



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN DUR 700**

PATTERN: SPECIAL PRODUCT

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr
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APPLICATION FIELD	Electrode with basic revestment, high tenor of chrome carbides, for revestigments welding, presenting high abrasion resistance with moderate shocks. Specially developed for stones mining, sand, calcareous rocks, charcoal, and in covering again and prevention maintenance of austenitic and manganese steel parts.				
TECHNICAL CHARACTERISTICS	The revestment of the electrode ESSEN DUR 700 with high efficiency, has characteristics of abrasion resistance in airscrew transportation, guide surfaces, gum buckets, earth mover machines and all manganese steel parts, the deposited metal is auto tempered.				
MECHANICAL PROPRIETIES	Hardness: 57-60 HRc Treatment: Overcooling and temperature 900-920°C in oil Working Temperature: up to 500°C				
OPERATIONAL CHARACTERISTICS	For C.A. or C.C +				
	Welding Position: P.V				
	Ø In mm	3,25x350mm	4,00x350mm	5,00x450mm	6,00x450mm
Amperage	90-120 A	120-160 A	160-200 A	200-240 A	
Package	5 kg	5 kg	5 kg	6 kg	
WELDING TECHNIQUES	The application characteristic of the electrode ESSEN DUR 700 are similar to the common electrodes. Keep the arch as short as possible. The electrode must be deposited in an angle of 90°C. The scoria fusion facility allows a wide textile of the passes. Do not overload the electrode with excessive amperage. A quick inclination can provoke the burn of its alloys elements, enclosed on the revestment.				