**TIG CrMo**

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| --- | --- |
| **Druh:** | Drát - TIG |
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| --- | --- | --- | --- |
| **Normy:** | | | |
|  | Norma | Číslo | Označení |
|  | ASME |  | ER 80S B2 |
|  | AWS | A 5.28 | ER 80S B2 |
|  | DIN | 8575 | SG CrMo 1 |
|  | EN | 12070 | W CrMo 1 Si |

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| --- | --- | --- |
| **Certifikace/klasifikace:** | | |
|  | BV |  |
|  | CR |  |
|  | DnV |  |
|  | RS |  |
|  | TUV |  |

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| --- | --- |
| **Fyzikální hodnoty:** |  |

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| --- | --- | --- |
|  | Ochranná atmosféra | Ar |
|  | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\TIG CrMo_1.bmp |

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| **Použití pro:** |  |

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| --- | --- |
|  | Nízkolegované |
|  | Žáropevné |

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| --- |
| **Typické chemické složení v %:** |

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | C | 0.09 - 0.13 | Si | 0.50 - 0.70 | Mn | 0.90 - 1.10 | Cr | 1.00 - 1.20 | Mo | 0.40 - 0.60 |  |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | |  | | --- | |  |  |  | | --- | |  |  |  | | --- | | **Typické mechanické hodnoty:** |  |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |  | Teplota | [°C] | 20 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rm | [MPa] | 570 - 665 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rp02 | [MPa] | < 490 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | A5 | [%] | > 22 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | KV | [J] | > 65 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **Rozměry a balení:** |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |  | 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] |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | |  | 2.00 | 1000 | svazek | 25.00 |  |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | |  | 2.50 | 1000 | svazek | 25.00 |  |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | |  | 3.00 | 1000 | svazek | 25.00 |  |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **Tepelné zpracování:** |  |  |  |  | | --- | --- | --- | |  | Žíhání | 720 °C/30 min | |  | Chládnutí | do 300 °C/pec/ vzduch |  |  | | --- | | **Použití:** |  |  |  | | --- | --- | |  | Drát legovaný Cr a Mo pro TIG svařování žárupevných, nelegovaných a nízkolegovaných konstrukčních ocelí do pracovní teploty 500 °C. Vhodný pro svařování potrubních vedení, vysokotlakých kotlů, pancerů a pro opravy tepelných energetických zařízení. Drát je možné použít na zařízení do teploty 550 °C. Svařovací dráty jsou baleny v papírových kartonech po 25 kg. | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  |  |  | | --- | --- | --- | |  |  |  | |  |  |  | |  |  |  | |  |  |  | |