



## UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN DUR 650 KB**

PATTERN: DIN 8555 E 6=60 G

Alloy Elements Included	C	Si	Mn	Cr	Mo
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APPLICATION FIELD	The electrode DUR 650 Kb, allows the deposition with exceptional resistance against metal and against –metal abrasion in manufacturing and restauration of parts with prolonged useful life. In parts which need to receive high polishment, like rolling roads, axle extremity, crankshaft, friction fork, break balance, cutting and strain tools, impressions, matrix, buckets, drags, percussion drills, charcoal extractors, rolling mills brake				
TECHNICAL CHARACTERISTICS	The electrode DUR 650 KB is an electrode for hard revestments developed in Brazil by UNIWEELD applied on abrasion wastages resistance and metal against metal friction. Its deposit is homogeneous and provides maximum utilisation. Free of sparkling and pores, accept high polishment. Hardness 60-62RC. Indicated to basis metal: Manganes steel, fused steel, tools steel, forged steel, laminated steel.				
MECHANICAL PROPRIETIES	Factored with <b>tipped</b> tool: When it is hot, up to 400°C Treatment: Overcooking and temperature 900-920°C in oil Working Temperature: up to 400°C				
OPERATIONAL CHARACTERISTICS	For C.A. or C.C +				
	Welding Position: P.V				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x450mm	5,00x450mm
Amperage	70-90 A	90-120 A	120-160 A	160-200 A	
Package	5 kg	5 kg	5 kg	5 kg	
WELDING TECHNIQUES	Clean the area to be revested, lower at least 2mm the area to be rebuild, use only electrodes very dry, clean powerfully each deposited pass, do not overload the electrode with excessive amperage, hot deposits in 400°C are factored with tipped tool.				