



**UNIWEELD 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](mailto:uniweld@uniweld.com.br)  
 Website: [www.uniweld.com.br](http://www.uniweld.com.br)

**Contact Uniweld**

**(+55 11) 4035-8877**

[sales@uniweld.com.br](mailto:sales@uniweld.com.br)

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

PATTERN: AWS E 308 L-16

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	It is an electrode of stainless rutilic steel with low tenor of C for corrosion high resistant welding, applied in chemical, petro chemical, paper and cellulose, textile, and dyeing, pharmaceutical and hospital industries. Ideal for junctions of similar and dissimilar steel.				
TECHICAL CHARACTERISTICS	deposits are austeniticos, low carbon, 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: 530-630 N/mm Elasticity Limit: 345 N/mm <sup>2</sup> Extension L = 5 d. %: 35% Resilience Kpm/cm <sup>2</sup> : D.V.M. 8-13 69-89J Brinel Hardness: 160-200 HB				
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	5 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.				