**SUPER Ni**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | AWS | A 5.15 | E Ni Cl |
|   | DIN | 8573 | E Ni BG 1 |
|   | ISO | 1071 | E Ni BG 2 |
|   | JUS | C.H3.061 | E Ni BG 2 |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\SUPER Ni_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\SUPER Ni_2.bmp |

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| **Použití pro:** |   |

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| --- | --- |
|   | Vysokolegované |
|   | Šedá litina |

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| **Typické chemické složení v %:** |

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| --- | --- | --- | --- |
|   | Ni | 98.0 |   |

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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] | Objednací číslo |   \*)  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.50 | 300 | pouzdro | 5.00 | 312 |   | 16 | 4 | 20 |   | B |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 6.00 | 186 |   | 32.3 | 4 | 24 |   | B |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 350 | pouzdro | 6.00 | 124 |   | 48.4 | 4 | 24 |   | C |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 350 | pouzdro | 6.00 | 62 |   | 96.8 | 4 | 24 |   | C |
|  |  |  |  |  |  |  |  |  |  |  |  |

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| **Použití:** |

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|   | Elektroda s Ni-drátem pro svařování šedé a temperované litiny a jejich svařování s ocelemi. Vhodná pro opravy zlomených částí, opravy odlitků po obrábění, svařování litiny a opravy po odlévání. Svarový kov je měkký a lehce obrobitelný. Při kování za studena dochazí k odstranění pnutí. Při použití malých průměrů elektrod se sníží množství vneseného tepla do svařence. Základní materiál by měl být čistý. Pro drážkování je vhodná elektroda Secator 2, broušení není doporučeno. Pro silnostěnné součástky doporučen lehký předehřev. |
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