



**UNIWELD IND. DE ELETRODOS LTDA**

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COMERCIAL DESIGNATION: **ESSEN CN 33 KB**

PATTERN: AWS E 330=15

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni	Mo
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APPLICATION FIELD	Special electrode with basic revestment, indicated for welding steel like 15Cr/35Ni, ASTM HT and HT 30. Its deposit is resistant to heat and russetting formation up to 1100°C. Indicated for welding parts submitted to impetuous temperatures variations. Must avoid prolonged exposition in sulphoric areas.					
MECHANICAL PROPRIETIES	Traction Resistance: mín. 520 RT (MPa)					
OPERATIONAL CHARACTERISTICS	For C.C +					
	Welding Position:					
	Ø In mm	3,25x350mm	4,00x350mm			
	Amperage Package	90-110 A 5 kg	120-140 A 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 part preparation on the amperage regulation to apply the electrode with smallest diameter, reducing the minimum heating of the part. Use stainless brush to clean and to restart the welding process.					

