**ABRADUR 54**

|  |  |
| --- | --- |
| **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 |

|  |  |
| --- | --- |
| **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 |

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

|  |  |
| --- | --- |
|  | Vysokolegované |
|  | Opravy a renovace |

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

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

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| |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | |  | | --- | |  |  |  | | --- | |  |  |  | | --- | | **Typické mechanické hodnoty:** |  |  | | --- | | **Rozměry a balení:** |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |  | 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 |  |  |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **Tepelné zpracování:** |  |  |  |  | | --- | --- | --- | |  | Předehřev | není vyžadován |  |  | | --- | | **Použití:** |  |  |  | | --- | --- | |  | 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. | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  |  |  | | --- | --- | --- | |  |  |  | |  |  |  | |  |  |  | |  |  |  | |