


## Nicro 600 Tig

| <b>KATEGÓRIA</b>                            | GMAW-GTAW plný drôt  |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
|---|--|-------------------------------------|---------------------|--|-------------------------------------|--------------------|------------------------------|------------------------------|-------|--------|--------|------------|-------|------|--------|---------|------------|--------|---------|---------|--------|------------|---------|-------|--------|------|------------|---------|--|---|----|
| <b>TYP</b>                                  | Plný zvärací drôt s niklovým základom vyvinutý pre metódu TIG.   |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>APLIKÁCIE</b>                            | Používa sa hlavne na zváranie nikel-chróm- železo zliatín (Inconel 600, 601, 690), rozdielných zliatín navzájom (Monel, Inconel, Incoloy), ale aj spájanie zliatín s nehrdzavejúcimi ocelami. Zároveň sa používa aj ako návarová vrstva.   |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>VLASTNOSTI</b>                           | Vďaka mangánu v základe sa vyznačuje zníženým rizikom mikro trhlin, stabilnými vlastnosťami a to aj pri vysokých teplotách až do 480°C.  |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>KLASIFIKÁCIA</b>                         | AWS  | A 5.14: ER NiCr-3                   |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
|   | EN ISO   | 18274: S Ni 6082 (NiCr20Mn3Nb)      |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
|   | DIN: W.Nr.   | 2.4806                              |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
|   | DIN  | 1736: SG NiCr20Nb                   |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>VHODNÉ PRE</b>                           | Inconel 600, 2.4816, 1.4876, 2.4817, 2.4851, 1.6901, NiCr15Fe, X10NiCrAlTi 32 20, LC-NiCr15Fe, NiCr23Fe, X3CrNiN 18 10, zliatina 600/B168, zliatina 800 / 800H, N 10665, N 06601, ťažko zvariteľné ocele   |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>SCHVÁLENIA</b>                           | CE   |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>POLOHY ZVÁRANIA</b>                      |    |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>ZÁKLADNÉ ZLOŽENIE ZVAROVÉHO KOVU V %</b> | <table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>S</th> <th>Nb+Ta</th> <th>Ti</th> <th>Fe</th> <th>Co</th> <th>Cu</th> <th>P</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>&lt; 0.10</td> <td>2.5-3.5</td> <td>&lt; 0.5</td> <td>18-22</td> <td>&lt; 0.015</td> <td>2.0-3.0</td> <td>&lt; 0.75</td> <td>&lt; 3.0</td> <td>&lt; 0.12</td> <td>&lt; 0.5</td> <td>&lt; 0.03</td> <td>&gt; 67</td> </tr> </tbody> </table>  |                                     | C                   | Mn                                     | Si                                  | Cr                 | S                            | Nb+Ta                        | Ti    | Fe     | Co     | Cu         | P     | Ni   | < 0.10 | 2.5-3.5 | < 0.5      | 18-22  | < 0.015 | 2.0-3.0 | < 0.75 | < 3.0      | < 0.12  | < 0.5 | < 0.03 | > 67 |            |         |  |   |    |
| C   | Mn   | Si                                  | Cr                  | S                                      | Nb+Ta                               | Ti                 | Fe                           | Co                           | Cu    | P      | Ni     |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| < 0.10                                      | 2.5-3.5  | < 0.5                               | 18-22               | < 0.015                                | 2.0-3.0                             | < 0.75             | < 3.0                        | < 0.12                       | < 0.5 | < 0.03 | > 67   |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>MECHANICKÉ VLASTNOSTI</b>                | <table border="1"> <thead> <tr> <th rowspan="2">Tepelné spracovanie</th> <th rowspan="2">R<sub>p0,2</sub> (N/mm<sup>2</sup>)</th> <th rowspan="2">R<sub>m</sub> (N/mm<sup>2</sup>)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Rázová húževnatosť (J) ISO-V</th> </tr> <tr> <th>+20°C</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>AW</td> <td>&gt; 420</td> <td>&gt; 640</td> <td>&gt; 35</td> <td>&gt; 200</td> <td>&gt; 100</td> </tr> </tbody> </table>  |                                     | Tepelné spracovanie | R <sub>p0,2</sub> (N/mm <sup>2</sup> ) | R <sub>m</sub> (N/mm <sup>2</sup> ) | A <sub>5</sub> (%) | Rázová húževnatosť (J) ISO-V |                              | +20°C | -196°C | AW     | > 420      | > 640 | > 35 | > 200  | > 100   |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| Tepelné spracovanie                         | R <sub>p0,2</sub> (N/mm <sup>2</sup> )   | R <sub>m</sub> (N/mm <sup>2</sup> ) |                     |  |                                     |                    | A <sub>5</sub> (%)           | Rázová húževnatosť (J) ISO-V |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
|   |  |                                     | +20°C               | -196°C                                 |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| AW  | > 420  | > 640                               | > 35                | > 200                                  | > 100                               |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| AW: stav po zvarení                         |  |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>ZVÁRACIE PARAMETRE / BALENIE</b>         | <table border="1"> <thead> <tr> <th rowspan="2">D (mm)</th> <th colspan="2">Zváracie parametre</th> <th colspan="2">Balenie (kg)</th> </tr> <tr> <th colspan="2">Prúd (A) (DC-)</th> <th>tuba</th> <th>kartón</th> </tr> </thead> <tbody> <tr> <td>1.6 x 1000</td> <td colspan="2">50-80</td> <td>5</td> <td>25</td> </tr> <tr> <td>2.0 x 1000</td> <td colspan="2">70-110</td> <td>5</td> <td>25</td> </tr> <tr> <td>2.4 x 1000</td> <td colspan="2">110-180</td> <td>5</td> <td>25</td> </tr> <tr> <td>3.2 x 1000</td> <td colspan="2">150-250</td> <td>5</td> <td>25</td> </tr> </tbody> </table> |                                     | D (mm)              | Zváracie parametre                     |                                     | Balenie (kg)       |                              | Prúd (A) (DC-)               |       | tuba   | kartón | 1.6 x 1000 | 50-80 |      | 5      | 25      | 2.0 x 1000 | 70-110 |         | 5       | 25     | 2.4 x 1000 | 110-180 |       | 5      | 25   | 3.2 x 1000 | 150-250 |  | 5 | 25 |
| D (mm)                                      | Zváracie parametre   |                                     |                     | Balenie (kg)                           |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
|   | Prúd (A) (DC-)   |                                     | tuba                | kartón                                 |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| 1.6 x 1000                                  | 50-80  |                                     | 5                   | 25                                     |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| 2.0 x 1000                                  | 70-110   |                                     | 5                   | 25                                     |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| 2.4 x 1000                                  | 110-180  |                                     | 5                   | 25                                     |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| 3.2 x 1000                                  | 150-250  |                                     | 5                   | 25                                     |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>TEPLOTA PRESÚŠANIA</b>                   | nepožaduje sa  |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |
| <b>PLYN PODĽA EN ISO 14175:</b>             | I1   |                                     |                     |  |                                     |                    |                              |                              |       |        |        |            |       |      |        |         |            |        |         |         |        |            |         |       |        |      |            |         |  |   |    |