**CAST NiFe**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | AWS | A 5.15 | E NiFe Cl |
|   | DIN | 8573 | E NiFe BG 1 |
|   | ISO | 1071 | E NiFe BG 2 |
|   | JUS | C.H3.016 | E NiFe BG 2 |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\CAST NiFe_1.bmp |

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| **Fyzikální hodnoty:** |   |

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|   | Tvrdost (1.vrstva) | 230 HV |
|   | Teplota sušení | 220/1h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\CAST NiFe_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 | 53.00 | Fe | 43.00 |   |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | 20 |   |   |   |   |   |   |
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|   | Rm | [MPa] | 450 |   |   |   |   |   |   |
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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 | 312 |   | 16 | 4 | 20 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 6.00 | 187 |   | 32 | 4 | 24 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 350 | pouzdro | 6.00 | 128 |   | 47 | 4 | 24 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 350 | pouzdro |   |   |   |   |   |   |   |  |
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| **Použití:** |

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|   | Elektroda na bázi Ni-Fe pro svařování šedé litiny, tvárné litiny a temperované litiny, také je vhodná pro opravy odlitku z těchto litin a pro spojování výše uvedených litin s ocelí. Mez pevnosti v tahu je vyšší než u meze pevnosti Ni - elektrod. Svařování je vhodnější po očkované litiny. Při použití malých průměrů elektrod je malý tepelný příkon do svařence. Svarový kov je silnější a více odolný nečistotám než Ni-trubička. Pro silnější součástky je doporučen předehřev. |
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