

3. SUDAREA PRIN DESCARCARE CAPACITIVA – bolturi cu virf

-Sisteme de sudura NCD67

NCD67

Capacitate M3-M8 mm

Putere livrata : 800 -3200KVA

Alimentare : 230 V/50 Hz (10%)

Greutate : 12,5 Kg

Gabarit : 165x290x380 mm



-Materiale si caracteristici de rezistenta la Bolturi

- Otel carbon St37-3K

Rm min = 420 N / mm²

- Otel inox 1.4301/1.4303

Rm min = 500 N / mm²

- Alama CuZn63

Rm min = 350 N / mm²

- Aluminu AlMg3

Rm min = 230 N / mm²

(Protectie disponibila la otel St37-3K: cuprat electrolitic C2E conf DIN267 pag 9, alte acoperiri –nichelat – la cerere

-Filet rulat la rece , toleranta 6 g, conk DIN 13 pag. 20

TABEL SUDABILITATE

Material de baza	Material bolturi			
Otel de constructie pina la 0,2 % C	1	1	1	3
Otel nealiat pina la 0,35 % C	2	1	1	3
Tabla de otel zincata	2	2	1	3
Otel aliat CrNi	1	2	2	3
Alama (Cu Zn 37)	2	2	1	3
Alama Al 99,5	3	3	3	2
Alama Al Mg3	3	3	3	1

1=buna

2=medie

3=inapta sudurii

Gama PK-B(PT)

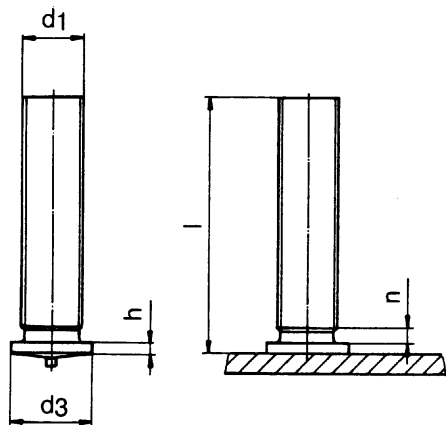
Bolturi filetate cu virf conf. DIN ENISO13918

Material: oțel S235 J2G3+C450 (St 37-3K) cuprat electrolic

oțel inox 1.4301 / 1.4303

Aliaj aluminiu AIMg3

Alama MS 63 (CuZn 37)



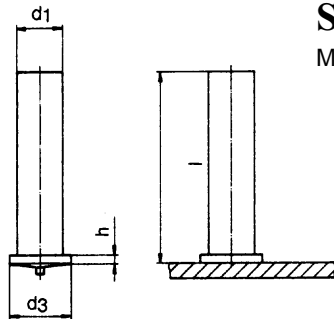
d_1	M 3	M 4	M 5	M 6	M 8
h	0,7-1,4	0,7-1,4	0,8-1,4	0,8-1,4	0,8-1,4
$d_3 \pm 0,2$	4,5	5,5	6,5	7,5	9,0
ρ_{max}	1,5	1,5	2,0	2,0	2,0

d_1	l	Art. Nr.				penseta		
		oțel St 37-3K	1.4301/1.4303	Al Mg 3	Cu Zn 37 (MS 63)	PK 02	PK 200 E	PK 300
M 3	6	11-00-10	11-00-12	11-00-14		20-03-00	20-43-00	21-55-00
	8	11-00-20	11-00-22	11-00-24				
	10	11-00-30	11-00-32	11-00-34				
	12	11-00-40	11-00-42	11-00-44				
	16	11-00-50	11-00-52	11-00-54				
	20	11-00-60		11-00-64				
M 4	6	11-10-00	11-10-02		11-10-07	20-05-00	20-23-00	21-55-01
	8	11-10-10	11-10-12	11-10-14	11-10-17			
	10	11-10-20	11-10-22	11-10-24	11-10-27			
	12	11-10-30	11-10-32	11-10-34	11-10-37			
	16	11-11-20	11-11-22	11-11-24	11-11-27			
	20	11-10-50	11-10-52	11-10-54	11-10-57			
	25	11-10-60	11-10-62	11-10-64				
	30	11-10-70	11-10-72	11-10-74				
	35	11-10-80	11-10-82	11-10-84				
M 5	8	11-20-00	11-20-02			20-06-00	20-25-00	21-55-02
	10	11-20-10	11-20-12	11-20-14	11-20-17			
	12	11-20-20	11-20-22					
	16	11-21-90	11-21-92	11-21-94	11-21-97			
	20	11-20-40	11-20-42	11-20-44				
	25	11-20-50	11-20-52		11-20-57			
	30	11-20-60	11-20-62		11-20-67			
	35	11-20-70	11-20-72					
	40	11-20-80	11-20-82					
	45	11-21-40						
M 6	8		11-30-02			20-07-00	20-26-00	21-55-03
	10	11-30-10	11-30-12	11-30-14	11-30-17			
	12	11-30-20	11-30-22	11-30-24	11-30-27			
	16	11-31-90	11-31-92	11-31-94	11-31-97			
	20	11-30-40	11-30-42	11-30-44	11-30-47			
	25	11-30-50	11-30-52	11-30-54				
	30	11-30-60	11-30-62					
	35	11-30-70	11-30-72					
	40	11-30-80	11-30-82					
	45	11-30-90	11-30-92					
M 8	16	11-36-80	11-36-82	11-36-84		20-09-00	21-12-00	21-55-04
	20	11-35-30	11-35-32	11-35-34				
	25	11-35-50	11-35-52	11-35-54				
	30	11-35-60	11-35-62					
	35	11-35-80	11-35-82					
	40	11-35-90	11-35-92					

Alte materiale la cerere

Gama PKS

(UT)



Stifturi (lise) conf. DIN ENISO13918

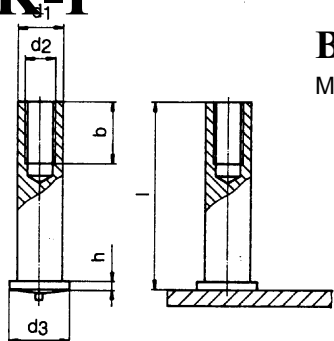
Material: oțel S235 J2G3+C450 (St 37-3K) cuprat electrolitic
Alte materiale la cerere

$d_1 \pm 0,1$	3	4	5	6	8
$d_3 \pm 0,2$	4,5	5,5	6,5	7,5	9,0
h	0,7-1,4	0,7-1,4	0,8-1,4	0,8-1,4	0,8-1,4

d1	l	Art. Nr.			Penseta		
		oțel clasa 4.8			PK 02	PK 200 E	PK 300
Ø 3	8	11-40-20			20-03-00	20-43-00	21-55-00
	10	11-40-30					
	12	11-40-40					
	16	11-40-50					
Ø 4	8	11-50-10			20-05-00	20-23-00	21-55-01
	10	11-50-20					
	12	11-50-30					
	16	11-51-00					
	20	11-50-50					
	40	11-51-40					
Ø 5	8	11-60-00			20-06-00	20-25-00	21-55-02
	10	11-60-10					
	12	11-60-20					
	16	11-62-00					
	20	11-60-40					
Ø 6	10	11-70-00			20-07-00	20-26-00	21-55-03
	12	11-70-10					
	16	11-71-20					
	20	11-70-30					
	25	11-70-40					
Ø 8	15	12-01-96			20-09-00	21-12-00	21-55-04
	16	12-07-91					
	20	12-01-99					
	25	12-02-00					

Gama PK-I

(IT)



Buce filetate conf. DIN ENISO13918

Material: oțel S235 J2G3+C450 (St 37-3K) cuprat electrolitic
Alte materiale la cerere

d_2	M 3	M 4	M 5
$d_1 \pm 0,1$	5	6	7,1 (Ø)
$d_3 \pm 0,2$	6,5	7,5	9,0
h	0,8-1,4	0,8-1,4	0,8-1,4
$b_{min.}$	5	6	8

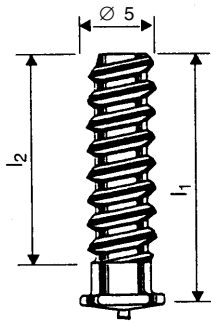
d2	l	Art. Nr.			Penseta		
		oțel clasa 4.8	1.4301/1.4303	Al Mg 3	PK 02	PK 200 E	PK 300
M 3	10	11-84-10	11-84-12		20-07-00	20-26-00	21-55-03
	12	11-83-50					
	15	11-81-60	11-81-62	11-81-64			
	20	11-84-20	11-84-22				
M 4	10	11-91-10	11-91-12		20-07-00	20-26-00	21-55-03
	12	11-90-30					
	15	11-90-80	11-90-82				
	20	11-91-00	11-91-02				
	25	11-90-70					
	* 15			11-93-44			
* 20			11-93-54				
M 5	12		11-98-02		20-08-00	21-27-00	21-55-07
	15		11-98-12	11-98-14			

*D1 = 7,1

Gama PK-Z

Bolturi speciale filetate (filet brad)

Material: otel S235 J2G3+C450 (St 37-3K) cuprat electrolitic
otel inox 1.4301 / 1.4303

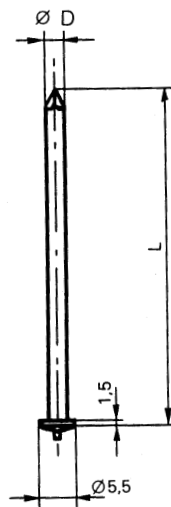


l_1 [mm]	l_2 [mm]
9	6
10	7
12	9
14,2	7,5
14,2	11
16	13
16,5	13,5
18,2	15
20	17
25	9
25	22
30	27

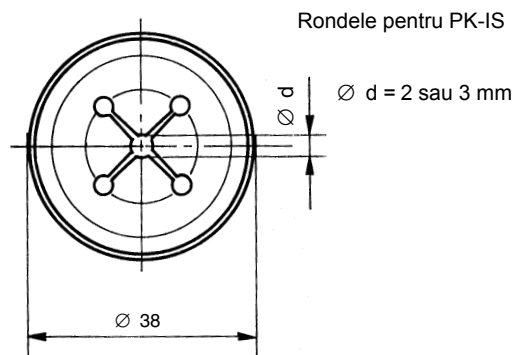
Gama PK-IS

Pini pentru izolatii

Material: otel S235 J2G3+C450 (St 37-3K) cuprat electrolitic
otel inox 1.4301



Ø D	L										
	20	30	40	50	60	80	100	150	200	250	
2											
3		25	30	40	50	60	80	100	150	200	250



Gama PK-K

Contacte sudate

Material: OTEL S235 J2G3+C450 (St 37-3K)

Cuprat electrolitic

Otel inox

Aliaj aluminiu

Contacte duble la cerere

