**TIG 19/12/3 NCSi**

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| **Druh:** | Drát - TIG |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | ASME |  | ER 316 L Si |
|   | AWS | A 5.9 | ER 316 L Si |
|   | DIN | 8556 | SG X 2 CNiMo 19 12 |
|   | ISO |  | 19 12 3 LC Si |
|   | W.Nr. |  | 1.4430 |

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| **Fyzikální hodnoty:** |   |

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|   | Ochranná atmosféra | Ar |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\TIG 19-12-3 NCSi_1.bmp |

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| **Použití pro:** |   |

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|   | Žáropevné |
|   | Vysokolegované |

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| **Typické chemické složení v %:** |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | < 0.025 | Si | 0.70 | Mn | 1.75 | Cr | 19.0 | Ni | 11.5 |   |
|   | Mo | 2.75 |   |  |  |  |  |  |  |  |  |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | -110 | 20 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] |   | 550 - 650 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] |   | > 320 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] |   | > 30 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | KV | [J] | > 32 | > 80 |   |   |   |   |   |
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| **Rozměry a balení:** |

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|   | Průměr [mm] | Délka [mm] | Balení | Hmotn. balení [kg] | [ks] v balení | Hmotn. 1 kusu [g] | Hmotn. 1000 ks [kq] | Krabiček /kartón [ks] | Hmotn. kartónu [kg] |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 1.60 | 1000 | svazek | 25.00 |   |   |   |   |   |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.00 | 1000 | svazek | 25.00 |   |   |   |   |   |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.50 | 1000 | svazek | 25.00 |   |   |   |   |   |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.00 | 1000 | svazek | 25.00 |   |   |   |   |   |   |  |
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| **Použití:** |

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|   | Austenitický drát pro svařování v inertním plynu. Vhodný pro svařování 18/8 Cr ocelí odolných korozi, pro zařízení a součástky v chemickém, papírenském a farmaceutickém průmyslu pro teploty do 350 °C. Svarový kov odolává oxidaci do 800 °C a je houževnatý do - 196 °C. Ochranná atmosféra: Ar (I1 odpovídající EN 439) Svařovací dráty jsou baleny v papírových kartonech po 25 kg. |
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