



UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN CN 39 L TI**

PATTERN: AWS E 309 L-16

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Application Field: The deposit of this electrode dispenses the thermic treatment after welding. In case that the metal thickness or its composition demands a pre-heating, it must not exceed 300°C. Ideal for resistant deposits against combustion of reduction gases.				
TECHICAL CHARACTERISTICS	The deposit of CN 39 L TI is austenitico. Ideal for connections with connected steel or without alloy manufactured of "Clad". DIN: 1.4742 - 1.4826 -1.4828 AISI: 302b - 309 - 309 S – 403 -410 - 416 -431 -405 -430 -430 F- 446				
MECHANICAL PROPRIETIES	Traction Resistance: 539 N/mm Elasticity Limit: 314 N/mm ² Extension L = 5 d.%: 35% Resilience Kpm/cm2 : D.V.M. 6-10 62-89J Brinel Hardness: 200 HB Welding Position:P.V.S				
OPERATIONAL CHARACTERISTICS	For C.A or C.C.+				
	Welding Position:P.V.S				
	∅ In mm	2,00x300mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage	45-55 A	65-80 A	85-110 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 and the junction preparation to handle the electrode, regulate the amperage using the electrode with the smallest possible diameter to avoid the super heat of the part, using stainless brush to clean and to restart the welding process.				