



**UNIWELD IND. DE ELETRODOS LTDA**

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COMERCIAL DESIGNATION: **ESSEN CAST GH**

PATTERN: AWS E ST

ALLOY ELEMENTS INCLUDED	C	Si	Mn	P	S
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APPLICATION FIELD	Special electrode for cold fused iron welding, indicated to recover small fusion fails, revestments, and as pillow layers in fused iron is a hard welding. Deposit is not for factories. The ESSEN CAST GH must not be used for union weldings, except in pillow layers. It is also indicated for welding crest basis in friezes in the suggar mill bobbins.				
OPERATIONAL CHARACTERISTICS	For C.A or C.C-				
	Welding Position: ---				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00x350mm
	Amperage	60-80 A	90-120 A	120-140 A	140-160 A
Package	5 kg	5 kg	5 kg	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.				