



UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN Cr Mo 9 IG**

PATTERN: AWS ER 505

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Mo
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APPLICATION FIELD	Application Field: Wire or small rod specially coppered to be used in the TIG or MIG processes in junctions of high responsibility, construction of vapour boilers, pression reservatories and pipelines, for working temperature up to 500°C. Apllied in industrial assemblies, petro chemicals, paper and cellulose, chemicals, pharmaceutical and frigorificals and metallurgicals. Indicated for steel welding with 9% of Cr and 1% of Mo.				
TECHNICAL CHARACTERISTICS	The deposited metal is resistant to salty water, leach, high temperature oxidation, growing old resistance, with great X ray quality for both TIG and MIG processes.				
MECHANICAL PROPRIETIES	Traction resistance: min. 420 RT (Pa)				
OPERATIONAL CHARACTERISTICS	For process TIG or MIG		Small rods and bobbins		
	Welding Position: -----				
	Ø In mm	0,80 MIG 1,60 Small Rod	1,00 MIG 2,40 Small Rod	1,20MIG 3,20 Small Rod	1,60MIG
Package	Bobbin 15-18 kg Small Rod 10kg	Bobbin: 15-18kg Small Rod 10kg	Bobbin: 15-18kg Small Rod 10kg	Bobbin 15-18kg Small Rod 10kg	
WELDING TECHNIQUES	Remove the ink, grease, rudiness of the area to be welded, prepare the junction following the rules. Regulate the necessary flowing out gas, avoid oscilant movements (zig-zag) during the welding process so it will not fail to protect the arch when it touches the corners. Keep the torch in a correct distance in accordance to the chamfer. Regulate the fount according to the thickness of the part and the small rod. To stablish the arch use the copper plate, use CHEM-SHARP automatically to apoint the tungstenium electrode when it is operating with the TIG process.				