



## UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN 23 S**

PATTERN: AWS RB Cu  $\text{Zn-D}$

Application Field	ESSEN 23 S is a special small rod covered with alpaca, universally used in production and maintenance. Ideal for structural assembly and hospital utensils and pipeline steel furniture. In construction and assembly of karts, motorcycles, bicycles, etc. In maintenance it is used to retest and reconstruct gear teeth, valves, axles, auto-wagons, muffers, escapes, applied in unions of ribbon saw, steel metal sheets, prolong augers or flutes. Fix pastilles of hard metal.					
Technical Characteristics	Special alloy like red-hot with high fluidity, resistance. Developed for production and maintenance of top and overlaid junctions, the use of flux ESSEN 23 is indispensable.					
Indicated to Basis Metals	Steel: Laminated - Forged – Inoxidable Iron: Laminated – Fused – Galvanized					
Mechanical Proprieties	Traction Resistance: 80 kg/mm <sup>2</sup> Extension (L 5d): 25% Hardness: 160 HB Electrical Resistance: 5m p/mm <sup>2</sup> Specific Weight: 8,7					
Operational Characteristics	For process – <b>Oxi-Acetic</b>					
	Welding position: Plain					
	Ø In mm	1,50x500	2,00x500	2,50x500	3,25x500	4,00x550
Welding Techniques	Clean the area to be welded in small thin metal sheets ESSEN 23 S =. Covered can be applied directly, because the flux covering the same is enough to disoxide the welding place. Bigger parts, even using the covered small rod must add the flux ESSEN 23 S to help disoxidizing the welding area. Heat the part indirectly, the torch flame carbonize the flux, obstructing the fluidity.					