**MIG 19/9 NCSi**

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| **Druh:** | Drát - MIG/MAG |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | ASME |  | ER 308 L Si |
|   | AWS | A 5.9 | ER 308 L Si |
|   | DIN | 8556 | SG X 2 CrNi 19 9 |
|   | EN | 12072 | G 19 9 LSi |
|   | ISO |  | 19 9 L Si |
|   | W.Nr. |  | 1.4316 |

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| **Certifikace/klasifikace:** |
|   | DB |  |
|   | TUV |  |

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| **Fyzikální hodnoty:** |   |

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|   | Ochranná atmosféra | Ar+O2, Ar+CO2 |
|   | Svařovací proud | C:\Documents and Settings\Admin\Dokumenty\MIG19-9NCSi_1.bmp |

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| **Použití pro:** |   |

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| --- | --- |
|   | Žáropevné |
|   | Vysokolegované |

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| **Typické chemické složení v %:** |

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | < 0.025 | Si | 0.70 | Mn | 2.00 | Cr | 19.0 | Ni | 9.00 |   |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | -196 | 20 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] |   | 550 - 650 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] |   | > 320 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] |   | > 30 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | KV | [J] | > 32 | > 80 |   |   |   |   |   |
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| **Rozměry a balení:** |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
|   | Průměr [mm] | Balení | Typ | Hmotn. balení [kg] | Objednací číslo |   \*)  |
|  |  |  |  |  |  |  |
|   | 0.80 | cívka |   | 15 |   | A |
|  |  |  |  |  |  |  |
|   | 0.90 | cívka |   | 15 |   | C |
|  |  |  |  |  |  |  |
|   | 1.00 | cívka |   | 15 |   | A |
|  |  |  |  |  |  |  |
|   | 1.20 | cívka |   | 15 |   | A |
|  |  |  |  |  |  |  |
|   | 1.60 | cívka |   | 15 |   | C |
|  |  |  |  |  |  |  |

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| **Použití:** |

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|   | Austenitický drát pro svařování v inertní atmosféře. Vhodný pro svařování ocelí odolných korozi 18/8 CrNi a pro zařízení a součástky v chemickém, papírenském a farmaceutickém průmyslu do teploty 350 °C. Svarový kov odolává oxidaci do 800 °C a je houževnatý do |
|   | - 196 °C. Svařovací drát je namotán na železných nebo plastových cívkách a odpovídá AWS A5.18 a DIN 8559.Ochranná atmosféra: Ar+1-3% O2, Ar+2.5% CO2, (M11, M12 odpovídající EN 439) |
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| **Poznámka výrobce:** |

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|   | Drát MIG 19/9 NCSi je v průměrech 0.80 a 1.00 mm nabízen také  |
|   | na 5 kg cívkách. |

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