



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN DUROWELD V**

PATTERN: AWS E Co Cr – A – Stellite 6

ALLOY ELEMENTS INCLUDED	C	Cr	W	Ni	Si	Co
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APPLICATION FIELD	Special small rods of cobalt, for surface coverings, pumping out, specially indicated to acid conductors. For hot and cold cutting laminas, tenacious pin of oven well, explosion engine valves. Used in the most varied industries, like: aeronautics, spacial, naval, petro chemical, paper, cellulose, mining, metallurgical, lamination, forging, ceramic, woodwork, nutritive, hydro and thermo electrical. Pointing out in tenacious pin of oven well and explosion engine valves.					
TECHNICAL 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: 40-45 HRC					
OPERATIONAL CHARACTERISTICS	For oxi-acetilenic or TIG					
	Welding Position: Plain					
	Ø In mm	3,00x350mm	4,00x350mm	5,00x350mm		
	Amperage Package	70-110 A 5 kg	90-130 A 5 kg	120-150 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					