



UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN DUR 350 KB**

PATTERN: DIN 8555 E 1=350 GP

| ALLOY ELEMENTS INCLUDED | C | Si | Mn | Cr | Mo |
|-------------------------|---|----|----|----|----|
|-------------------------|---|----|----|----|----|

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|-----------------------------|---|-------------------|-------------------|-------------------|------------|
| APPLICATION FIELD | Electrode DUR 350 kb is used with success in restorations in general, resistant to metal friction with against-metal, rollings, link, bombs framework, loading shovels, tractor roofing course, gearing teeth, waggon wheels, rolling bridges wheels, axles, matrix, wheel teeth, tractor bracket, guide wheels, tools to perforate wells, drag buckets | | | | |
| TECHNICAL CHARACTERISTICS | DUR 350 KB is an electrode for hard revestments, developed in Brazil by UNIWEELD and applied for restoration and protection filling up to wastage, abrasion, its deposit has excellent resistance to medium impact. Indicated to basis metal: Fused steel, railway steel, temperad steel, steel tools to work in cooling jobs. | | | | |
| MECHANICAL PROPRIETIES | Hardness :350 HB Treatment: 500°C Working Temperature: 920°C in water or oil | | | | |
| OPERATIONAL CHARACTERISTICS | For C.A. or C.C + | | | | |
| | Welding Position: P.V | | | | |
| | Ø In mm | 2,50x350mm | 3,25x350mm | 4,00x450mm | 5,00x450mm |
| Amperage Package | 70-110 A 5 kg | 110-130 A 5 kg | 130-150 A 5 kg | 150-205 A 5 kg | |
| WELDING TECHNIQUES | Clean the area to be welded, keep a short arch, the electrode must be very dry, conducted with quick oscillating movements, the steel parts of any size can be revested without pre-heating, the hard steel parts, depending on the thickness must be pre-heated between 100-200°C. | | | | |