



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN CN 37 Kb**

PATTERN: AWS E 307-15

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

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|-----------------------------|--|------------|------------|------------|------------|
| APPLICATION FIELD | Basic electrode with connected soul, indicated for unions of stainless steel from the same class or similar steel with dissimilar steel. Filling up rails, bypasses and parts of machines in general. Ideal to recover cavitation damages in water turbines, with thickness up 12 mm. | | | | |
| TECHICAL CHARACTERISTICS | The deposited metal is austenitico and resistant up to 850°C and to sea water corrosion with excellent characteristic of becoming hard in cold. Benefaction steel with and without alloy highly resistant, steel Cr, stainless manganes steel and non magnetized steel. | | | | |
| MECHANICAL PROPRIETIES | Traction Resistance: 590-685 N/mm Elasticity Limit: 295-340 N/mm ² Extension L = 5 d.%: 35 Resilience Kpm/cm ² : D.V.M. 14-16 62-83 J Brinel Hardness: 200 | | | | |
| OPERATIONAL CHARACTERISTICS | For C.C + | | | | |
| | Welding Position: P.V.S | | | | |
| | Ø In mm | 2,00x300mm | 2,50x350mm | 3,25x350mm | 4,00x350mm |
| Amperage | 45-55 A | 65-80 A | 85-110 A | 110-140 A | |
| Package | 4 kg | 5 kg | 5 kg | 5 kg | |
| WELDING TECHNIQUES | The parts must be cleaned and free of contaminants, junsctions well prepared, in junctions use the smallest possible electrode's diameter, keeping the arch always short to reduce the heating entrance on the part. On the cleaning process and to restart welding, use only stainless brush, avoiding contamination on the welding string. | | | | |