**INOX R 29/9**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | AWS | A 5.4 | E 312 17 |
|   | DIN | 8556 | E 29 9 R 26 |
|   | EN | 1600 | E 29 9 R 12 |
|   | ISO | 3581 | E 29.9 R 26 |
|   | JUS | C.H3.011 | E 29 9 R 26 |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX R 29 9_1.bmp |

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| **Fyzikální hodnoty:** |   |

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| --- | --- | --- |
|   | Tvrdost (1.vrstva) | 245 HV |
|   | Obal/náplň | rutilový |
|   | Teplota sušení | 300 °C/2h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX R 29 9_2.bmp |

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| **Použití pro:** |   |

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|   | Vysokolegované |

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| **Typické chemické složení v %:** |

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | 0.15 | Si | < 0.90 | Mn | 1.20 | Cr | 29.0 | Ni | 9.00 |   |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | 20 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] | 740 - 840 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] | > 500 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] | > 20 |   |   |   |   |   |   |
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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] |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.00 | 250 | pouzdro | 4.00 |   |   |   | 4 | 16 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.50 | 300 | pouzdro | 4.00 | 244 |   | 16.4 | 4 | 16 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 4.50 | 137 |   | 32.8 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 350 | pouzdro | 4.50 | 92 |   | 48.9 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 350 | pouzdro | 4.50 | 62 |   | 72.3 | 4 | 18 |   |  |
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| **Tepelné zpracování:** |

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|   | Předehřev | závisí na základním materiálu |

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| **Použití:** |

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|   | Rutilová austeniticko-feritická elektroda pro svařování obtížně svařitelných ocelí. Vhodná jako mezivrstva pod tvrdonávary, navařování ozubených kol a vřeten při zachování vysoké meze pevnosti a tvrdosti povrchu. Svarový kov má vynikající odolnosti proti kavitaci a vzniku trhlin. Tvrdost návaru závisí na podmínkách svařování a chemickém složení základního materiálu. |
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