**E Mn 17 Cr 13**

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| **Druh:** | Elektroda |
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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\E Mn 17 Cr 13_1.bmp |

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| **Fyzikální hodnoty:** |   |

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|   | Tvrdost (1.vrstva) | 220 HB, 48 HRC (vytvrzeno za studena |
|   | Obal/náplň | rutilový |
|   | Výtěžnost [%] | 140 |
|   | Teplota sušení | 300/2h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\E Mn 17 Cr 13_2.bmp |

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| **Použití pro:** |   |

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|   | Žáropevné |
|   | Vysokolegované |
|   | Opravy a renovace |

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| **Typické chemické složení v %:** |

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|   | C | 0.60 | Mn | 16.50 | Cr | 13.50 |   |

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| **Typické mechanické hodnoty:** |

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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] |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 450 | pouzdro | 5.40 | 84 |   | 64.1 | 5 | 27 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 450 | pouzdro | 5.40 | 56 |   | 96.2 | 5 | 27 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 450 | pouzdro | 5.40 | 40 |   | 135.1 | 5 | 27 |   |  |
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| **Použití:** |

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|   | Elektroda pro svařování a navařování součástí odolných těžkým rázům a kavitaci do 500 °C. Dále je vhodná jako mezivrstva pod návary elektrod typu Abradur 54, 58, 64, 65 a 66. Elektroda je vhodná pro navařování kolejnic, vyhýbek, navařování pístů čerpadel sacích |
|   | bagrů, drtících zařízení s velkými rázy. Svarový kov lze obrábět před kalením. Tvrdost návaru závisí na podmínkách svařování a chemickém složení základního materiálu. Koeficient opotřebení: 70% |
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