**INOX B 18/8/6**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | AWS | A 5.4 | E 307 15 |
|   | DIN | 8556 | E 18 8 Mn B 20+ |
|   | EN | 1600 | E 18 8 Mn B 22 |
|   | ISO | 3581 | E 18 8 Mn B 20+ |
|   | JUS | C.H3.017 | E 18 8 Mn B 20+ |

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| **Certifikace/klasifikace:** |
|   | SŽ |  |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX B 18 8 6_1.bmp |

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| **Fyzikální hodnoty:** |  |

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| --- | --- | --- |
|   | Obal/náplň | bázický |
|   | Teplota sušení | 300 °C/2h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX B 18 8 6_2.bmp |

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| **Použití pro:** |   |

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|   | Žáropevné |
|   | Vysokolegované |

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| **Typické chemické složení v %:** |

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | 0.12 | Si | 0.80 | Mn | 7.00 | Cr | 19.0 | Ni | 9.00 |   |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | 20 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] | 590 - 690 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] | > 350 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] | > 40 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | KV | [J] | > 80 |   |   |   |   |   |   |
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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 | 3.50 |   |   |   | 4 | 14 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.50 | 300 | pouzdro | 3.50 | 223 |   | 15.7 | 4 | 14 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 4.50 | 154 |   | 29.3 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 450 | pouzdro | 4.50 | 35 |   | 43.3 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 450 | pouzdro | 6.00 | 87 |   | 68.7 | 5 | 30 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |

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| **Použití:** |

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|   | Bazická austenitická elektroda pro svařování nízko a vysokolegovaných ocelí. Svar je odolný tvorbě okují do 800 °C a nízkým teplotám do -100 °C. Předehřev a tepelné zpracování je doporučeno, závisí na základním materiálu. |
|   |  |
|   | Způsobilost: SZ |
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