**INOX B 18/8/6**

|  |  |
| --- | --- |
| **Druh:** | Elektroda |
|  |  |

|  |  |  |  |
| --- | --- | --- | --- |
| **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+ |

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

|  |
| --- |
|  |

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

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

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

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

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

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

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

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | |  | | --- | |  |  |  | | --- | |  |  |  | | --- | | **Typické mechanické hodnoty:** |  |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |  | Teplota | [°C] | 20 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rm | [MPa] | 590 - 690 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rp02 | [MPa] | > 350 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | A5 | [%] | > 40 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | KV | [J] | > 80 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **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 | 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 |  |  | |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **Použití:** |  |  |  | | --- | --- | |  | 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 | |  |  | |  |  | |  |  | |  |  |  |  | | --- | --- | --- | |  |  |  | |  |  |  | |  |  |  | |  |  |  | |