



## UNIWELD IND. DE ELETRODOS LTDA

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## Contact Uniweld

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

PATTERN: AWS E 309 Mo-16

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Electrode of rutile stainless steel, appropriated to connection in similar refractory steel or alloys of Cr – Ni or no alloy steel. Ideal for welding interlayers in plate “CLAD”.				
TECHICAL CHARACTERISTICS	Ideal for jobs that require resistance against reduction gases of sulphur and temperatures up to 1.000°C. Indicated to basis metal: Din: 1.4742 – 1.4826 – 14828. AISI: 302B – 309 – 309S – 403 – 405 – 410 – 416 – 430 – 446.				
MECHANICAL PROPRIETIES	Traction Resistance: 590- 685 N/mm <sup>2</sup> Elasticity Limit: 345 N/mm <sup>2</sup> Extension L=5 d. % : 35 Resilience Kpm/cm <sup>2</sup> : D.V.M. 9-13 62-89J				
OPERATIONAL CHARACTERISTICS	For C.C.+ or C.A.				
	Welding Position: P.V.S.				
	∅ In mm	2,00x350mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage	45-55 A	65-80 A	85-110 A	115-140 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. Use the electrode very dry, use stainless brush to clean and to restart the welding process.				