



UNIWEELD IND. DE ELETRODOS LTDA

Address: 1788, XV de Dezembro Avenue – Tanque do Moinho
Zip Code: 12.910-691 – Bragança Paulista – São Paulo – Brazil
Phone: (+55 11) 4035-8877 – Fax: (+55 11) 4603-2511
E-mail: uniweld@uniweld.com.br
Website: www.uniweld.com.br

Contact Uniweld

(+55 11) 4035-8877

sales@uniweld.com.br

COMERCIAL DESIGNATION: **ESSEN DUROWELD X TI**

PATTERN: Stellite 31

ALLOY ELEMENTS INCLUDED	C	Cr	Mn	Si	Ni	Co
-------------------------	---	----	----	----	----	----

APPLICATION FIELD	The special electrode ESSEN DUROWELD X TI, is an alloy based on cobalt, containing chrome and molibdenium. Presents an excellent resistance to corrosion, wastage by friction and cavity. It has a stable arch with little sprinkles, easy to remove the scoria and deposit totally free of porosity. It was developed specifically to combat the erosion by cavity in hydraulic hard systems. There is also a big application in ship's airscrew, and in general, in components that anyway suffer with erosion by cavity. Welded in plain and horizontal positions.					
MECHANICAL PROPRIETIES	Hardness: 30-35 HRc					
OPERATIONAL CHARACTERISTICS	For: C C +					
	Welding Position: Plain					
	∅ In mm	3,25x350 mm	4,00x350mm	4,80x350 mm		
	Amperage Package	70-100 A 5 kg	110-150 A 5 kg	140-180 A 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.					