



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN DUR 45 TI**

PATTERN: SPECIAL PRODUCT

ALLOY ELEMENTS INCLUDED	C	Cr	Mo	Mn	Si
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APPLICATION FIELD	The application of this electrode is ideal to revestments which must resist to humid abrasion from moderate to strong impacts. It is applied the electrode ESSEN DUR 45 TI, mainly in hammers, hammer mills and hard revestments on the manganes which did not become hard. The hardness of 45HRc, will protect the manganes of premature wastage by abrasion. It is possible to apply 2-3 layers without scratches risk.				
TECHNICAL CHARACTERISTICS	The ESSEN DUR 45 TI is a product specially developed for hardness of 45 HRc. Despite having high tenor of Cr and C, it is not classified as an electrode of chrome carbide composition. Not being chrome carbide, its compositions allows high impact and high resistance in humid places. This special electrode, is detached, by its special characteristic of welding out of the position, the only one in its gender in the market				
MECHANICAL PROPRIETIES	Hardness: 44-46 HRc				
OPERATIONAL CHARACTERISTICS	For C.A. or C.C-				
	Welding Position: Welded in all positions.				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x450mm	5,00x450mm
Amperage Package	70-110A 5 kg	110-140 A 5 kg	140-170 A 5 kg	170-210 A 5 kg	
WELDING TECHNIQUES	It is welded the electrode ESSEN DUR 45 TI with the electrode perpendicular with regards to the basis metal, short arch, without pre-heating, in strings of 80-100mm. Interpellate maximum 200°C, the electrode oscillation, during the welding must not exceed three times its diameter. Do not hammer the welding deposit. In deposits where the area is bigger, must be welded in turns, to reduce the risk of transversal scratches.				