**ABRADUR 66**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | DIN | 8555 | E 10 UM 65 GR |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\ABRADUR 66_1.bmp |

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| **Fyzikální hodnoty:** |   |

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|   | Tvrdost (1.vrstva) | 50 HRC při 600 °C |
|   | Obal/náplň | bázický |
|   | Výtěžnost [%] | 235 |
|   | Teplota sušení | 300/2h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\ABRADUR 66_2.bmp |

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| **Použití pro:** |   |

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|   | Žáropevné |
|   | Vysokolegované |
|   | Opravy a renovace |

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| **Typické chemické složení v %:** |

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | 6.00 | Cr | 22.00 | Mo | 6.00 | Nb | 6.00 | V | 1.00 |   |
|   | W | 2.00 |   |  |  |  |  |  |  |  |  |

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| **Typické mechanické hodnoty:** |

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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] |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 4.00 | 61 |   | 65.8 | 5 | 20 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 350 | pouzdro | 5.40 |   |   |   | 5 | 26 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 450 | pouzdro | 5.40 | 42 |   | 128 | 5 | 26 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 450 | pouzdro | 5.40 | 27 |   | 200 | 5 | 26 |   |  |
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| **Tepelné zpracování:** |

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|   | Předehřev | není vyžadován |

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| **Použití:** |

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|   | Elektroda vytvaří extrémně tvrdý návar odolný opakovanému opotřebení se středními rázy do teploty 600°C. Elektroda je vhodná na stroje přemísťující zeminu, na součástky v cementárnách a cihelnách, roštnice u topenišť, žlaby a zvonové uzávěry pro zavážení vysokých pecí. Doporučená podkladová vrstva s Inox 18/8/6 nebo E Mn17Cr13. Navařený kov lze obrábět broušením. |
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