



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN DUROWELD 421**

PATTERN: Produto Especial

ALLOY ELEMENTS INCLUDED	C	Cr	Mn	Si	Co	
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APPLICATION FIELD	Special electrode indicated to forge hammers' recovery and printing impressions. It has a high resistance to high temperatures. Its advantage is in its factory deposit (220HB), becoming hard later in hot or cold jobs, reaching the hardness of 350HB					
MECHANICAL PROPRIETIES	Hardness: 220-350 HB					
OPERATIONAL CHARACTERISTICS	For: CC +					
	Welding Position: Plain					
	Ø In mm	4,00x350mm	5,00x350mm			
	Amperage Package	150-170 5 kg	180-200 5 kg			
WELDING TECHNIQUES	Cleanness of the area is indispensable and essential to keep the extension of the arch always short, not to overload the electrode with excessive amperage, welding only when the electrode is very dry, prepare the junctions following the rules, thickness superior to 350mm, must be chamfered.					