



Stroj OMI 205

V - svar, poloha vodorovná shora				
Plyn		CO ₂		
Drát		0.6		
Př.10pol.	Posuv	Pos.m/min	Mat. s = mm	A
1	3-4	3-5.8	1	30-55
2	3-4	3-5.8	1-1.5	35-60
3	3.5-4.5	4.4-6.8	1-2.5	40-65
4	4-6	5.8-10.5	1-2.5	50-90
5	5-7	8.1-12.9	2-3	70-100
6	5.5-7.5	9.4-14	3	70-100
7	6-8.5	10.5-16.2	3	75-110
8	7.5-10	14-19.5	3	80-115
9	8.5-11	16.2-20	3-4	80-120
10	9-11	17.2-20	3-4	100-130

V - svar, poloha vodorovná shora				
Plyn		CO ₂		
Drát		0.8		
Př.10pol.	Posuv	Pos.m/min	Mat. s = mm	A
1	2.5-3.5	1.7-4.4	1	35-60
2	3-3.5	3-4.4	1-2	55-80
3	3-4	3-5.8	1-3	60-90
4	3-4	3-5.8	2-3	80-100
5	3-4.5	3.6.8	3	80-110
6	3.5-5	4.4-8.1	3	100-120
7	4.5-6.5	6.8-11.7	3-4	120-150
8	6-7	10.5-12.9	3-4	135-155
9	7.5-8.5	14-16.2	4-5	150-190
10	7.5-9	14-17.2	4-6	180-200

Datum:.....

Zkoušku provedl:.....

Kontroloval:.....

