



## UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: ESSEN LH 2: **ESSEN LH 2**

PATTERN: DIN E 6 - 60 S

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Mo
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APPLICATION FIELD	Special electrode indicated for welding all kinds of cutting tools in printworks, like for example: pull back tools, turn and roll plain and mold impressions, print impressions e for deep stamping, wire cutting, etc.			
TECHNICAL CHARACTERISTICS	Excellent minimum tenacity proprieties, contraction of the deposited material, consequently high traction resistance are the most important characteristics of this kind of electrode, the deposited material, corresponds in its chemical composition and a steel with 5% chrome spicy to the air. AISI: A8-A1-D2-D3 DIN: 17006: X50 Cr Mo W 9-11 –x100 Cr Mo V51 X165 Cr Mo V12 – X210 Cr 12			
MECHANICAL PROPRIETIES	Hardness: 57-62 HRc Normalize between:820-850°C Temperature:: 950-980°C Reveniment according to necessity			
OPERATIONAL CHARACTERISTICS	For C.A. or C.C. +			
	Welding Position: P.V.S.			
	Ø Im mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage package	60-80 A 5 kg	90-120 A 5 kg	120-150 A 5 kg	
WELDING TECHNIQUES	The parts must be clean and free of contamination. The parts must not be pre-heated and between the passes it can not exceed 300°C. After each string beats hot with the ball hammer. The strings must be narrow and short and must be interpolated to avoid super-heating. The second layer must be applied crossing the first one. In case that there is only one part, it must be semi-submerged in running water			