



UNIWELD IND. DE ELETRODOS LTDA

Address: 1788, XV de Dezembro Avenue – Tanque do Moinho
 Zip Code: 12.910-691 – Bragança Paulista – São Paulo – Brazil
 Phone: (+55 11) 4035-8877 – Fax: (+55 11) 4603-2511
 E-mail: uniweld@uniweld.com.br
 Website: www.uniweld.com.br

Contact Uniweld

(+55 11) 4035-8877

sales@uniweld.com.br

COMERCIAL DESIGNATION: ESSEN CCR 70				
PATTERN: SPECIAL PRODUCT				
ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr

APPLICATION FIELD	Welding steel that work with high resistance to abrasion wastage. Its utilisation has a large sclae of applications in equipments repairing industries which work in mining and components revestments of machines used in civil construction and agriculture. Examples: Earth-mover, charcoal extractors, guides surfaces, parts with exigence of abrasive jobs with temperatures up to 600°C.			
TECHICAL CHARACTERISTICS	The welding metal produced by this electrode corresponds to those chrome steel with high carbon tenor. Its micro structure is constituted by complex carbides of chrome and tungstenium over a matrix austenitics. The hardness of the deposit increases with the carbon tenor, but can not be increased by thermic treatment. The susceptibility to scratches can be reduced by pre-heating or post-heating.			
MECHANICAL PROPRIETIES	Hardness: 57 a 62 HRc Working Temperature: up to 500°C			
OPERATIONAL CHARACTERISTICS	For C.C./C.C.-			
	Welding Position: Plain			
	Ø In mm	2,50x350mm	3,25x350mm	4,00x450mm
Amperage	70-90 A	110-150A	140-180 A	170-230 ^a
Package	5 kg	5 kg	5 kg	5 kg
WELDING TECHNIQUES	Clean and brush the area to be welded. The electrode during the welding process must be inclined 90°C in accordance to the part, with a tolerance of maximum 10°. When this electrode is used for filling up another layer, it is recommended to remove and brush the scoria before starting the welding process. Use the amperage in the medium value. Weld pulling the electrode in straight line (without refusion). Use the welding parameters correctly			

--