**MIG 19/9 NCSi**

|  |  |
| --- | --- |
| **Druh:** | Drát - MIG/MAG |
|  |  |

|  |  |  |  |
| --- | --- | --- | --- |
| **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 |

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

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

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

|  |  |
| --- | --- |
| **Použití pro:** |  |

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

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

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

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | |  | | --- | |  |  |  | | --- | |  |  |  | | --- | | **Typické mechanické hodnoty:** |  |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |  | Teplota | [°C] | -196 | 20 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rm | [MPa] |  | 550 - 650 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rp02 | [MPa] |  | > 320 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | A5 | [%] |  | > 30 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | KV | [J] | > 32 | > 80 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **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 | |  |  |  |  |  |  |  |  |  | | --- | | **Použití:** |  |  |  | | --- | --- | |  | 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) | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  |  |  | | --- | | **Poznámka výrobce:** |  |  |  | | --- | --- | |  | Drát MIG 19/9 NCSi je v průměrech 0.80 a 1.00 mm nabízen také | |  | na 5 kg cívkách. | | |