



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN CN 38 H TI**

PATTERN: AWS E 308 H-16

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Special and rutilic electrode, indicated for welding similar steel composition like AISI 301, 320, 304, 305 and 308 with high tenor of C. Recommended for welding and construction of equipments and recipients for the chemical industry, textile, cellulose, etc.				
TECHICAL CHARACTERISTICS	The deposits are austeniticos, resistant to temperatures of 300°C an impetuous colling after the welding is not necessary. Indicated to basis metal: DIN: 1.4300 - 1.4301 - 1.4310 AISI: 301 - 302 - 304 -305 308				
MECHANICAL PROPRIETIES	Traction Resistance: mín. 550 RT (MPa)				
OPERATIONAL CHARACTERISTICS	For: C.A or C.C+				
	Welding Position:-----				
	Ø In mm	2,00x300mm	2,50x350mm	3,25x350mm	4,00x350mm
	Amperage	45-55 A	65-80 A	90-110 A	120-140 A
Package	4 kg	4 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 of the surface of the part, the junction preparation and to use the electrode with the smallest possible diameter, smaller possible amperage. Use stainless brush to clean and to restart the welding process.				