



**UNIWEELD IND. DE ELETRODOS LTDA**

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COMERCIAL DESIGNATION: **ESSEN CN 29/9 KB**

PATTERN: AWS E 312-15

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	The CN 29/9 KB is an electrode austenitic-ferritic with very high traction resistance, arch opening easily, soft deposit and without sparkling, resistant to scratches and easy scoria removal. Ideal for junctions of steel with unknown composition or like pillow for hard revestment. Dissimilar steel junctions, moles, crane rails, gearing's teeth reconstruction in steel, pinion, link of chains and molds. Screw extraction, laminator, axles reconstructions, etc.				
TECHICAL CHARACTERISTICS	The electrode CN 29/9 KB was developed in Brazil to become the most useful tool in maintenance, steel welding with unknown composition. Tools Steel: Steel with low, medium and high alloy. Fused Steel: Manganese steel, chrome steel, stainless steel.				
MECHANICAL PROPRIETIES	Traction Resistance: 80-88 N/mm > 785N/mm <sup>2</sup> Elasticity Limit: 30-35 N/mm <sup>2</sup> > 588N/mm <sup>2</sup> Extension L = 5 d.%: 20-30% Resilience Kpm/cm <sup>2</sup> : D.V.M. 7-10 41J Brinel Hardness: 200-250HB				
OPERATIONAL CHARACTERISTICS	For C. A or C.C +.				
	Welding Position: P.V.S.				
	Ø In mm	2,00x300mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage	45-55 A	50-80 A	80-110 A	110-140 A	
Package	4 kg	5 kg	5 kg	5 kg	
WELDING TECHNIQUES	The parts must be cleaned without oil, grease or oxides, in junction welding, always use the electrode with the smallest diameter to reduce heating entrance, in pillow use electrode with the biggest diameter and interpolated passes to avoid super-heating. The junction preparation is done according to the thickness of the part.				