**INOX R 25/20**

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| **Druh:** | Elektroda |
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| **Normy:** |
|   | Norma | Číslo | Označení |
|   | AWS | A 5.4 | E 310 16 |
|   | DIN | 8556 | E 25 20 R 26 |
|   | EN | 1600 | E 25 20 R 12 |
|   | ISO | 3581 | E 25.20 R 26 |
|   | JUS | C.H3.011 | E 25 20 R 26 |

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| **Certifikace/klasifikace:** |
|   | UDT |  |

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| **Poloha svařování:** |   |
|   | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX R 25 20_1.bmp |

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| **Fyzikální hodnoty:** |   |

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| --- | --- | --- |
|   | Obal/náplň | rutilový |
|   | Teplota sušení | 300 °C/2h |
|   | Svařovací proud | C:\Documents and Settings\Admin\Plocha\Jesenice\INOX R 25 20_2.bmp |

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| **Použití pro:** |   |

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| --- | --- |
|   | Žáropevné |
|   | Vysokolegované |

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| **Typické chemické složení v %:** |

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|   | C | 0.11 | Si | < 0.90 | Mn | 2.00 | Cr | 25.0 | Ni | 20.0 |   |

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| **Typické mechanické hodnoty:** |

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|   | Teplota | [°C] | 20 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rm | [MPa] | 540 - 640 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | Rp02 | [MPa] | > 300 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | A5 | [%] | > 30 |   |   |   |   |   |   |
|  |  |  |  |  |  |  |  |  |  |
|   | KV | [J] | > 50 |   |   |   |   |   |   |
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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] |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.00 | 250 | pouzdro | 3.50 |   |   |   | 4 | 14 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 2.50 | 300 | pouzdro | 4.00 | 234 |   | 17.1 | 4 | 16 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 3.25 | 350 | pouzdro | 4.50 | 130 |   | 34.6 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 4.00 | 350 | pouzdro | 4.50 | 87 |   | 51.7 | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |
|   | 5.00 | 350 | pouzdro | 4.50 |   |   |   | 4 | 18 |   |  |
|  |  |  |  |  |  |  |  |  |  |  |  |

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| **Tepelné zpracování:** |

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| --- | --- | --- |
|   | Předehřev | 200-300 °C |
|   | Předehřev | + mezihousenková teplota |

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| **Použití:** |

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|   | Obalená rutilová, austenitická elektroda pro svařování nerezovýchocelí typu 309 a 310. Elektroda odolná okujím do 1200 °C. Předehřev a mezihousenková teplota pro feritické oceli je 200-300 °C a závisí na druhu základního materiálu a jeho tloušťce. Teplotní interval mezi 650-900 °C může způsobit křechkost svarového kovu. Na silnostěnné svarky je možno použít basickou elektrodu INOX B 25/20. |
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