



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN CAST 99**

PATTERN: AWS E Ni cI

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Ni	
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APPLICATION FIELD	The ESSEN CAST 99 is indicated for fused iron, gray, nodule and soft welding, as well as filling up pumping out surfaces, fusion fails or filling up welded junctions in pair with ESSEN CAST 55 or ESSEN CAST GH. This electrode is also indicated for fused iron union and other materials like: steel, fused steel, copper, monel, etc.				
TECHNICAL CHARACTERISTICS	The ESSEN CAST 99, is an electrode with pure nickel soul and grafit covering with a balanced and perfect formulation, allowing its use in all welding positions, without occurrence of pores or bites. The arch is stable and the deposited metal is ductil, allowing dilatation and contraction of the basis metal, avoiding scratches occurrence. Another important characteristic of the deposit is that there is no carbides formation, turning it easily to factoring.				
OPERATIONAL CHARACTERISTICS	For C.A or C.C-				
	Welding Position: P.V.S.				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00x350mm
	Amprage	50-70 A	70-100 A	90-130 A	120-150 A
Package	5 kg	5 kg	5 kg	5 kg	
WELDING TECHNIQUES	Clean the area to be welded, removing the oxides, incrustations, oil, grease, etc. If possible, heat the parts which are very contaminated with oil in 400°C and keep in this temperature until the end of the volatilization process. In case of scratches, take them out using mechanical resources, avoiding super heating. Cold welding. Keep the arch short and deposit alternating strings with maximum lenght of 10 x the electrode's diameter. Control the temperature in 80°C. By the end of each string welding, hammer it softly in the same welding position and just once, using the ball hammer.				