



XA 00150520

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	ASME		23
EN ISO		13	24
		14	25
		16	27

AWS A5.20

OK Tubrod 15.13	E71T-1C H4	E71T-1M H8
OK Tubrod 15.13S	E71T-9 H4	
OK Tubrod 15.14	E71T-1C	E71T-1M
FILARC PZ6113	E71T-1C H4	E71T-1M H8
FILARC PZ6114		E71T-1MJ H4
FILARC PZ6114S	E71T-1CJ H4	
Dual Shield 7100 Ultra	E71T-9C H8	E71T-9M
Dual Shield 7100 LH	E71T-1C	E71T-1M
Dual Shield 7100S	E71T-1C	
OK E71T-1	E71T-1C H4	E71T-1M H8
71T	E71T-9C H8	

AWS A5.29

OK Tubrod 15.17		E81T1-Ni1M
FILARC PZ6116S	E81T1-K2 JH4	
FILARC PZ6138		E81T1-Ni1M JH4
FILARC PZ6138 SR		E81T1-Ni1M J
FILARC PZ6138S SR	E81T1-Ni1C J	

AWS A5.29

Dual Shield 55		E91T1-Ni1M
Dual Shield 62		E101T1-G
Dual Shield II 81-K2		E81T1-K2
OK Tubrod 15.09		E111T1-K3MJ-H4

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EN ISO 17632-A

T 42 2 P C 1 H5	T 46 2 P M 1 H10	CO ₂	Ar / 15-25 CO ₂
T 46 3 P C 2 H5		CO ₂	
T 46 2 P C 2 H5	T 46 2 P M 2 H5	CO ₂	Ar / 15-25 CO ₂
T 42 2 P C 1 H5	T 46 2 P M 1 H10	CO ₂	Ar / 15-25 CO ₂
	T 46 4 P M 1 H5		Ar / 15-25 CO ₂
T 46 4 P C 1 H5		CO ₂	
T 42 3 R C 1 H5	T 42 3 R M 1 H10	CO ₂	Ar / 15-25 CO ₂
T 42 2 P C 1 H5	T 46 2 P M 1 H10	CO ₂	Ar / 15-25 CO ₂
		CO ₂	
T 42 2 P C 1 H5	T 46 2 P M 1 H10	CO ₂	Ar / 15-25 CO ₂
		CO ₂	

EN ISO 17632-A

T 46 3 1Ni P C 2 H5	T 46 4 1Ni P M 2 H5	CO ₂	Ar / 15-25 CO ₂
T 46 6 1,5Ni P C 1 H5		CO ₂	
	T 50 6 1Ni P M 1 H5		Ar / 15-25 CO ₂
	T 46 6 1Ni P M 1 H5		Ar / 15-25 CO ₂
T 46 6 1Ni P C 1 H5		CO ₂	

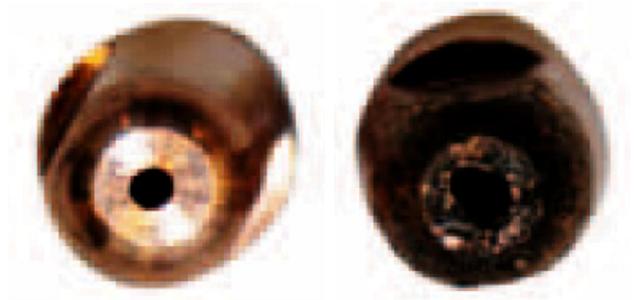
EN ISO 18276-A

	T 55 4 Z P M 2 H5		Ar / 15-25 CO ₂
	T 62 4 Mn1,5Ni P M 2 H5		Ar / 15-25 CO ₂
			Ar / 15-25 CO ₂
	T 69 4 2NiMo P M 2 H5		Ar / 15-25 CO ₂

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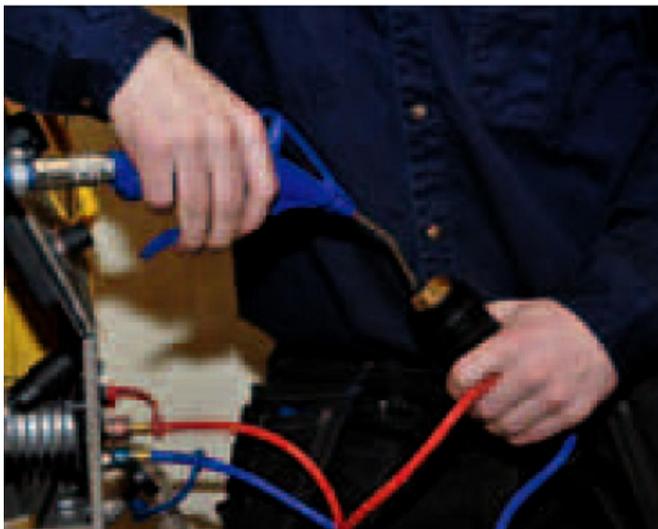
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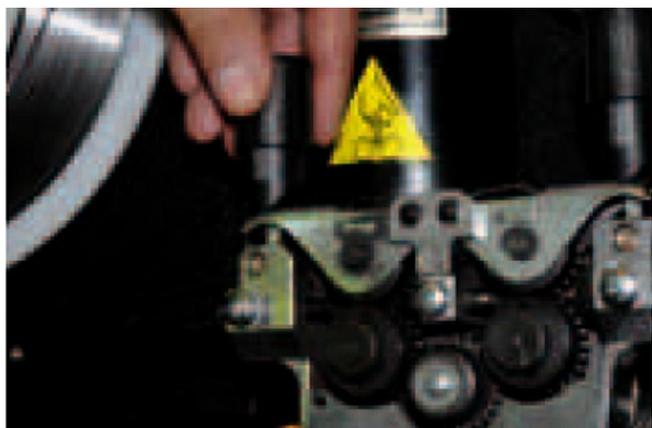
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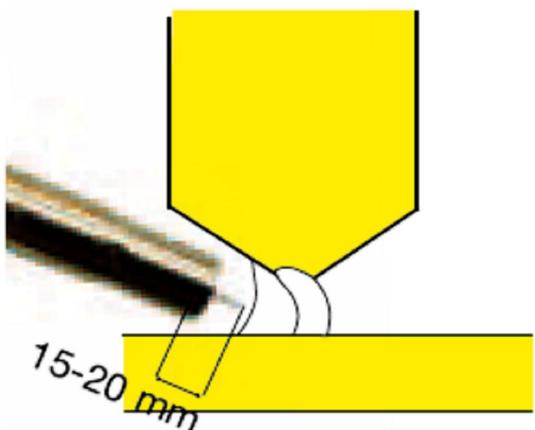
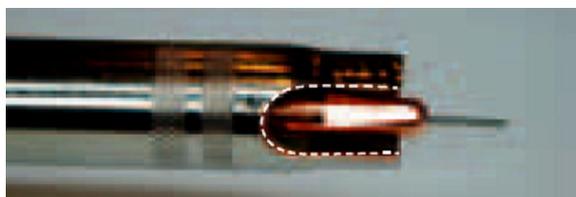
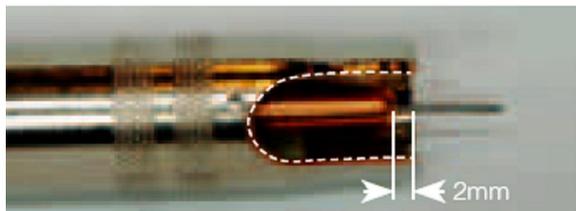
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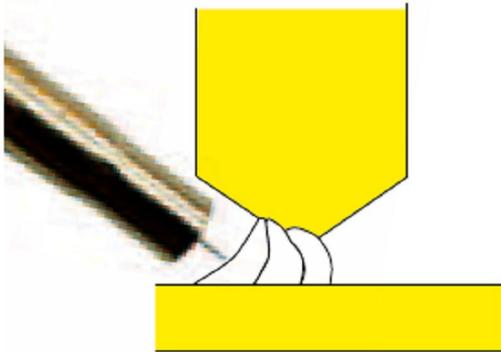
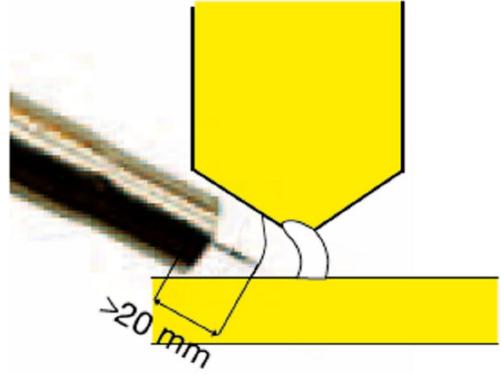
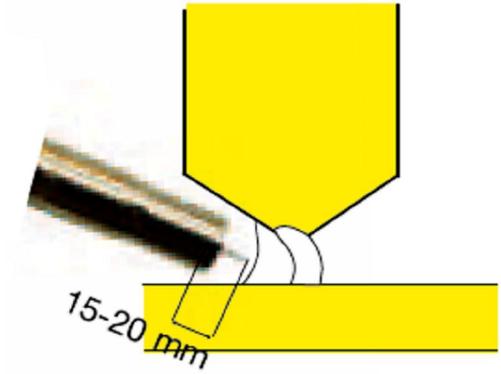
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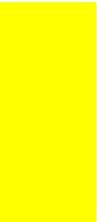
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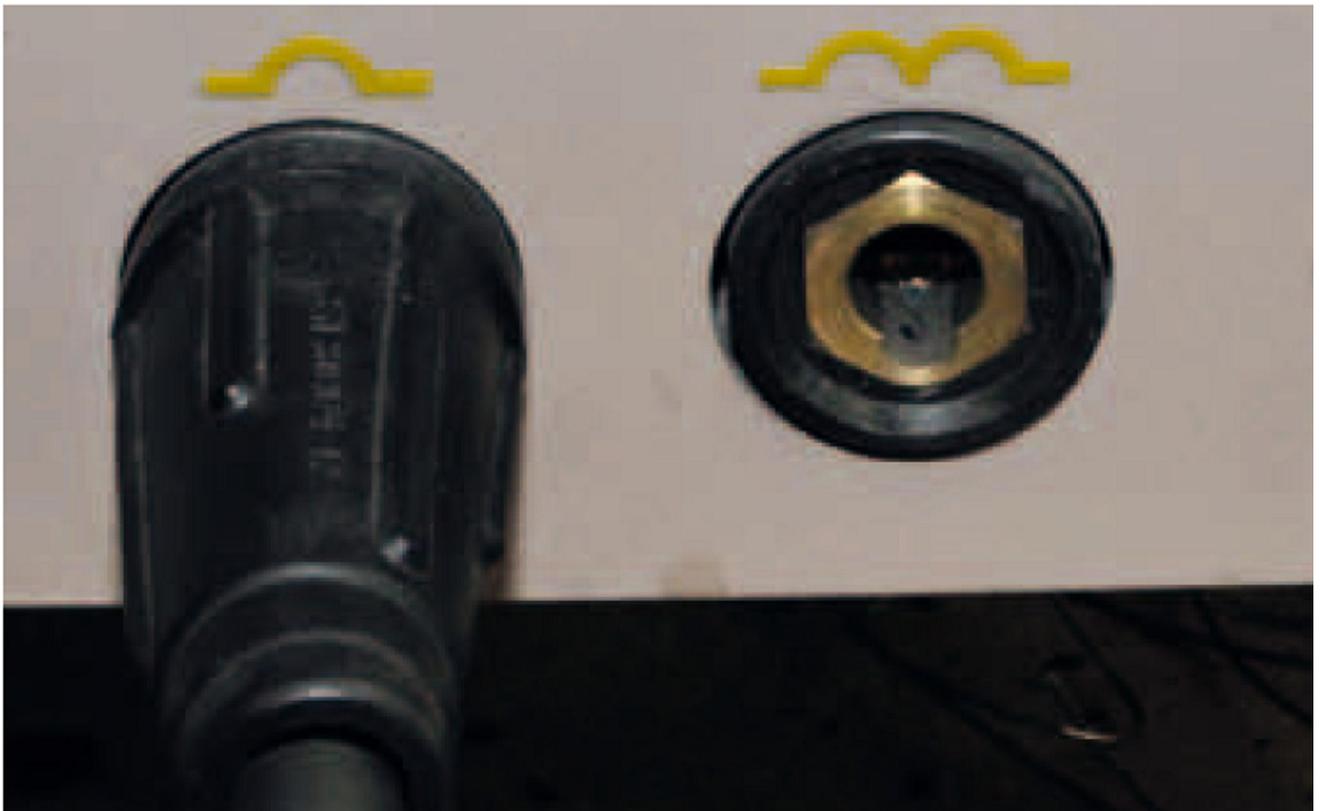
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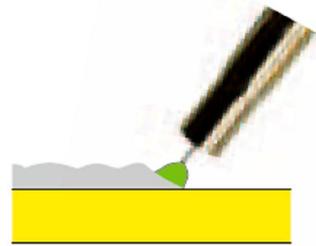


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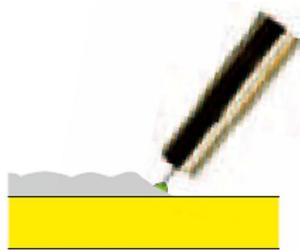
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16-17



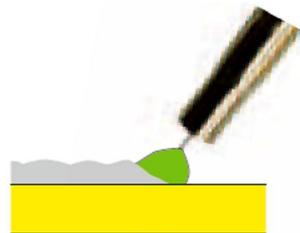
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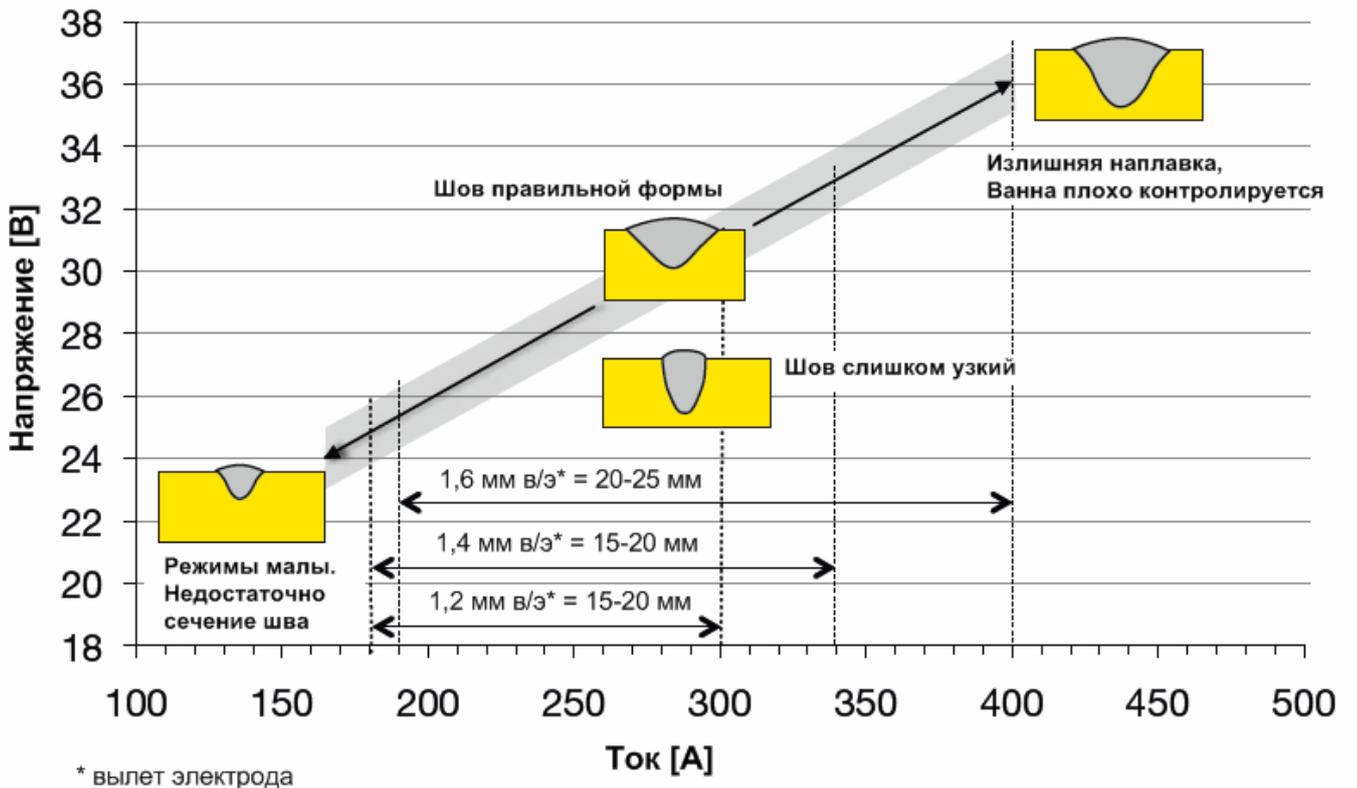


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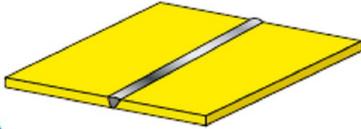
16-17

Ar/20CO₂

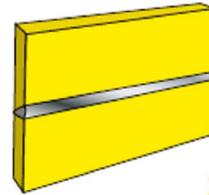


ASME EN ISO

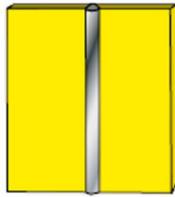
1G/PA



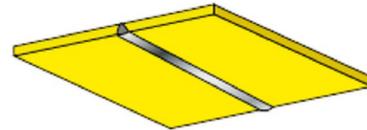
2G/PC



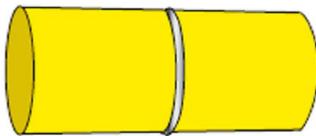
3G/PF&PG



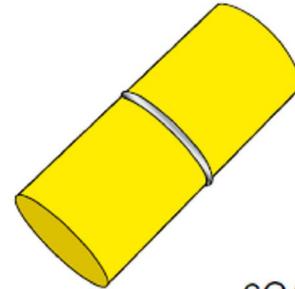
4G/PE



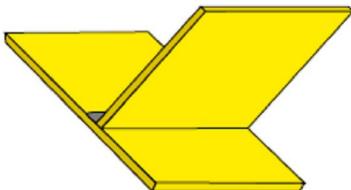
5G/PF&PG



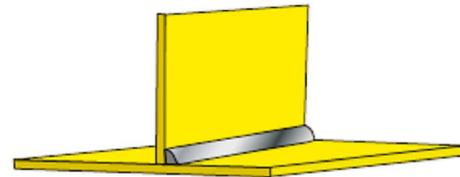
6G/HL045



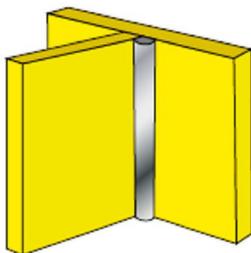
1F/PA



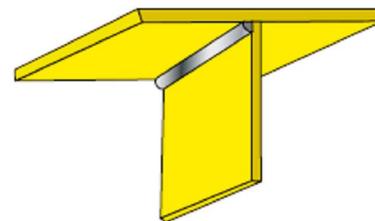
2F/PB



3F/PF&PG



4F/PD



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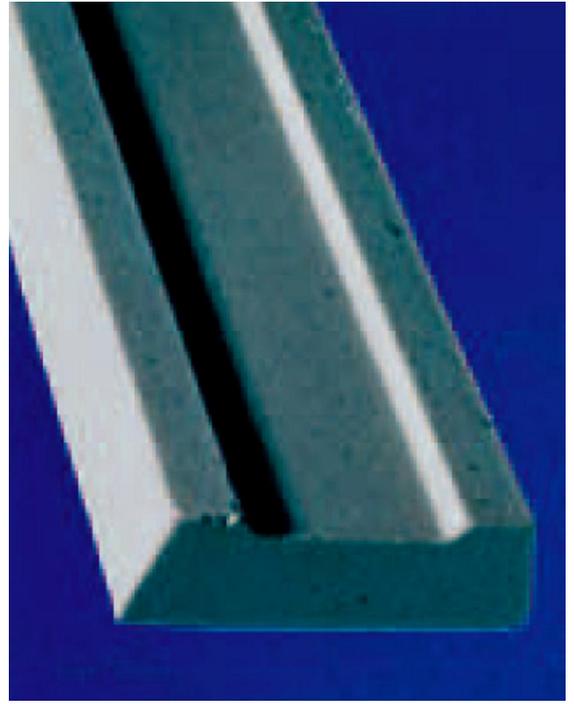
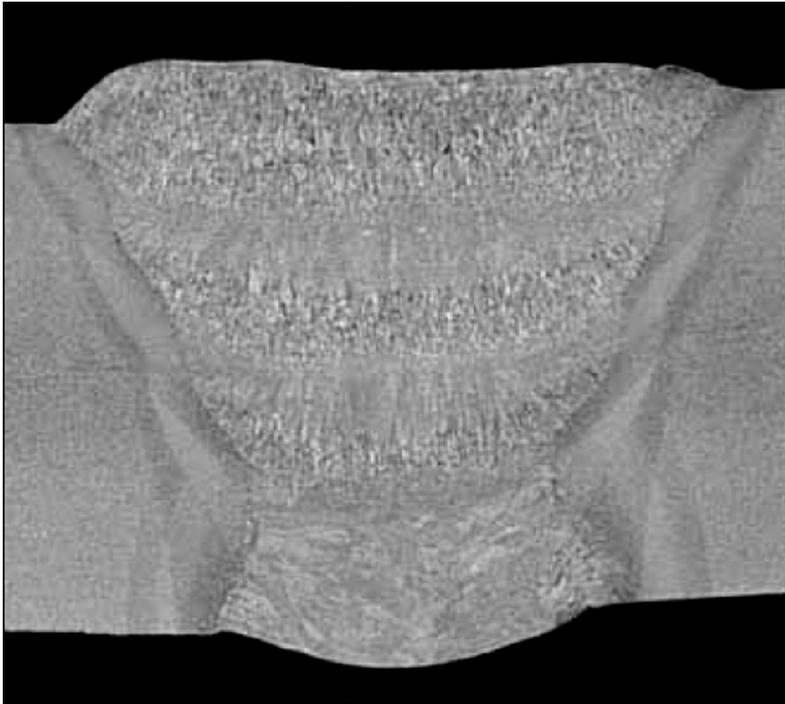
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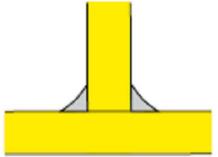
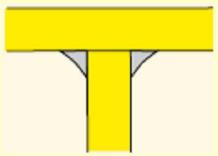
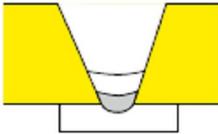
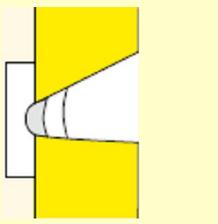
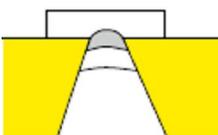
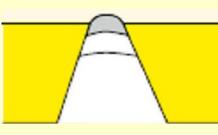
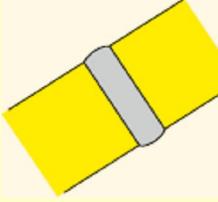


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PF/3G.

		ø 1,2	ø 1,4	ø 1,6
-	1F/PA	2		
-	2F/PB	2		
-	3F↑/PF			
-	4F/PD			
	1G/PA		1	
	1G/PA	2		
	2G/PC			
	2G/PC			
	3G/PF			3
	3G/PF			3
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	4G/PE		2	
	5G/PF			
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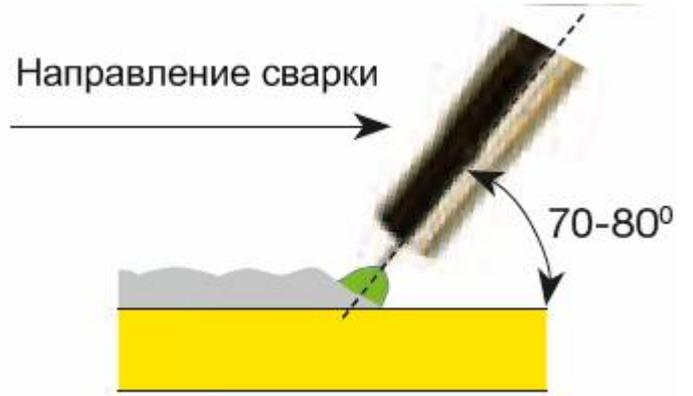
		ø 1,2 (15-20)			
		I []	V [/]	U []*	
1F/2F					
		180-300	6,0-14,0	24-31	
3F/4F					
		180-250	6,0-10,0	23-28	
1G		**	180-200	6,0-8,0	23-26
			180-280	6,0-12,0	25-31
2G		**	180-210	6,0-8,5	23-26
			180-260	6,0-10,0	25-29
3G		**	180-220	6,0-8,5	23-27
			180-240	6,0-9,0	24-28
4G					
			180-260	6,0-10,0	24-28
5G					
			180-240	6,0-9,0	24-28
6G					
			180-240	6,0-9,0	24-28

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CO₂
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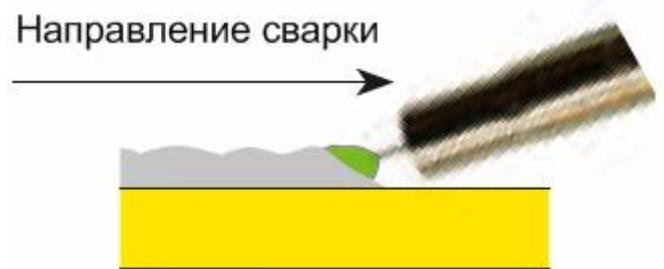
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Ar/20CO₂.

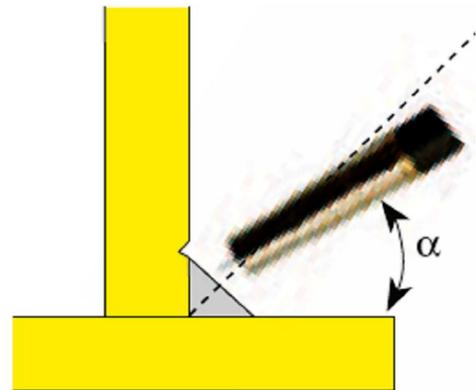
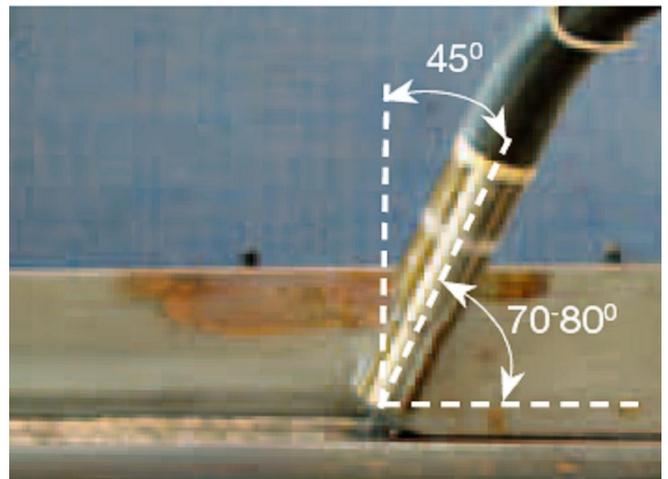
	ø 1,4 (15-20)			ø 1,6 (20-25)		
	I []	V [/]	U []*	I []	V [/]	U []*
	190-340	4,5-10,5	24-32	200-400	4,5-10,5	25-35
	190-240	4,5-6,0	24-28	3F: 220-250	5,0-5,8	24-28
				4F: 200-250	4,0-5,8	25-29
	190-340	4,4-10,5	24-32	210-400	4,5-10,5	25-35
	180-210	4,0-5,0	23-27	190-220	3,7-5,0	25-28
	190-300	4,4-8,5	24-32	210-320	4,5-8,0	25-33
	180-210	4,0-5,5	23-27			
	190-240	4,4-6,2	24-29	220-250	5,0-6,0	24-28
	190-240	4,5-6,0	24-28			
	190-240	4,5-6,0	24-28			
	190-240	4,5-6,0	24-28			



70-80°



2F/PB Ę

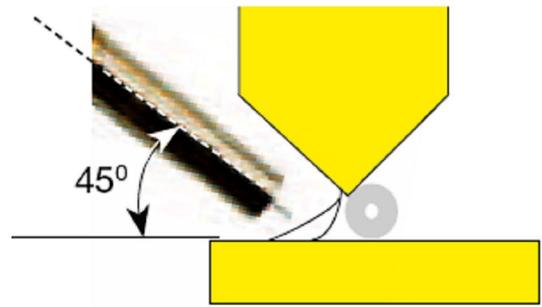
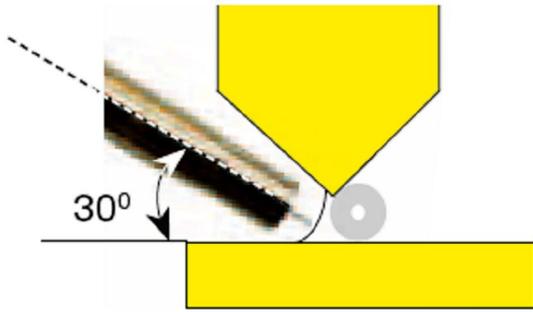


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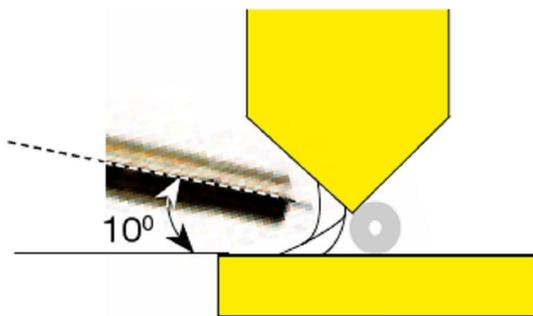
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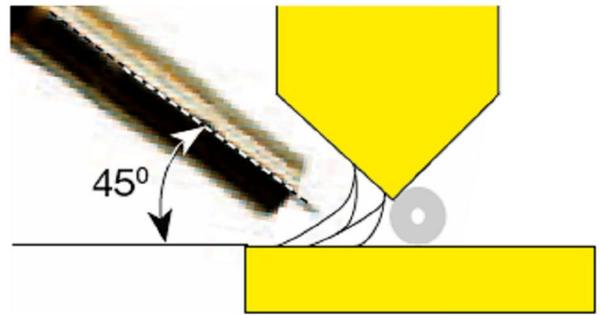
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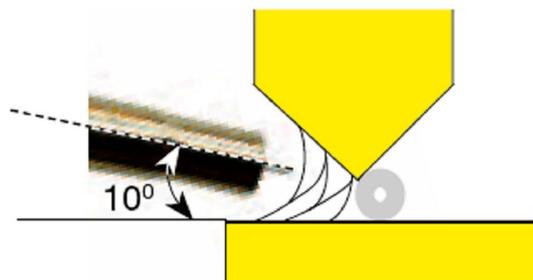
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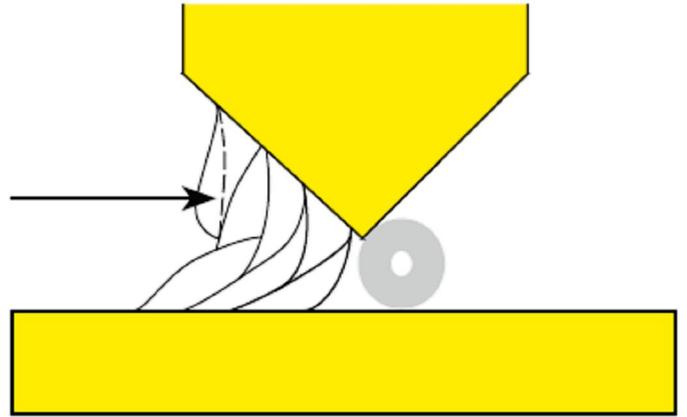
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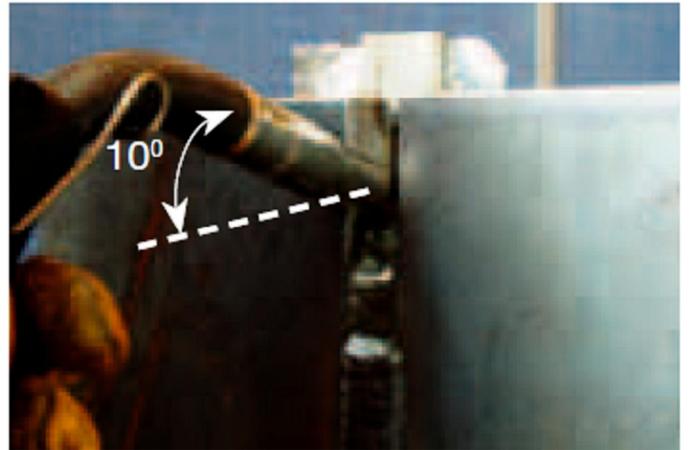
3G↑/3F↑/PF Ë

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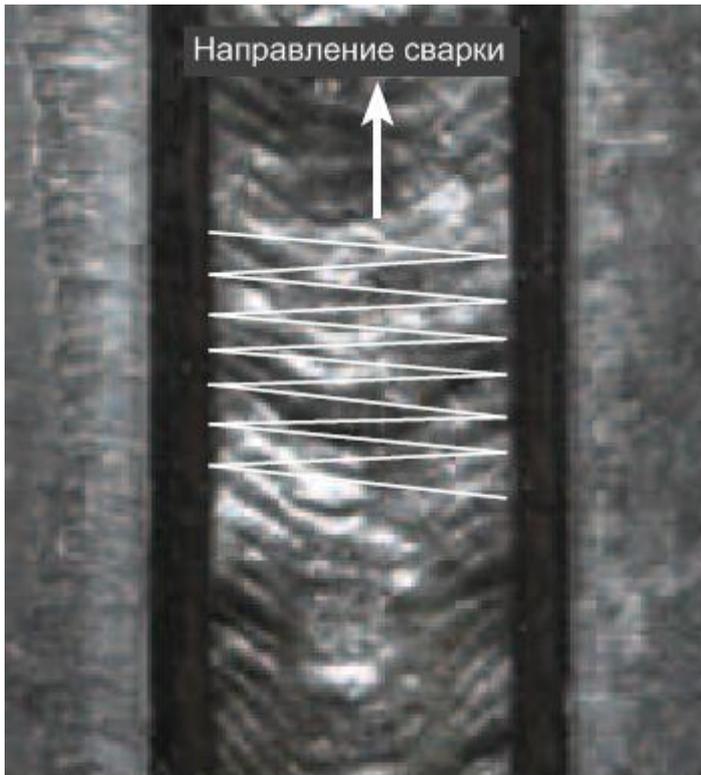
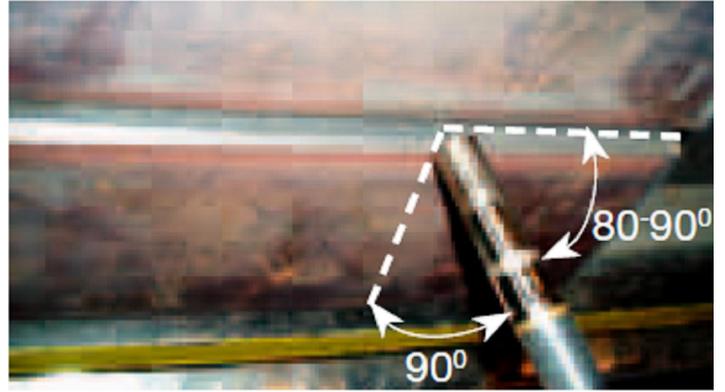
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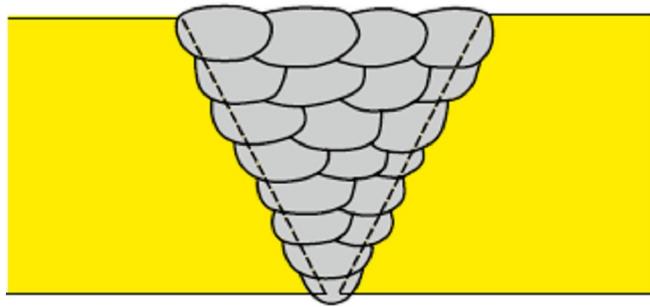
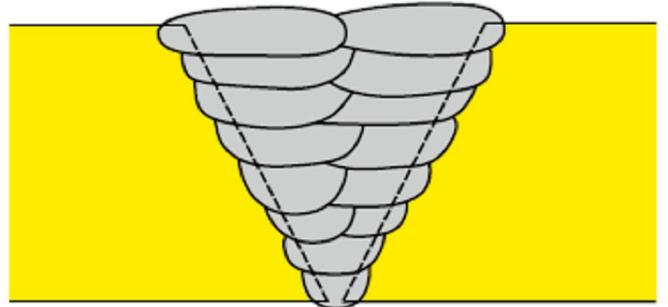
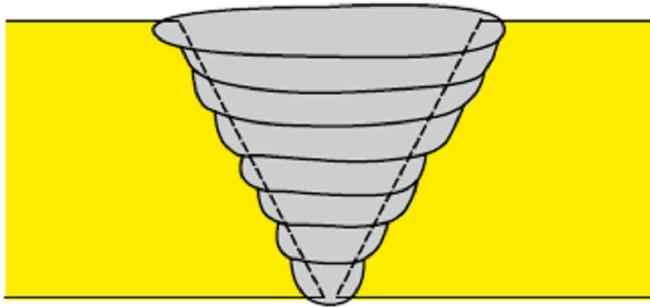


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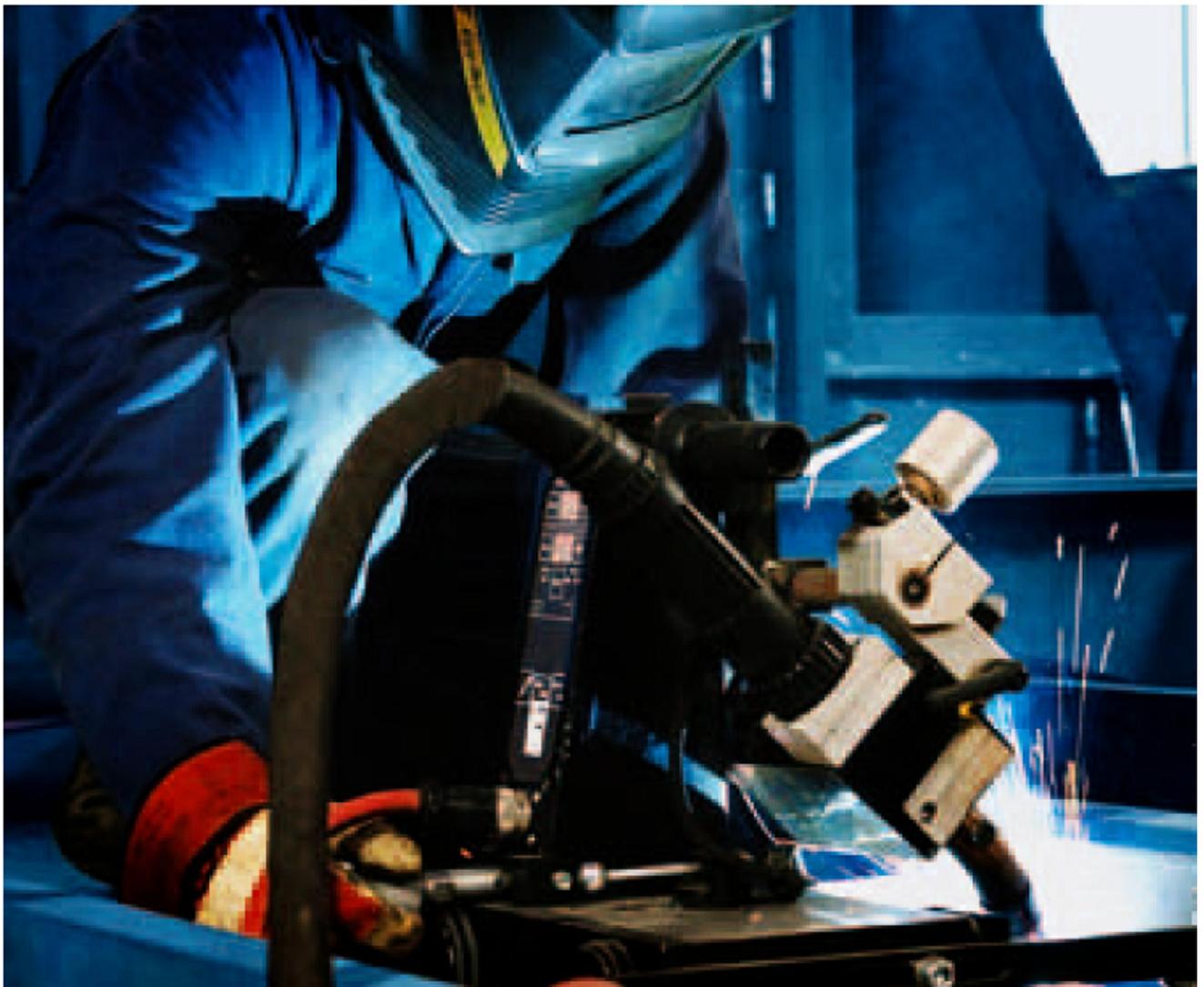
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	1,5-2,5	/
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MAG FCAW

MIG-

- ESAB Miggytrac
- ESAB Railtrac
- ESAB Railtrac Orbital



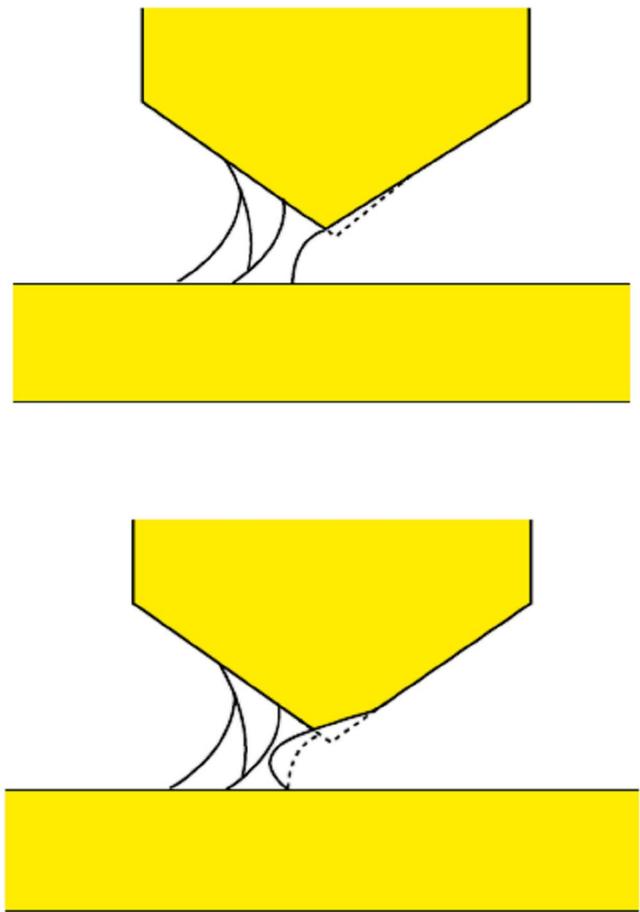
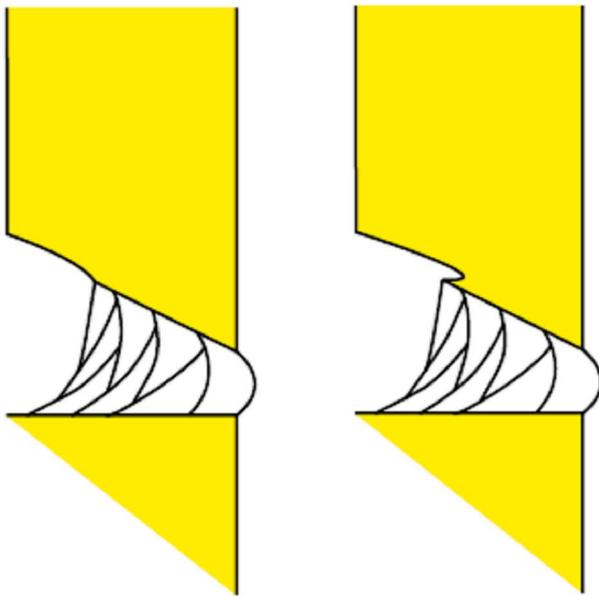
ESAB Miggytrac.

ESAB Railtrac.



ESAB Railtrac
Orbital



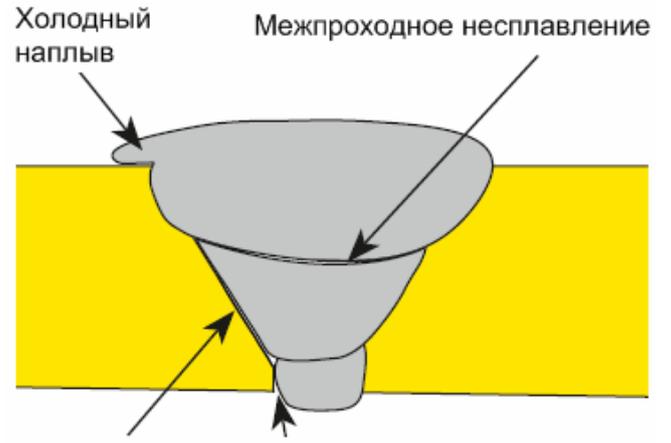




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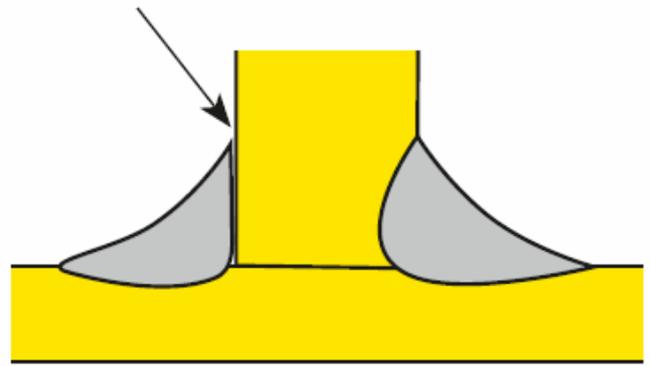
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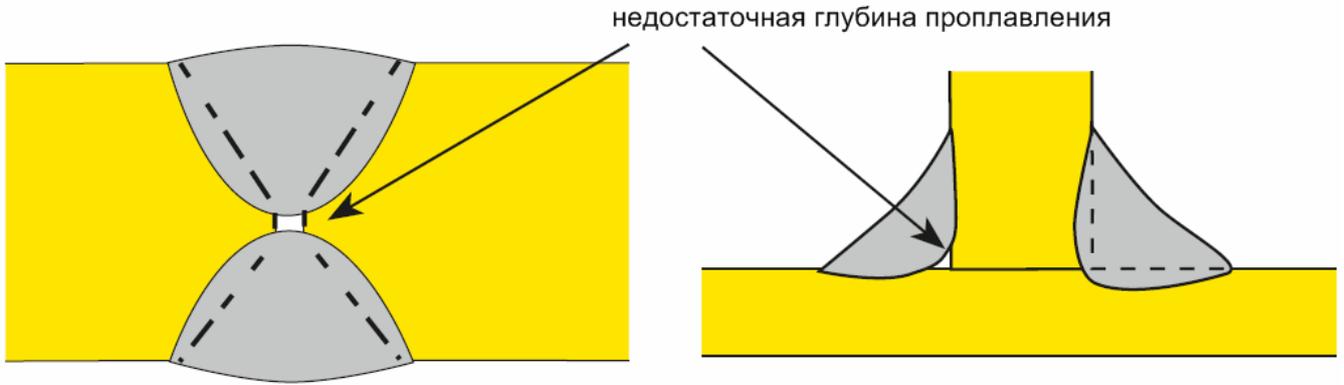
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Несплавление со стенкой

Несплавление в корне



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1G/PA 2G/PC, 1G (2G) (2G).



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- - 70-90° ;
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1G/PA

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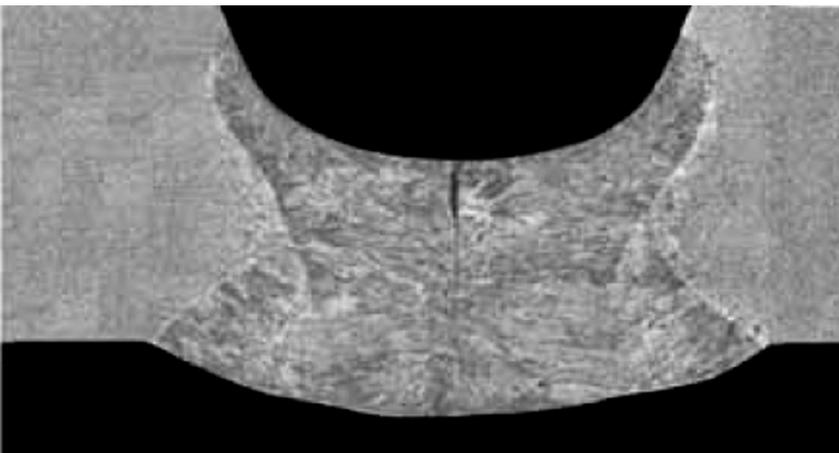
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ISO14001

OHSAS 18001



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(495) 663 20 08, .- (812) 336 70 80,
 (343) 220 10 07, (843) 291 75 37, .
 (831) 278 00 03, 8 (913) 766 46 74, 8
 (919) 209 52 15, - - (863) 295 03 85, -
 8 (914) 755 02 28, (727) 259 86 60, (38044) 501 23
 24, (37517) 328 60 49

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