



UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN Cr 41 Mo KB**

PATTERN: AWS E 410 Ni Mo=15

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Special basic electrode indicated for welding fused steel and stainless martensilicos for work temperatures up to 450°C and for construction and maintenance of hydroelectrical turbines.				
TECHICAL CHARACTERISTICS	In interconnections it is advised a pre-heating of 200°C and accepts overcooking in 700-800°C avoiding severe structure and obtaining a good ductibility in the deposited metal. Indicated to basis metal: DIN: 1.400- 1.4001- 1.4002- 1.4006- 1.4021- 1.4024 AISI: 403- 410- 416				
MECHANICAL PROPRIETIES	Traction Resistance: min. 486 N/ mm Elasticity Limit: 40-50 Kp/mm 392N/mm Extension L = 5 d.%: 29 Brinel Hardness = 350				
OPERATIONAL CHARACTERISTICS	For C.C.+				
	Welding Position: P.V..				
	∅ In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00,x450mm
Amperage Package	65-80 A 5 kg	90-110 A 5 kg	120-140 A 5 kg	160-180 A 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 part preparation on the amperage regulation to apply the electrode with smallest diameter, reducing the minimum heating of the part. Use stainless brush to clean and to restart the welding process.				