FIG. 1

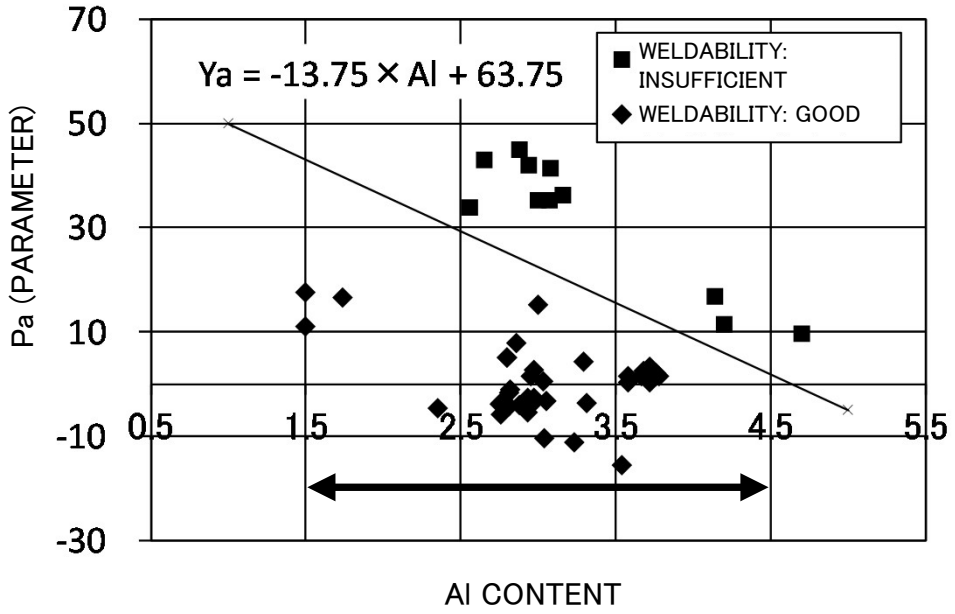
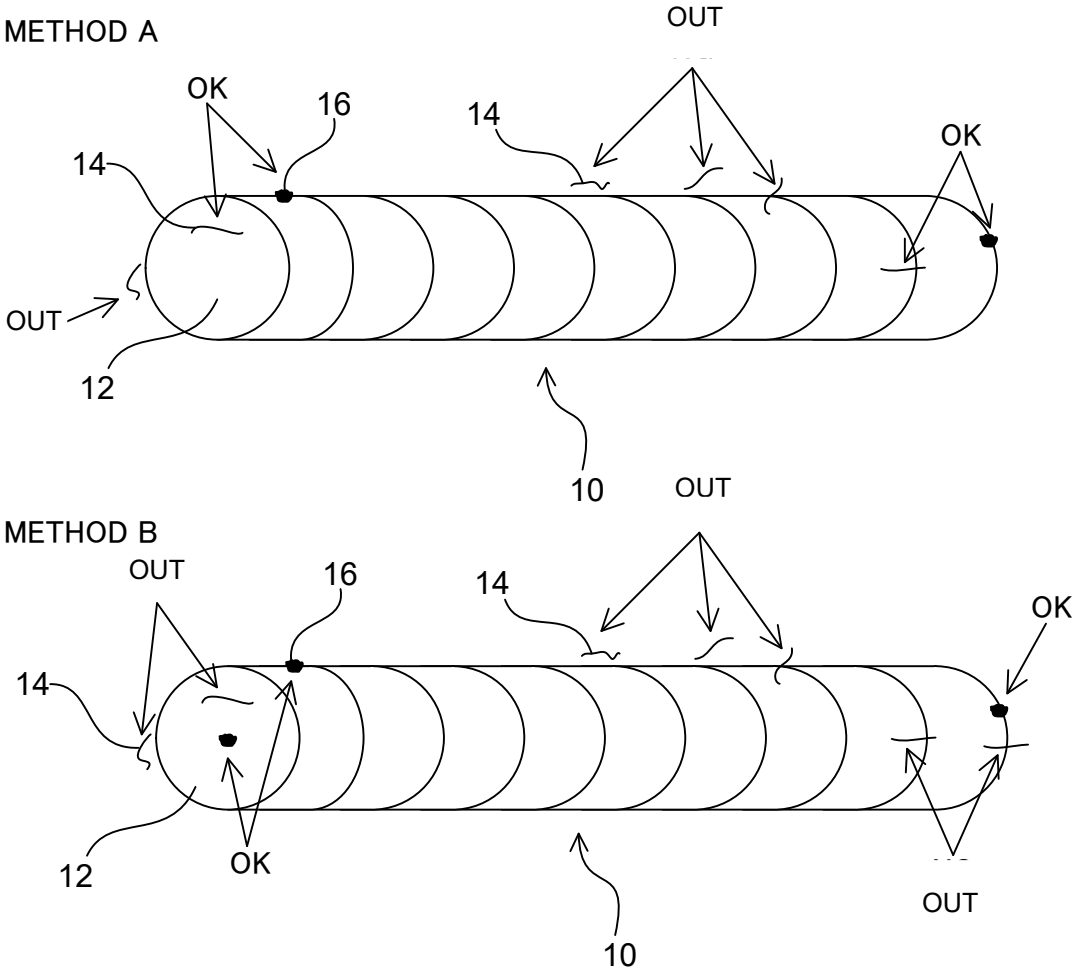

70
50
30
10
-10
-30
Pa (PARAMETER)
Ya = -13.75 × Al + 63.75
WELDABILITY: INSUFFICIENT
WELDABILITY: GOOD
0.5
1.5
2.5
3.5
4.5
5.5
Al CONTENT

FIG. 2


METHOD A
OUT
OK
16
14
14
OK
OUT
12
10
METHOD B
OUT
OUT
16
14
OK
14
12
OK
OUT
10