**INOX R 25/20**

|  |  |
| --- | --- |
| **Druh:** | Elektroda |
|  |  |

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

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

|  |
| --- |
|  |

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

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

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

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

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

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

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

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | |  | | --- | |  |  |  | | --- | |  |  |  | | --- | | **Typické mechanické hodnoty:** |  |  | | --- | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | |  | Teplota | [°C] | 20 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rm | [MPa] | 540 - 640 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | Rp02 | [MPa] | > 300 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | A5 | [%] | > 30 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  | |  | KV | [J] | > 50 |  |  |  |  |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **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] |  |  | |  |  |  |  |  |  |  |  |  |  |  |  | |  | 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 |  |  | |  |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | | **Tepelné zpracování:** |  |  |  |  | | --- | --- | --- | |  | Předehřev | 200-300 °C | |  | Předehřev | + mezihousenková teplota |  |  | | --- | | **Použití:** |  |  |  | | --- | --- | |  | 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. | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  | |  |  |  |  | | --- | --- | --- | |  |  |  | |  |  |  | |  |  |  | |  |  |  | |