



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN Cr 43 KB**

PATTERN: AWS E 430=15

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Special basic electrode indicated for welding stainless martensitic-ferritic steel and for filling up draining surfaces in carbon steel or low alloys. Good performance in working temperatures up to 450°C.				
MECHANICAL PROPERTIES	Traction Resistance: min. 450 RT (MPa)				
OPERATIONAL CHARACTERISTICS	For C.C.+				
	Welding Position: P. V.				
	∅ In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00,x350mm
	Amperage Package	65-80 A 5 kg	90-110 A 5 kg	120-140 A 5 kg	160-180 A 5 kg
WELDING TECHNIQUES	Prepare the area to be welded, clean well, regulate the amperage according to the recommendations in accordance with the size of the part and electrode's diameter, establish a short arch, keep the electrode perpendicular to the part. Depending on the shape and thickness of the part, the steel martensitic and pre-ferritic must be pre-heated in 250°C.				