

ABSTRACT OF THE DISCLOSURE
ARC STARTING METHOD OF MULTIPLE-ELECTRODE ONE-SIDE
WELDING EQUIPMENT AND THE MULTIPLE-ELECTRODE ONE-SIDE
WELDING EQUIPMENT

An arc starting method of multiple-electrode one-side welding equipment includes a first process of setting an arc generation auxiliary material at a first electrode; a second process of causing the first electrode to generate an arc and causing a welding carriage to move immediately thereafter; a third process of causing a second electrode to generate an arc at a molten pool, and controlling feeding of a wire serving as the second electrode in three stages including a first stage in which the wire is fed at a slowdown speed, a second stage in which the feeding of the wire is stopped, and a third stage in which the wire is fed at an ordinary speed varying in accordance with a variation of a voltage value of the wire; and a fourth process of causing a third electrode and following electrodes to generate arcs at molten pools, and controlling feeding of wires serving as the third electrode and the following electrodes in the three stages including the first to third stages. By such a method, the arc starting is automated, and the amount of arc generation auxiliary material used is reduced.

(FIG. 1)