



UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN CN 31 HC Kb**

PATTERN: **A.W.S. E 310 H \neq 15**

Alloy Elements Included	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Special electrode indicated against corrosion wastages and it is resistant to working temperatures up to 1150°C. Specially indicated for welding and filling up in laminated cylinders, rails and support in high oven and turbines. Pelton, Kaplan, Francis.				
TECHICAL CHARACTERISTICS	In fused steel with thickness up to 20mm, it is recommended a pre-heating approximatedly 200°C, the deposit has structure austenitica. Ideal for junctions of manganese steel. DIN: ----- AISI: A 296- A 362- 351 - CRAU CK 20 A 297- A 362- ACI N° HK				
MECHANICAL PROPERTIES	Traction Resistance: 70-75 N/mm Elasticity Limit: 30-35 N/mm ² Extension L = 5 d.%: 20% Resilience Kpm/cm ² : D.V.M. 62-89J Brinell Hardness: 200				
OPERATIONAL CHARACTERISTICS	For C.A or C.C. +				
	Welding Position: P.V.S.				
	Ø In m/m e em	2,00x300mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage	45-55 A	50-80 A	80-110 A	110-150 A	
Package	4 kg	5 kg	5 kg	5 kg	
WELDING TECHNIQUES	Clean the area to be welded, determine the electrode's diameter in accordance with the part, adjust the amperage, keep the arch short, use stainless brush to clean and to restart the welding process.				