



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN CAST 55 HL**

PATTERN: AWS E NI 7E CL

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Ni	Fe
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APPLICATION FIELD	Iron-Nickel electrodes, indicated for welding gray fused iron, modular and fused iron connected. It can be used for dissimilar weldings among fused iron, low alloy carbon steel and not ferrous, it is pointed out for its high efficiency and is also indicated for filling up and recovering fusing fails.				
MECHANICAL PROPRIETIES	Traction Resistance: 480 MPA Extension: 15% Hardness brinel: 220HB				
OPERATIONAL CHARACTERISTICS	For C.A or C.C-				
	Welding Position: ---				
	Ø In mm	2,50x350mm	3,25x350m	4,00x350mm	5,00x350mm
Amperage Package	60-80 A 5 kg	90-120 A 5 kg	120-140 A 5 kg	140-160 A 5 kg	
WELDING TECHNIQUES	Clean the area to be welded, removing oil, grease, rustiness, etc. Use always the smallest possible electrode's diameter to avoid super heat of the part. Weld with short arch, small and alternating strings. Hammer each string while it is hot to avoid contraction.				