



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN DUROWELD SN**

PATTERN: AWS E Co Cr – B – Stellite 12

ALLOY ELEMENTS INCLUDED	C	Cr	W	Ni	Si	Co
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APPLICATION FIELD	Special small rods with high cobalt, for surface coverings, pumping out, specially indicated to gas pipelines, vapour and acids, submitted by hot, corrosion and wastage. Ideal to revet knives and tools, for paper and cellulose industries, drawer valves for the chemical industries, explosion engine valves, where the hardness is essential in high temperatures.					
TECHICAL CHARACTERISTICS	Deposit values of high cobalt, resistant to heat and thermic shock, associated to high tenacity. These are small rods fused and rectificated to be used by 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: 51-54 HRc					
OPERATIONAL CHARACTERISTICS	For oxi-acetilenic or TIG					
	Welding Position: Plain					
	Ø In mm	3,00x350mm	4,00x350mm	5,00x350mm		
	Amperage Package	80-110 A 5 kg	90-130 A 5 kg	120-150 A 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.					

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