



## UNIWELD IND. DE ELETRODOS LTDA

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## Contact Uniweld

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COMERCIAL DESIGNATION: **ESSEN DUROWELD N**

PATTERN: AWS E Co Cr – C – Stellite 1

ALLOY ELEMENTS INCLUDED	C	Cr	W	Si	Ni	Co
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APPLICATION FIELD	Special small rods of cobalt, for surface coverings, pumping out, specially indicated to exposed revetments and high abrasion with elevated temperatures. It is applicable in most of steels. Ideal in rubber industries to revet bambories components, and also in automotive, aeronautics, atomic spacial, naval petro chemical, chemical, paper, cellulose, mining, metallurgical, lamination, forging, ceramic, woodwork, nutritive, hydro and thermo electrical. Pointing out in woodwork in welding saw's teeth				
TECHNICAL CHARACTERISTICS	Deposit values of high cobalt, resistant to corrosion, heat and thermic shock, associated to high tenacity. These are small rods fused and rectificated one by one. The nude small rods are used in the oxi-acetilenic or TIG processes. Resistant to job temperatures up to 600°C with excellent welding and resistance, its deposits bright and accept high polish				
MECHANICAL PROPRIETIES	Hardness: 54-58 HRC				
OPERATIONAL CHARACTERISTICS	For oxi-acetilenic or TIG				
	Welding Position: Plain				
	∅ In mm	3,00x350mm	4,00x350mm	5,00x350mm	6,00x350mm
Amperage Package	80-110 A 5 kg	130-160 A 5 kg	150-190 A 5 kg	180-220 A 5 kg	
WELDING TECHNIQUES	Clean and ungrease the area to be revested removing any vestigie of old revestments or hard surfaces. In case it is necessary to obtain pure deposits, apply at least three passes, with the minimal possible intensity in amperage, to get the mentioned hardness. It is recommended a pillow, depending on the basis metal, applied in ESSEN CN 31 TI or DUR 650 KB to avoid pores or scratches, recommending a pre-heat of 300°C and a slow post-cooling.				