



**UNIWEELD IND. DE ELETRODOS LTDA**

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COMERCIAL DESIGNATION: **ESSEN A 6**

PATTERN: SPECIAL PRODUCT

Elementos de Liga Contido	Si	Fl	Ti	Zn	Mn	Cu	Al
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APPLICATION FIELD	ESSEN A 6 is a special aluminium electrode, applied not only in production but also in maintenance. Ideal in production of bus-waggons, internal combustion motors cages, pipelines and squadrons arming, sections, doors and windows, ladders, recipients, pipelines, electrical circuit borders. Good corrosion and traction resistance.				
TECHNICAL CHARACTERISTICS	The electrode ESSEN A 6 specially extruded with aluminium and <b>silicon</b> to be applied in continuous current on the positive pole, purposed to aluminium weldings and its alloys. Indicated to Basis Metals: Aluminium: Laminated Aluminium: Fused Aluminium: Extruded Aluminium: Injected				
MECHANICAL PROPRIETIES	Traction Resistance: 20-24 Kg/mm <sup>2</sup> Elasticity Limit: 9 Kg/mm <sup>2</sup> Extension: L = 5 d. : 3%				
OPERATIONAL CHARACTERISTICS	For: C.A or C.C-				
	Welding position: H.				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00x350mm
Amperage Package	60-100 A 5 kg	80-120 A 5 kg	100-140 A 5 kg	120-160 A 5 kg	
WELDING TECHNIQUES	Clean the area for mechanical processes, do not use sandpaper or emery. Prepare the junction, chamfer the parts with thickness higher than 4,00mm, do not leave gaps, a pre-heat of 150-200C is advised. Due to the special and resistant elements which composes the covering, the higroscopicity is reduced to the minimum allowing a prolonged storage.				