**VAC 60**

|  |  |
| --- | --- |
| **Druh:** | Drát - MIG/MAG |
|  |  |

|  |  |  |  |
| --- | --- | --- | --- |
| **Normy:** | | | |
|  | Norma | Číslo | Označení |
|  | ASME |  | ER 70 S 6 |
|  | AWS | SFA 5.18 | ER 70 S 6 |
|  | DIN | 8559 | SG 2 |
|  | EN | 440 | G3 Si 1 |
|  | W.Nr. |  | 1.5125 |

|  |  |  |
| --- | --- | --- |
| **Certifikace/klasifikace:** | | |
|  | ABS |  |
|  | BV |  |
|  | CWB |  |
|  | CR |  |
|  | DB |  |
|  | DnV |  |
|  | GL |  |
|  | LRS |  |
|  | TUV |  |
|  | UDT |  |

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| --- |
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| --- | --- |
| **Fyzikální hodnoty:** |  |

|  |  |  |
| --- | --- | --- |
|  | Ochranná atmosféra | CO2,Ar+CO2,CO2+Ar+O2 |
|  | Svařovací proud | C:\Documents and Settings\Admin\Dokumenty\vystup_1.bmp |

|  |  |
| --- | --- |
| **Použití pro:** |  |

|  |  |
| --- | --- |
|  | Nelegované |

|  |
| --- |
| **Typické chemické složení v %:** |

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | C | 0.08 | Si | 0.90 | Mn | 1.50 | P | < 0.025 | S | < 0.025 |  |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | |  | | --- | |  |  |  | | --- | |  |  |  | | --- | | **Typické mechanické hodnoty:** |  |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |  | Teplota | [°C] | -40 | 20 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rm | [MPa] |  | 510 - 590 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rp02 | [MPa] |  | 410 - 490 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | A5 | [%] |  | 22 - 30 |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | KV | [J] | > 47 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **Rozměry a balení:** |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | |  | Průměr [mm] | Balení | Typ | Hmotn. balení [kg] |  |  | |  |  |  |  |  |  |  | |  | 0.60 | cívka |  | 15 |  |  | |  |  |  |  |  |  |  | |  | 0.80 | cívka |  | 15 |  |  | |  |  |  |  |  |  |  | |  | 0.90 | cívka |  | 15 |  |  | |  |  |  |  |  |  |  | |  | 1.00 | cívka |  | 15 |  |  | |  |  |  |  |  |  |  | |  | 1.20 | cívka |  | 15 |  |  | |  |  |  |  |  |  |  | |  | 1.60 | cívka |  | 15 |  |  | |  |  |  |  |  |  |  |  |  | | --- | | **Použití:** |  |  |  | | --- | --- | |  | Poměděný drát pro svařování v ochranné atmosféře. Vhodný pro | |  | svařování nelegovaných ocelí s mezí pevnosti pod 530 N/mm2, | |  | jako kotlové plechy, jemnozrnné oceli, trubkové oceli, lodní plechy | |  | a oceli na odlitky. Svařovací drát je namotán na železných nebo | |  | plastových cívkách odpovídající AWS A5.18 a DIN 8559. | |  | Ochranná atmosféra: 100% CO2, Ar+18% CO2, CO2+Ar+02, C1, | |  | (M21, M22-M33 odpovídající EN 439) | |  | Způsobilost: SZ |  |  | | --- | | **Poznámka výrobce:** |  |  |  | | --- | --- | |  | Drát VAC 60 je v průměrech 0.60, 0.80 a 1.00 mm nabízen také na | |  | 5 kg cívkách. | |  |  |  |  | | --- | --- | --- | |  |  |  | |  |  |  | |  |  |  | |  |  |  | |