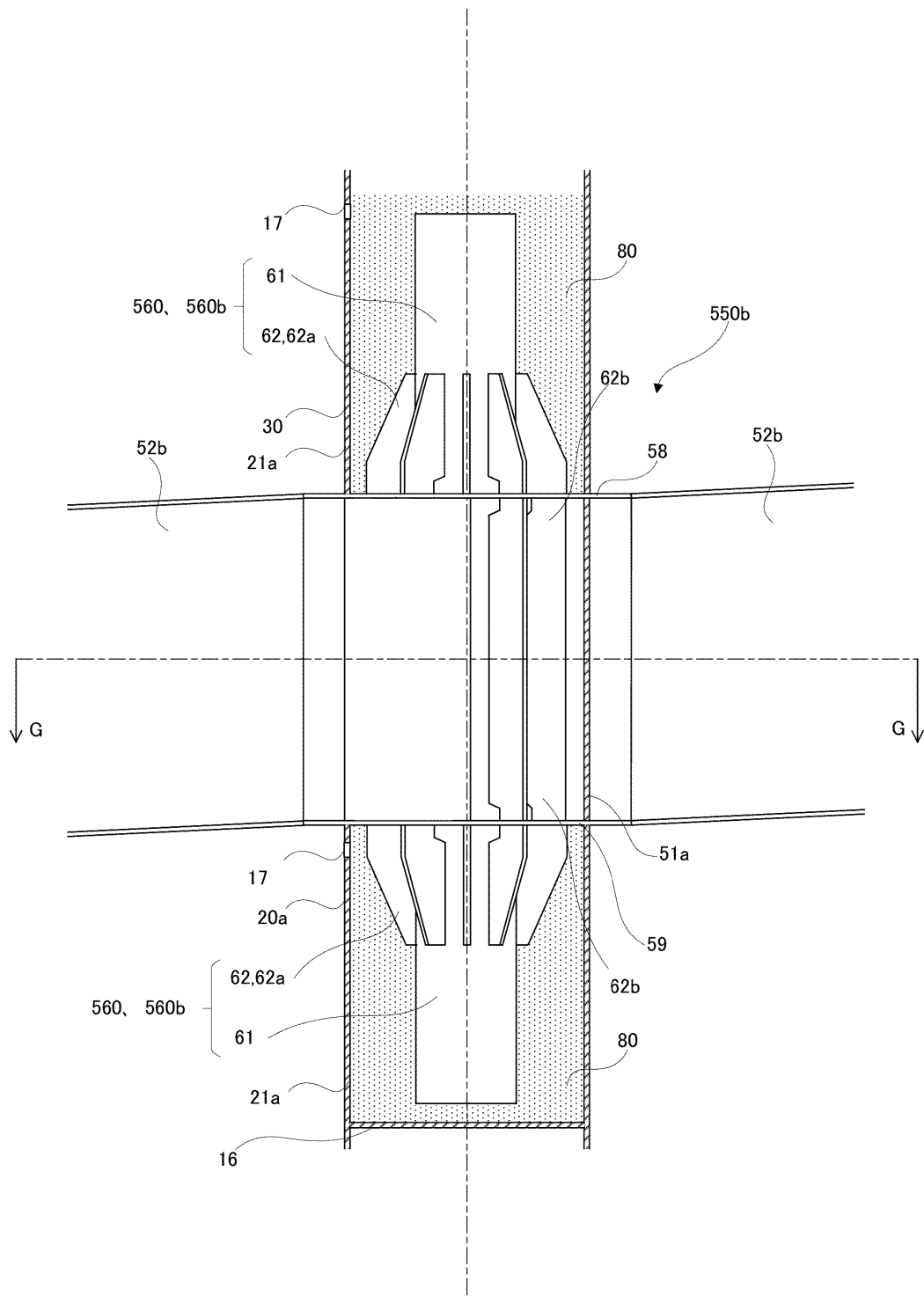
[図24]



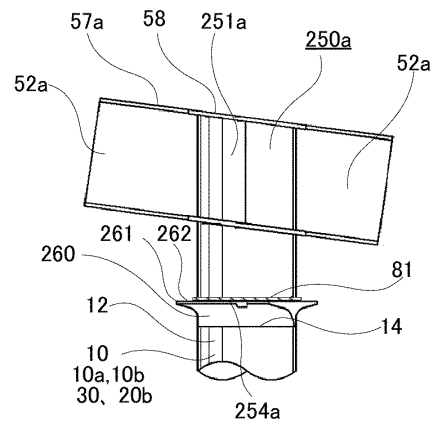
[図26]



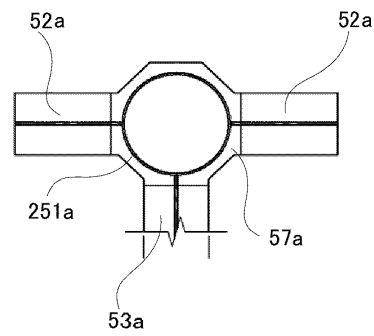
[図27]



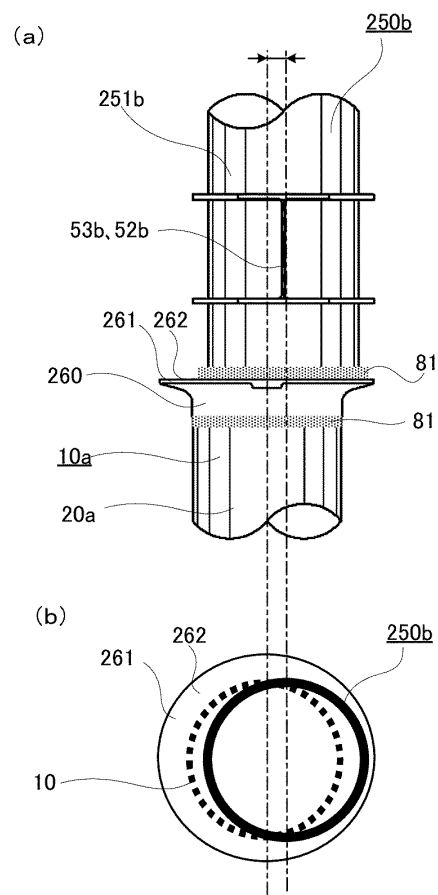
[図28]



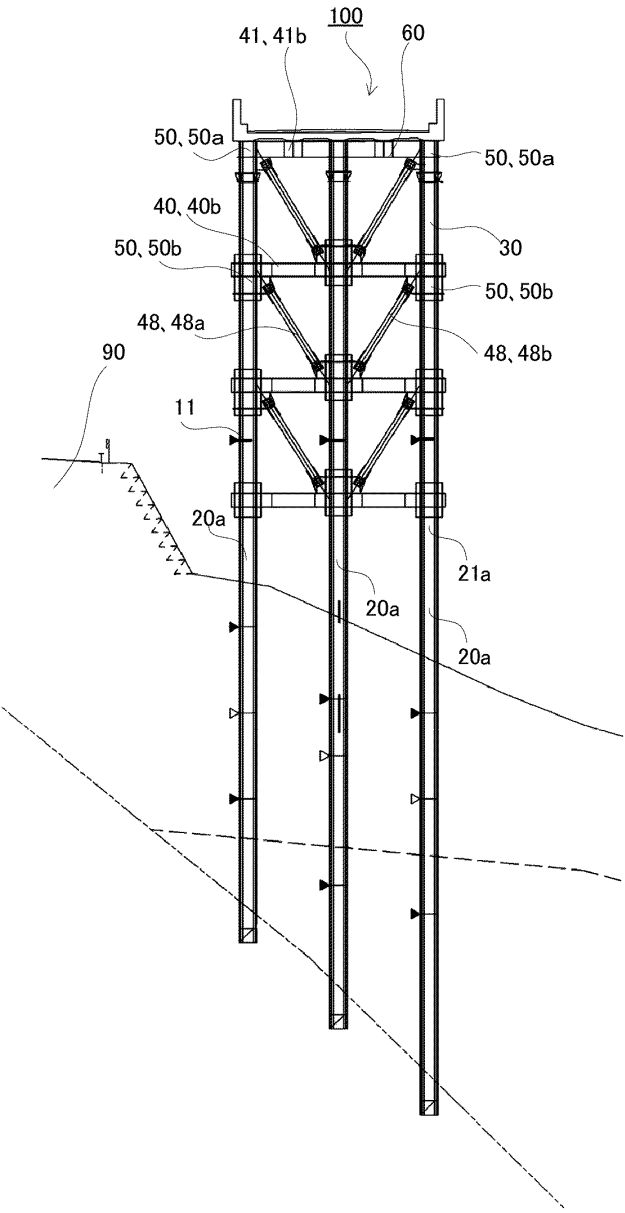
[図29]



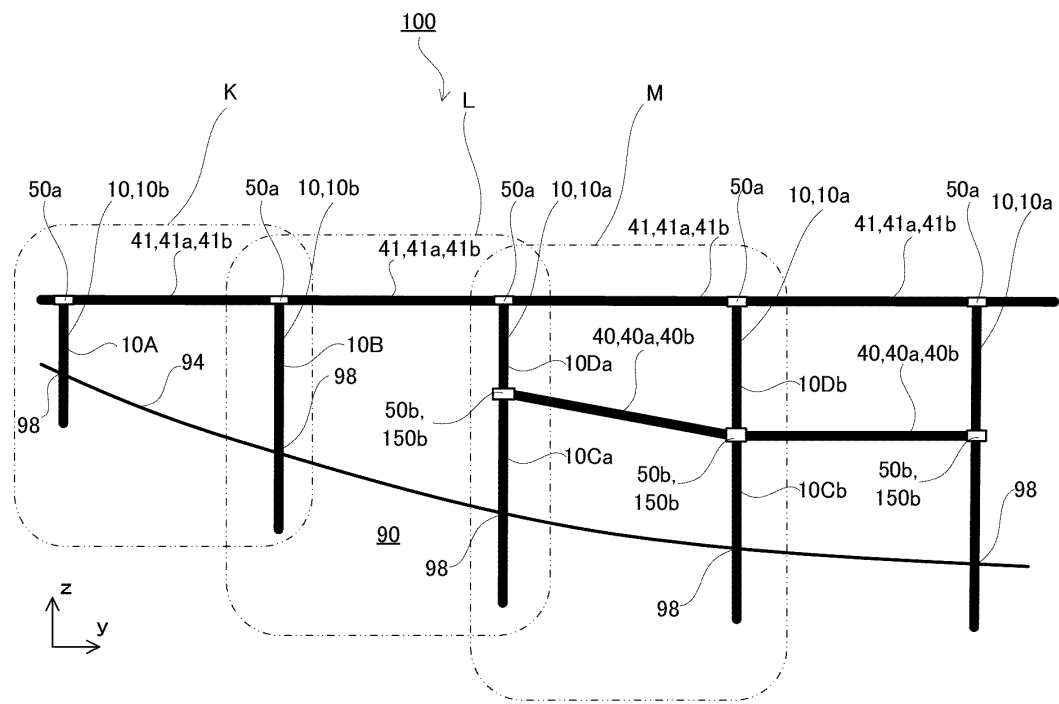
[図30]



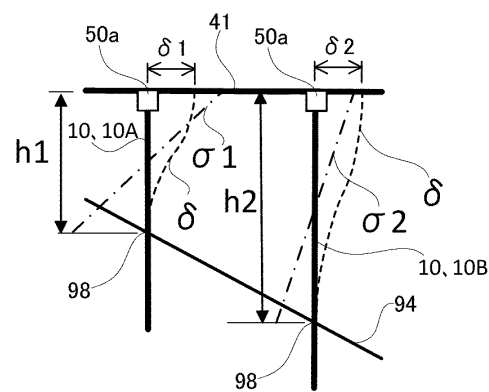
[図31]



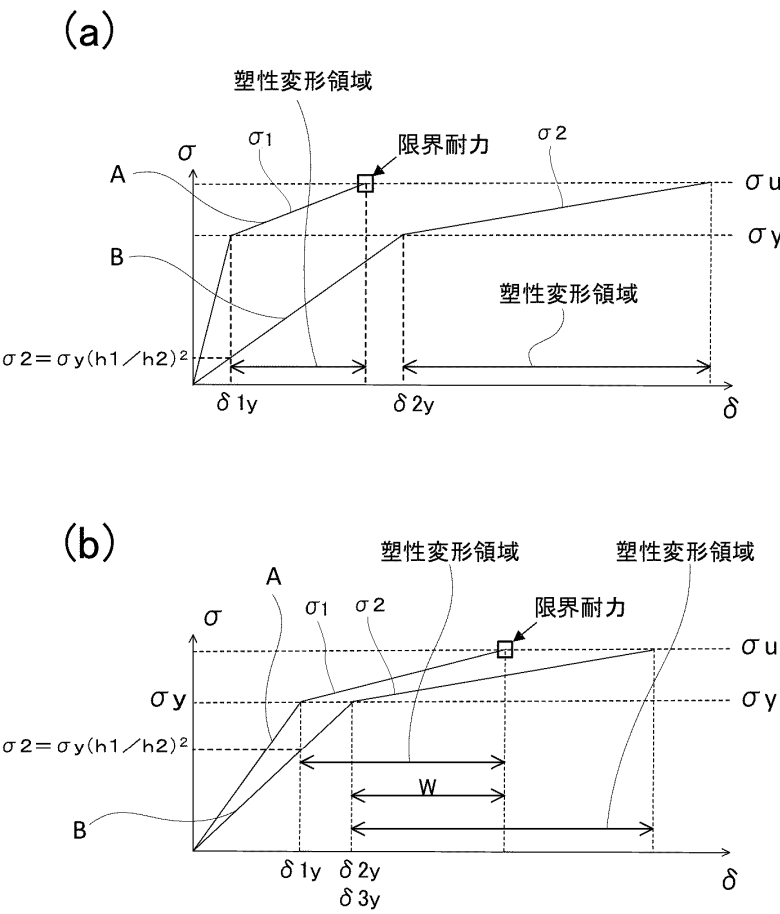
[図32]



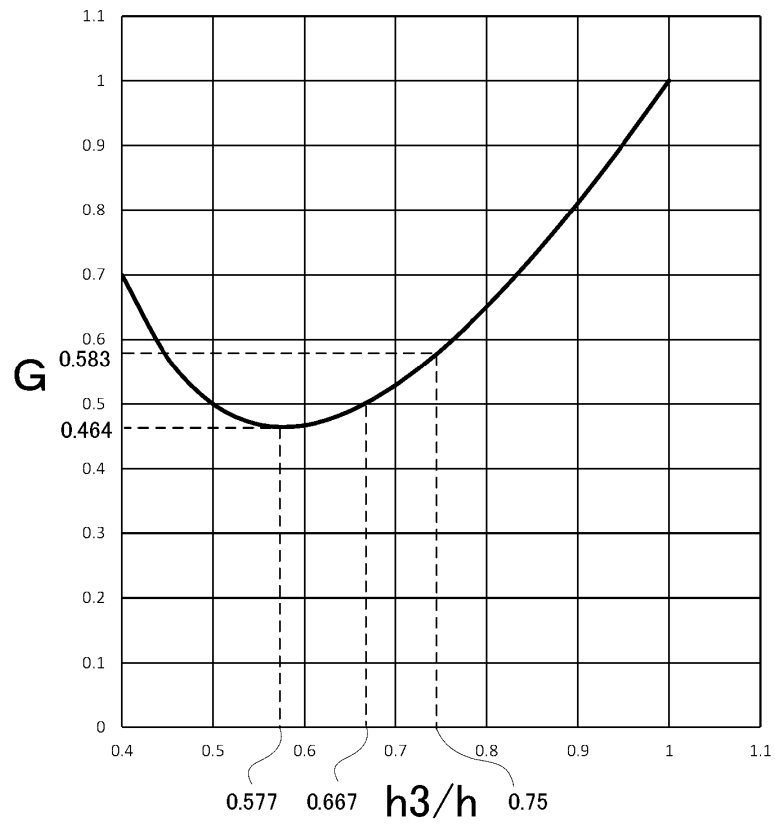
[図33]



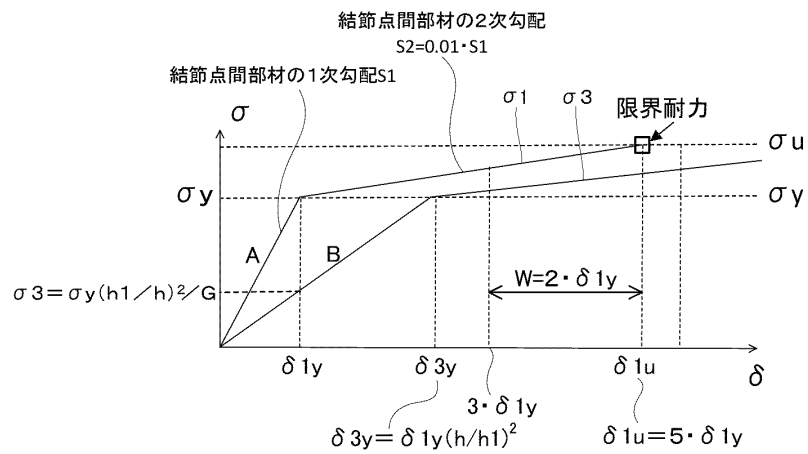
[図37]



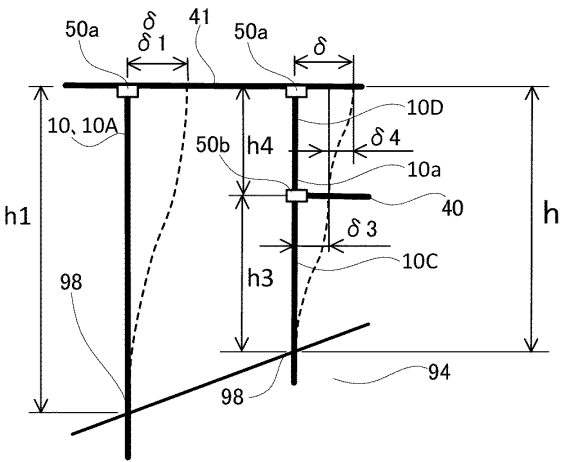
[図38]



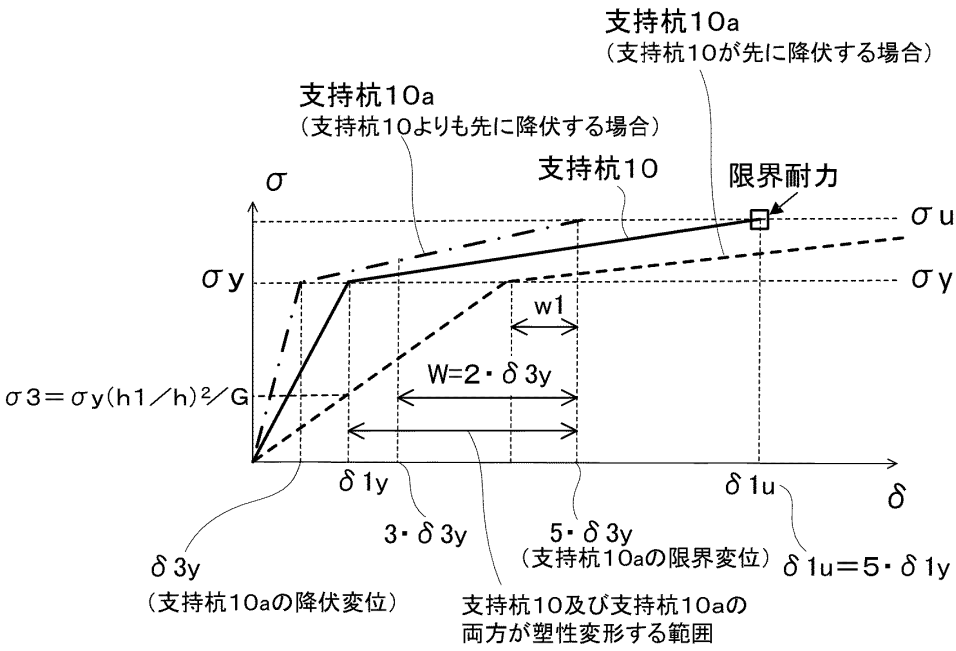
[図39]



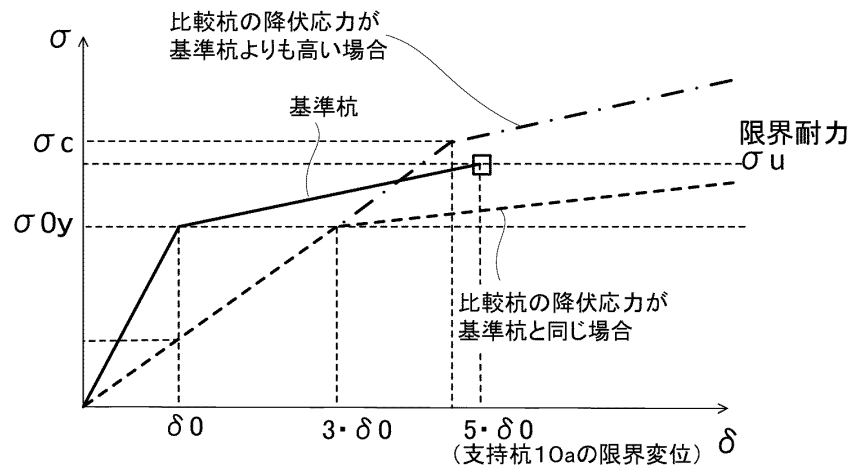
[図40]



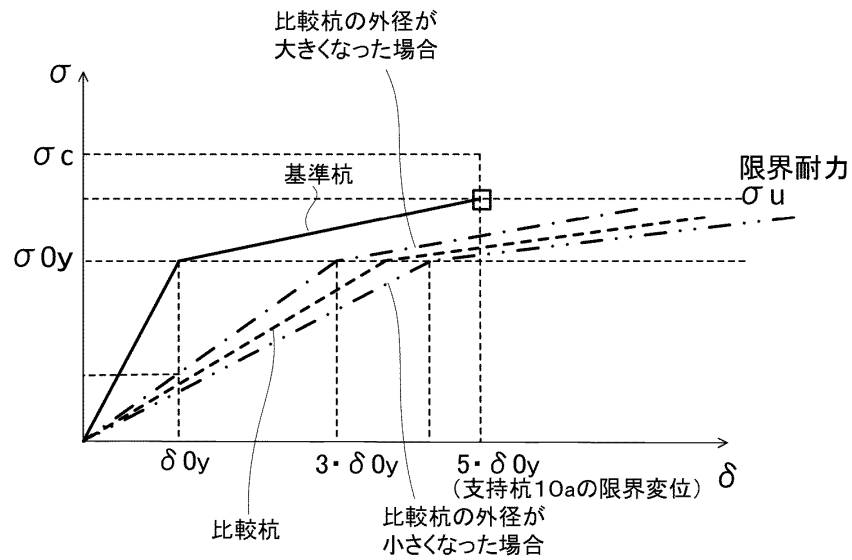
[図41]



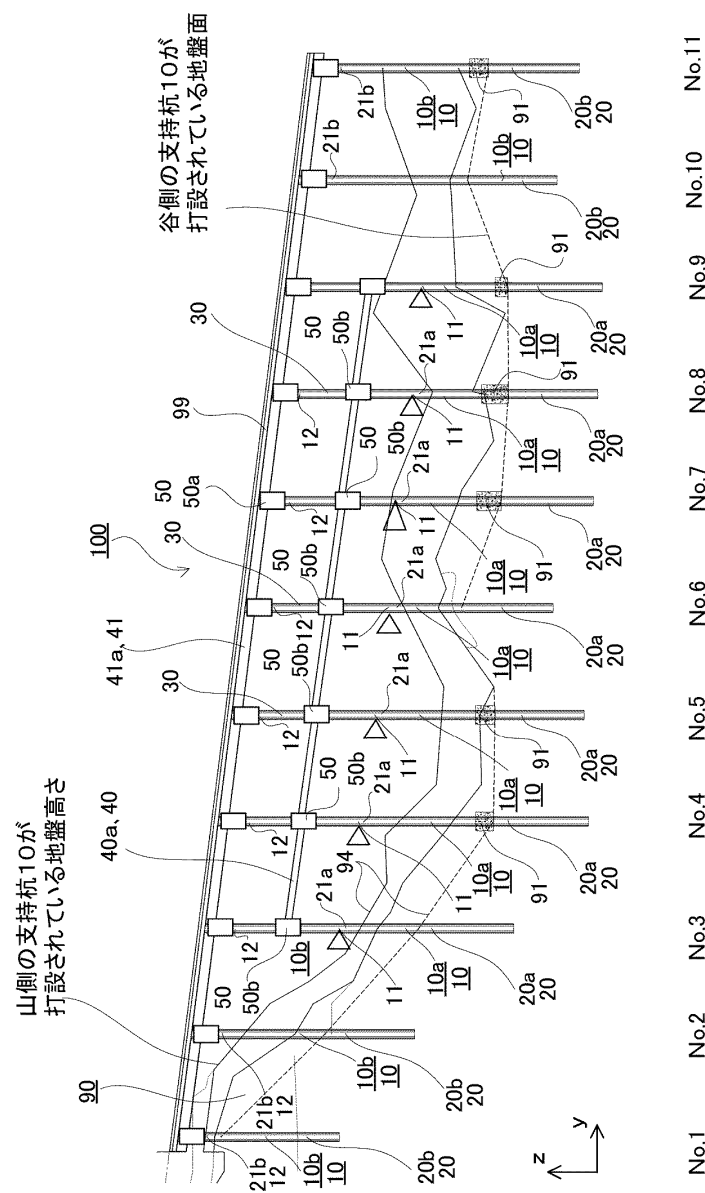
[図42]



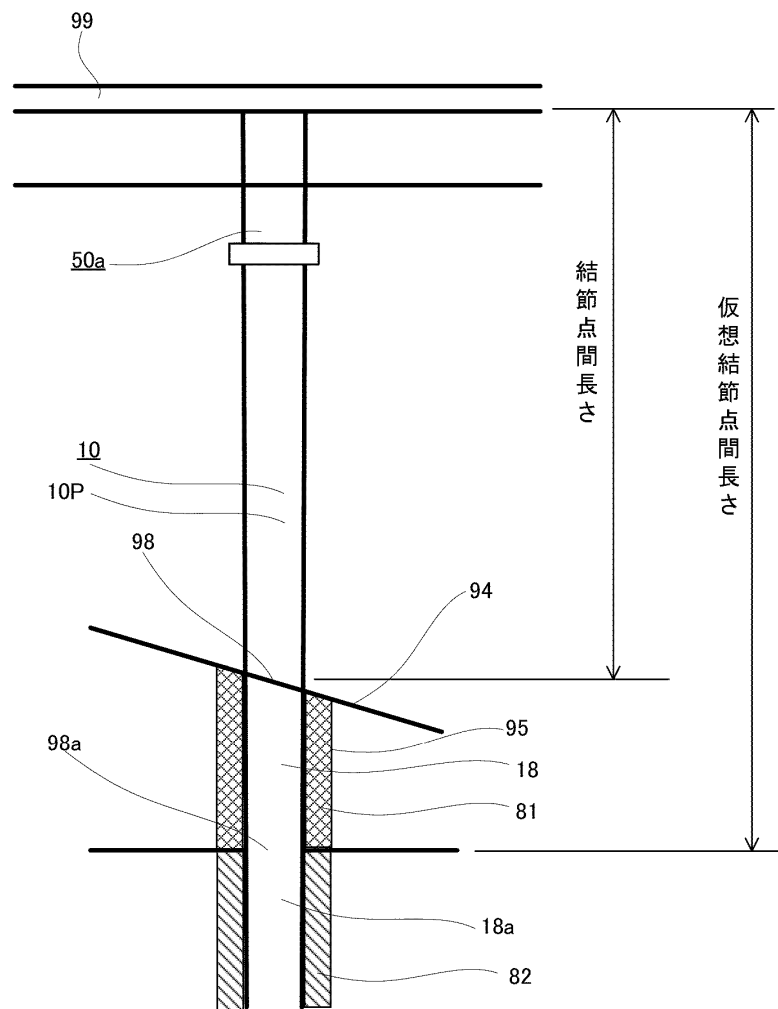
[図43]



[図44]



[図45]



[図47]

