**TIG VAC 60**

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| **Druh:** | Drát - TIG |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | ASME |  | ER 70 S 6 |
|   | AWS | SFA A 5.18 | ER 70 S 6 |
|   | DIN | 8559 | SG 2 |
|   | EN | 1668 | WSG 2 |
|   | W.Nr. |  | 1.5125 |

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| **Fyzikální hodnoty:** |   |

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|   | Ochranná atmosféra | Ar |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\TIG VAC 60_1.bmp |

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| **Použití pro:** |   |

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|   | Nízkolegované |

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| **Typické chemické složení v %:** |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | 0.08 | Si | 0.90 | Mn | 1.50 | P | < 0.025 | S | < 0.025 |   |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | -40 | 20 |   |   |   |   |   |
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|   | Rm | [MPa] |   | 540-640 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] |   | > 410 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] |   | > 22 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | KV | [J] | > 47 |   |   |   |   |   |   |
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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 |   |   |   |   |   |   |  |
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|   | 2.00 | 1000 | svazek | 25.00 |   |   |   |   |   |   |  |
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|   | 2.50 | 1000 | svazek | 25.00 |   |   |   |   |   |   |  |
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|   | 3.00 | 1000 | svazek | 25.00 |   |   |   |   |   |   |  |
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| **Použití:** |

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|   | Poměděný TIG-drát pro svařování v ochranné atmosféře. Vhodný pro svařování nelegovaných ocelí s mezí pevnosti pod 530 N/mm2, jako kotlové plechy, jemnozrnné oceli, trubkové oceli, |
|   | lodní plechy a oceli na odlitky. Ochranná atmosféra: Ar(I1 odpovídající EN 439) Svařovací dráty jsou baleny v papírových kartonech po 25 kg. |
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