



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 37 TI**

PATTERN: AWS E 307-16

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

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.				
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.				
INDICATED TO BASIS METAL	Benefaction steel with and without alloy highly resistant, steel Cr, stainless manganes steel and non magnetized steel.				
MECHANICAL PROPRIETIES	Traction Resistance: 590-685N/mm ² Elasticity Limit: 295-340N/mm ² Extension L = 5 d %: 35 Resilience Kpm/cm ² : DVM 14-16 62-83J Brinel Hardness: 200				
OPERATIONAL CHARACTERISTICS	For C.C. +				
	Welding Position: Welded in all positions				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00x450mm
Amperage Package	65-75A 5 kg	85-100A 5 kg	110-130A 5 kg	140-160A 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.				