**MONEL**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | AWS | A 5.15 | E E NiCu B |
|   | DIN | 8573 | E NiCu G 3 |
|   | ISO | 1071 | E NiCu 2 BG 2 |
|   | JUS | C.H3.061 | E NiCu 2 BG 2 |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\MONEL_1.bmp |

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| **Fyzikální hodnoty:** |   |

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|   | Tvrdost (1.vrstva) | 165 HV |
|   | Teplota sušení | 200 °C/1h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\MONEL_2.bmp |

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| **Použití pro:** |   |

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|   | Vysokolegované |
|   | Šedá litina |
|   | Ni slitiny |

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| **Typické chemické složení v %:** |

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|   | Ni | 70.0 | Cu | 30.0 |   |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | 20 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] | 300 |   |   |   |   |   |   |
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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 | 5.00 | 307 |   | 16.3 | 4 | 20 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 6.00 | 186 |   | 32.2 | 4 | 24 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 350 | pouzdro | 6.00 | 124 |   | 48.4 | 4 | 24 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 350 | pouzdro | 6.00 | 62 |   | 96.8 | 4 | 24 |   |  |
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| **Použití:** |

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|   | Elektroda s monel-jádrem je vhodná pro svařování šedé litiny a dalších druhů litin za studena. |
|   | To je vhodné zejména pro opravy součástek. Při použití malých průměrů elektrod by měl být malý podíl vneseného tepla do svařence. Svarový kov je lehce obrobitelný. Je doporučen mírný předehřev pro součástky se silnější stěnou.

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