**INOX B 70/15**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | AWS | A 5.11 | E NiCrFe 3 |
|   | DIN | 1736 | EL NiCr 15 FeMn |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX B 70 15_1.bmp |

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| **Fyzikální hodnoty:** |   |

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| --- | --- | --- |
|   | Tvrdost (1.vrstva) | 178-220 HV |
|   | Obal/náplň | bázický |
|   | Teplota sušení | 250-300 °C/2h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX B 70 15_2.bmp |

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| **Použití pro:** |   |

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|   | Žáropevné |
|   | Vysokolegované |
|   | Ni slitiny |

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| **Typické chemické složení v %:** |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | 0.06 | Si | 0.50 | Mn | 6.50 | Cr | 15.0 | Ni | Zb. |   |
|   | Mo | 1.50 | Fe | 7.00 | Nb | 2.00 |   |  |  |  |  |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | -196 | 20 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] |   | 620 - 720 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] |   | > 390 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] |   | > 30 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | KV | [J] | > 60 |   |   |   |   |   |   |
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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] |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.50 | 300 | pouzdro | 3.50 | 153 |   | 22.9 | 4 | 14 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 4.50 | 104 |   | 43.4 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 350 | pouzdro | 4.50 | 65 |   | 69.8 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 350 | pouzdro | 5.50 | 63 |   | 88 | 4 | 22 |   |  |
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| **Použití:** |

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|   | Speciální bazická obalovaná elektroda s austenitickou strukturou na bázi Ni. Používá se pro svařování v průmyslu s nízkými teplotami a v jaderném strojírenství, pracujících v teplotním rozmezí-196 °C až +600 °C. Elektroda je odolná proti tvorbě okují až do 1200 °C (S-free atmosféra), dále je odolná proti teplotním šokům u plně austenitických ocelí, vysoce odolná proti horkým trhlinám a korozi při vysokých teplotách. Tvrdost návaru 178-220 HV. Doporučen předehřev v závislosti na základním materiálu, mezihousenková teplota 125-150 °C. |
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