



UNIWEELD IND. DE ELETRODOS LTDA

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Comercial Designation: **ESSEN CN 36 L TI**

PATTERN: AWS E 316 L=16

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni	Mo
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APPLICATION FIELD	Special and rutilic electrode for steel Cr-Ni-Mo austenitic resistant to chemical substances. Specially for similar steel in equipments of textile, paper and cellulose, petro chemical and pharmaceutical, nutritive and hospital industries. It is not necessary an impetuous cooling after welding.				
TECHICAL CHARACTERISTICS	The deposits have low carbon, austenitic, resistant to temperatures of 300°C. An impetuous cooling after welding is not necessary. Indicated to basis metal: DIN: 1.4401 - 1.4404 - 1.4435 - 1.4436 AISI: 316 - 316 L				
MECHANICAL PROPRIETIES	Traction Resistance: min 490 N/mm ² Elasticity Limit: 32-42 Kp/mm ² 314 N/mm ² Extension L = e d% : 30-40 Resilience Kpm/cm ² : D.V.M 8-13 62-83 J Brinel Hardness: 160-190				
OPERATIONAL CHARACTERISTICS	For C.A or C.C +				
	Welding Position: PVS				
	Ø In m/m	2,00x300mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage Package	35-55 A 4 kg	50-80 A 5 kg	70-110 A 5 kg	110-140 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.				