



**UNIWELD IND. DE ELETRODOS LTDA**

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COMERCIAL DESIGNATION: **ESSEN 80**

PATTERN: SPECIAL PRODUCT

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr
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APPLICATION FIELD	Electrode manufactured by Uniweld Ind. De Eletrodos Ltda with exclusivity all over Brazil. It is an electrode projected and developed to bobbins surfaces treatments in sugar mills. This projection aims the increasing on the production, becoming rough the soft rolls in sugar mills, overcoming the job loss resultant. It produces a humidity reduction and a drop on the POL. The drop on the sacarosis residual percentage is extremely significant, where it is contacted the drop from 5 to 2. It produces a substancial economy, because it is only a drop of one digit what is approximatedly 1 kg of extra sugar per ton of suggar cane crushed. The ESSEN 80 is applied in 100% of suggar mills in Brazil, including the indication tecniques made by Copersucar				
TECHICAL CHARACTERISTICS	The ESSEN 80 is deposited while the rolls are rotating. It means more economy, because it is not necessary stops, it is not necessary chevrons. The wastage on the rools decrease in 30%. The deposition of chrome carbides in globules in flanks and friezes become highly wrinkled, working in low amperage, without suffering any kind of change in its revestment				
MECHANICAL PROPRIETIES	Hardness: 50-60 RC				
OPERATIONAL CHARACTERISTICS	For C.C.+				
	Welding Position: P.V.				
	Ø In mm	3,25X350 mm	4,00X450mm	5,00X450mm	6,00X450mm
Amperage	110-120A	120-130A	150-170A	190-210A	
Package	16 kg	20 kg	20 kg	20 kg	
WELDING TECHNIQUES	An important factor to obtain the maximum efficiency of the product is the consumption time of each electrode, which the ideal indication is from 3 to 4 minutes for each small rod. An excessive amperage will bring the sensation that the electrode is softer and consequently there will be a higher consumption of this electrode with low efficiency in this product, because there will be a lower quantity of globules deposited. A very low amperage will promote a longer electrode's consumption period with low efficiency in this electrode				