



## UNIWEELD IND. DE ELETRODOS LTDA

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## Contact Uniweld

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COMERCIAL DESIGNATION: **ESSEN DUROWELD SN TI**

PATTERN: AWS E Co Cr – B – Stellite 12

ALLOY ELEMENTS INCLUDED	C	Cr	W	Ni	Si	Co
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APPLICATION FIELD	Special electrode with high cobalt, for surface coverings, pumping out, specially indicated to exposed revestments 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. Resistant to job temperatures up to 600°C with excellent welding and resistance, its deposits bright and accept high polish.			
MECHANICAL PROPRIETIES	Hardness: 51-54 RC			
OPERATIONAL CHARACTERISTICS	For: C.A or C.C-			
	Welding Position: Plain			
	Ø In mm	3,00x350mm	4,00x350mm	5,00x350mm
Amperage	80-110 A	90-130 A	120-150 A	
Package	5 kg	5 kg	5 kg	
WELDING TECHNIQUES	Clean and ungrease the area to be reveted removing any vestigie of old revetments 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.			