**ABRADUR 54**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | DIN | 8555 | E 6 UM 55 G |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\ABRADUR 54_1.bmp |

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| **Fyzikální hodnoty:** |   |

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|   | Tvrdost (1.vrstva) | 54 HRC |
|   | Obal/náplň | bázický |
|   | Výtěžnost [%] | 110 |
|   | Teplota sušení | 300/2h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\ABRADUR 54_2.bmp |

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| **Použití pro:** |   |

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|   | Vysokolegované |
|   | Opravy a renovace |

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| **Typické chemické složení v %:** |

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|   | C | 3.60 | Si | 2.00 | Cr | 9.50 |   |

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| **Typické mechanické hodnoty:** |

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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] |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 4.00 | 99 |   | 40.3 | 5 | 20 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 450 | pouzdro | 5.40 | 70 |   | 77 | 5 | 27 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 450 | pouzdro | 5.00 | 42 |   | 119 | 5 | 25 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 6.00 | 450 | pouzdro |   |   |   |   |   |   |   |  |
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| **Tepelné zpracování:** |

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|   | Předehřev | není vyžadován |

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| **Použití:** |

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|   | Basická elektroda tvořící tvrdou vrstvu s vynikající odolností proti abrazi a vysokému tlakovému namáhání, těžkým rázům a proti opotřebení kov na kov. Elektroda je vhodná pro drtící kladiva, míchací stroje, drtiče, části bagru, ozubená kola, hrany pluhu a shrnovačů. Svarový kov je špatně obrobitelný. Při teplotě 500 °C je tvrdost 300 HB. |
|   | Koeficient opotřebení: 70 %.  |
|   | Tvrdost vrstvy závisí na podmínkách navařování a chemickém složení základního materiálu. |
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