



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 CN 31 TI**

PATTERN: AWS E 310-16

| ALLOY ELEMENTS INCLUDED | C | Si | Mn | Cr | Ni | Mo |
|-------------------------|---|----|----|----|----|----|
|-------------------------|---|----|----|----|----|----|

| | | | | | |
|-----------------------------|---|------------|------------|------------|------------|
| APPLICATION FIELD | Special and basic electrode for welding steel with similar chemical composition, alloy 25Cr/20Ni. Deposit highly resistant to heat. Resistant to russetting formation in temperatures up to 1200°C. Indicated for welding oven parts, thermic fences and parts submitted to high temperatures in general. | | | | |
| TECHICAL CHARACTERISTICS | The deposited metal is austenitico, resistant to working temperatures of 1200°C and tenacity to cooling of -195°C. Ideal for welding steel when we do not have the material composition. | | | | |
| MECHANICAL PROPRIETIES | Traction Resistance: 570-665 Elasticity Limit: 343 N/mm ² Extension L = 5 d. %: 30% Resilence Kpm/cm ² : D.V.M. 8-12 55-83J Brinel Hardness: 150-190HB | | | | |
| OPERATIONAL CHARACTERISTICS | For C.C.+ C. A. | | | | |
| | Welding Position: P.V.S | | | | |
| | Ø In mm | 2,50x350mm | 3,25x350mm | 4,00x350mm | 5,00x350mm |
| Amperage | 60-80 A | 85-11 A | 110-140 A | 140-180 A | |
| Package | 5 kg | 5 kg | 5 kg | 5 kg | |
| WELDING TECHNIQUES | As in all welding processes, the quality of the deposits vary according to the welder experiences and skills. The cleanness and the junction preparation to handle the electrode, regulate the amperage. Use the electrode very dry, use stainless brush to clean and to restart the welding process. | | | | |