



UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN CN 38 L IG**

PATTERN: AWS ER 308 L

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Special wire and small rods of stainless steel with low carbon tenor, indicated in welding materials of similar chemical composition, for example, AISI 304 L. Its deposit is resistant to corrosion. Recommended to chemical and textile industries equipments.				
MECHANICAL PROPRIETIES	Traction resistance: mín. 520 RT (MPa)				
OPERATIONAL CHARACTERISTICS	For process TIG or MIG Small rods and Bobbins				
	Welding Position: -----				
	Ø In mm	0,80 MIG 1,60 Small Rod	1,00 MIG 2,40 Small Rod	1,20MIG 3,20 Small Rod	1,60MIG
Package	Bobbin 15-18 kg Small Rod 10kg	Bobbin: 15-18 kg Small Rod 10 kg	Bobbin: 15-18 kg Small Rod 10kg	Bobbin 15-18kg Small Rod 10kg	
WELDING TECHNIQUES	Remove the ink, grease, rudiness of the area to be welded, prepare the junction following the rules. Regulate the necessary flowing out gas, avoid oscilant movements (zig-zag) during the welding process so it will not fail to protect the arch when it touches the corners. Keep the torch in a correct distance in accordance to the chamfer. Regulate the fount according to the thickness of the part and the small rod. To stablish the arch use the copper plate, use CHEM-SHARP automatically to apoint the tungstenium electrode when it is operating with the TIG process.				

