

308 LSi

KATEGÓRIA	GMAW-GTAW Pevné Drôty
TYP	Zvárací drôt z nehrdzavejúcej ocele na zváranie typov CrNi 18/10.
APLIKÁCIE	Kotly, poľnohospodárstvo, zásobníky kvapalín, potravinárske stroje a zariadenia, nábytok.
VLASTNOSTI	308LSi má dobrú všeobecnú odolnosť proti korózii. Zliatina má nízky obsah uhlíka, preto sa odporúča najmä tam, kde existuje riziko medzi kryštalickej korózie. Vyšší obsah kremíka zlepšuje zváracie vlastnosti, ako je zvlhčovanie.

KLASIFIKÁCIA	AWS	A 5.9: ER 308LSi
	EN ISO	14343-A: G 19 9 L Si
	DIN: W.Nr.	1.4316
	DIN	8556: SG X2CrNi 19 9

VHODNÉ PRE	W.Nr:	1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4550, 1.4452	1.4300, 1.4312, 1.4316, 1.4318, 1.4319, 1.4320, 1.4321, 1.4322, 1.4323, 1.4324, 1.4325, 1.4326, 1.4327, 1.4328, 1.4329, 1.4330, 1.4331, 1.4332, 1.4333, 1.4334, 1.4335, 1.4336, 1.4337, 1.4338, 1.4339, 1.4340, 1.4341, 1.4342, 1.4343, 1.4344, 1.4345, 1.4346, 1.4347, 1.4348, 1.4349, 1.4350, 1.4351, 1.4352, 1.4353, 1.4354, 1.4355, 1.4356, 1.4357, 1.4358, 1.4359, 1.4360, 1.4361, 1.4362, 1.4363, 1.4364, 1.4365, 1.4366, 1.4367, 1.4368, 1.4369, 1.4370, 1.4371, 1.4372, 1.4373, 1.4374, 1.4375, 1.4376, 1.4377, 1.4378, 1.4379, 1.4380, 1.4381, 1.4382, 1.4383, 1.4384, 1.4385, 1.4386, 1.4387, 1.4388, 1.4389, 1.4390, 1.4391, 1.4392, 1.4393, 1.4394, 1.4395, 1.4396, 1.4397, 1.4398, 1.4399, 1.4400, 1.4401, 1.4402, 1.4403, 1.4404, 1.4405, 1.4406, 1.4407, 1.4408, 1.4409, 1.4410, 1.4411, 1.4412, 1.4413, 1.4414, 1.4415, 1.4416, 1.4417, 1.4418, 1.4419, 1.4420, 1.4421, 1.4422, 1.4423, 1.4424, 1.4425, 1.4426, 1.4427, 1.4428, 1.4429, 1.4430, 1.4431, 1.4432, 1.4433, 1.4434, 1.4435, 1.4436, 1.4437, 1.4438, 1.4439, 1.4440, 1.4441, 1.4442, 1.4443, 1.4444, 1.4445, 1.4446, 1.4447, 1.4448, 1.4449, 1.4450, 1.4451, 1.4452, 1.4453, 1.4454, 1.4455, 1.4456, 1.4457, 1.4458, 1.4459, 1.4460, 1.4461, 1.4462, 1.4463, 1.4464, 1.4465, 1.4466, 1.4467, 1.4468, 1.4469, 1.4470, 1.4471, 1.4472, 1.4473, 1.4474, 1.4475, 1.4476, 1.4477, 1.4478, 1.4479, 1.4480, 1.4481, 1.4482, 1.4483, 1.4484, 1.4485, 1.4486, 1.4487, 1.4488, 1.4489, 1.4490, 1.4491, 1.4492, 1.4493, 1.4494, 1.4495, 1.4496, 1.4497, 1.4498, 1.4499, 1.4500, 1.4501, 1.4502, 1.4503, 1.4504, 1.4505, 1.4506, 1.4507, 1.4508, 1.4509, 1.4510, 1.4511, 1.4512, 1.4513, 1.4514, 1.4515, 1.4516, 1.4517, 1.4518, 1.4519, 1.4520, 1.4521, 1.4522, 1.4523, 1.4524, 1.4525, 1.4526, 1.4527, 1.4528, 1.4529, 1.4530, 1.4531, 1.4532, 1.4533, 1.4534, 1.4535, 1.4536, 1.4537, 1.4538, 1.4539, 1.4540, 1.4541, 1.4542, 1.4543, 1.4544, 1.4545, 1.4546, 1.4547, 1.4548, 1.4549, 1.4550, 1.4551, 1.4552, 1.4553, 1.4554, 1.4555, 1.4556, 1.4557, 1.4558, 1.4559, 1.4560, 1.4561, 1.4562, 1.4563, 1.4564, 1.4565, 1.4566, 1.4567, 1.4568, 1.4569, 1.4570, 1.4571, 1.4572, 1.4573, 1.4574, 1.4575, 1.4576, 1.4577, 1.4578, 1.4579, 1.4580, 1.4581, 1.4582, 1.4583, 1.4584, 1.4585, 1.4586, 1.4587, 1.4588, 1.4589, 1.4590, 1.4591, 1.4592, 1.4593, 1.4594, 1.4595, 1.4596, 1.4597, 1.4598, 1.4599, 1.4600, 1.4601, 1.4602, 1.4603, 1.4604, 1.4605, 1.4606, 1.4607, 1.4608, 1.4609, 1.4610, 1.4611, 1.4612, 1.4613, 1.4614, 1.4615, 1.4616, 1.4617, 1.4618, 1.4619, 1.4620, 1.4621, 1.4622, 1.4623, 1.4624, 1.4625, 1.4626, 1.4627, 1.4628, 1.4629, 1.4630, 1.4631, 1.4632, 1.4633, 1.4634, 1.4635, 1.4636, 1.4637, 1.4638, 1.4639, 1.4640, 1.4641, 1.4642, 1.4643, 1.4644, 1.4645, 1.4646, 1.4647, 1.4648, 1.4649, 1.4650, 1.4651, 1.4652, 1.4653, 1.4654, 1.4655, 1.4656, 1.4657, 1.4658, 1.4659, 1.4660, 1.4661, 1.4662, 1.4663, 1.4664, 1.4665, 1.4666, 1.4667, 1.4668, 1.4669, 1.4670, 1.4671, 1.4672, 1.4673, 1.4674, 1.4675, 1.4676, 1.4677, 1.4678, 1.4679, 1.4680, 1.4681, 1.4682, 1.4683, 1.4684, 1.4685, 1.4686, 1.4687, 1.4688, 1.4689, 1.4690, 1.4691, 1.4692, 1.4693, 1.4694, 1.4695, 1.4696, 1.4697, 1.4698, 1.4699, 1.4700, 1.4701, 1.4702, 1.4703, 1.4704, 1.4705, 1.4706, 1.4707, 1.4708, 1.4709, 1.4710, 1.4711, 1.4712, 1.4713, 1.4714, 1.4715, 1.4716, 1.4717, 1.4718, 1.4719, 1.4720, 1.4721, 1.4722, 1.4723, 1.4724, 1.4725, 1.4726, 1.4727, 1.4728, 1.4729, 1.4730, 1.4731, 1.4732, 1.4733, 1.4734, 1.4735, 1.4736, 1.4737, 1.4738, 1.4739, 1.4740, 1.4741, 1.4742, 1.4743, 1.4744, 1.4745, 1.4746, 1.4747, 1.4748, 1.4749, 1.4750, 1.4751, 1.4752, 1.4753, 1.4754, 1.4755, 1.4756, 1.4757, 1.4758, 1.4759, 1.4760, 1.4761, 1.4762, 1.4763, 1.4764, 1.4765, 1.4766, 1.4767, 1.4768, 1.4769, 1.4770, 1.4771, 1.4772, 1.4773, 1.4774, 1.4775, 1.4776, 1.4777, 1.4778, 1.4779, 1.4780, 1.4781, 1.4782, 1.4783, 1.4784, 1.4785, 1.4786, 1.4787, 1.4788, 1.4789, 1.4790, 1.4791, 1.4792, 1.4793, 1.4794, 1.4795, 1.4796, 1.4797, 1.4798, 1.4799, 1.4800, 1.4801, 1.4802, 1.4803, 1.4804, 1.4805, 1.4806, 1.4807, 1.4808, 1.4809, 1.4810, 1.4811, 1.4812, 1.4813, 1.4814, 1.4815, 1.4816, 1.4817, 1.4818, 1.4819, 1.4820, 1.4821, 1.4822, 1.4823, 1.4824, 1.4825, 1.4826, 1.4827, 1.4828, 1.4829, 1.4830, 1.4831, 1.4832, 1.4833, 1.4834, 1.4835, 1.4836, 1.4837, 1.4838, 1.4839, 1.4840, 1.4841, 1.4842, 1.4843, 1.4844, 1.4845, 1.4846, 1.4847, 1.4848, 1.4849, 1.4850, 1.4851, 1.4852, 1.4853, 1.4854, 1.4855, 1.4856, 1.4857, 1.4858, 1.4859, 1.4860, 1.4861, 1.4862, 1.4863, 1.4864, 1.4865, 1.4866, 1.4867, 1.4868, 1.4869, 1.4870, 1.4871, 1.4872, 1.4873, 1.4874, 1.4875, 1.4876, 1.4877, 1.4878, 1.4879, 1.4880, 1.4881, 1.4882, 1.4883, 1.4884, 1.4885, 1.4886, 1.4887, 1.4888, 1.4889, 1.4890, 1.4891, 1.4892, 1.4893, 1.4894, 1.4895, 1.4896, 1.4897, 1.4898, 1.4899, 1.4900, 1.4901, 1.4902, 1.4903, 1.4904, 1.4905, 1.4906, 1.4907, 1.4908, 1.4909, 1.4910, 1.4911, 1.4912, 1.4913, 1.4914, 1.4915, 1.4916, 1.4917, 1.4918, 1.4919, 1.4920, 1.4921, 1.4922, 1.4923, 1.4924, 1.4925, 1.4926, 1.4927, 1.4928, 1.4929, 1.4930, 1.4931, 1.4932, 1.4933, 1.4934, 1.4935, 1.4936, 1.4937, 1.4938, 1.4939, 1.4940, 1.4941, 1.4942, 1.4943, 1.4944, 1.4945, 1.4946, 1.4947, 1.4948, 1.4949, 1.4950, 1.4951, 1.4952, 1.4953, 1.4954, 1.4955, 1.4956, 1.4957, 1.4958, 1.4959, 1.4960, 1.4961, 1.4962, 1.4963, 1.4964, 1.4965, 1.4966, 1.4967, 1.4968, 1.4969, 1.4970, 1.4971, 1.4972, 1.4973, 1.4974, 1.4975, 1.4976, 1.4977, 1.4978, 1.4979, 1.4980, 1.4981, 1.4982, 1.4983, 1.4984, 1.4985, 1.4986, 1.4987, 1.4988, 1.4989, 1.4990, 1.4991, 1.4992, 1.4993, 1.4994, 1.4995, 1.4996, 1.4997, 1.4998, 1.4999, 1.5000
	DIN	X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP),	X6CrNiNb 18 10 (TP)
	AIISI	202, 302, 304L, 304, 305, 321, 347, 304 LN	
		ASTM A320 Trieda B8C/D, 302	

SCHVÁLENIA TUV (12386.00), DB (43.206.02), CE schválene

ZVÁRACIE POZÍCIE:



HMOTNOSŤ ZVÁRANÉHO KOVU %

C	Mn	Si	Cr	Ni	Mo	P	S
<0.03	1.0-2.5	0.65-1.0	19.5-22.0	9.0-11.0	<0.75	<0.03	<0.03

MECHANICKÉ VLASTNOSTI

Tepelné Spracovanie	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Nárazová Energia (J) ISO-V			Tvrdosť HRC / HV
				20°C	-60°C	-196°C	
AW	460	620	36	110	70	45	

AW: po zváraní

PARAMETRE ZVÁRANIA / BALENIE

PARAMETRE ZVÁRANIA			BALENIE		
D (mm)	Napätie (V)	Prúd (A) (DC+)	Typ cievky	kg cievka	kg / paleta
0.6	-	-	D-200 / D-300	5 / 15	1000 / 1080
0.8	12-24	55-160	D-200 / S-300 / Bubon	5 / 15 / 250	1000 / 1080 / 1000
1.0	15-28	80-240	D-200 / S-300 / Bubon	5 / 15 / 250	1000 / 1080 / 1000
1.2	15-29	100-300	S-300 / Bubon	15 / 250	1080 / 1000
1.6	23-31	150-375	S-300 / Bubon	15 / 250	1080 / 1000

TEPLOTA OPÄTOVNÉHO SUŠENIA Nevyžaduje sa

PLYN PODĽA EN ISO 14175: M11, M12, M13