**VAC 60**

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| **Druh:** | Drát - MIG/MAG |
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| **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 |

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

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| **Fyzikální hodnoty:** |  |

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

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| **Použití pro:** |   |

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| --- | --- |
|   | Nelegované |

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| **Typické chemické složení v %:** |

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

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | -40 | 20 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] |   | 510 - 590 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] |   | 410 - 490 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] |   | 22 - 30 |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | KV | [J] | > 47 |   |   |   |   |   |   |
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| **Rozměry a balení:** |

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

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|   | 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 |

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| **Poznámka výrobce:** |

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|   | Drát VAC 60 je v průměrech 0.60, 0.80 a 1.00 mm nabízen také na  |
|   | 5 kg cívkách. |

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