



**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](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 39 KB**

PATTERN: AWS E 309-15

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Special and basic electrode, indicated for welding stainless steel submitted to severe conditions of corrosion. Indicated for union of dissimilar metal like for example, AISI 304 with the carbon steel. There is also big applications in clade of carbon steel, like in pressure vases, heat exchanger, etc.				
TECHICAL CHARACTERISTICS	Traction Resistance: 539 N/mm Elasticity Limit: 314 N/mm <sup>2</sup> Extension L = 5 d. %: 35% Resilience Kpm/cm <sup>2</sup> : D.V.M. 6-10 62-89J Brinel Hardness: 200 HB Welding Position: P.V.S				
MECHANICAL PROPRIETIES	Traction Resistance: mín. 550 RT (MPa)				
OPERATIONAL CHARACTERISTICS	For C.C +				
	Welding Position: -----				
	Ø em 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.				