



## UNIWELD IND. DE ELETRODOS LTDA

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## Contact Uniweld

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COMERCIAL DESIGNATION: **ESSEN MN 14**

PATTERN: AWS E FE MN = A

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Ni	Cr
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APPLICATION FIELD	Electrode for union and revestment of manganese steel (HADFIELD). Mainly developed for crossing rails, mandible guides, wheels, impact laminas, buckets, hammer mills, wire netting, rails, digging machines, polygon corners.				
TECHNICAL CHARACTERISTICS	Indicated to basis metal: Manganese steel (HADFIELD) – Fused steel Forges Steel – Low alloy steel				
MECHANICAL PROPERTIES	Hardness as deposited: 250. HB Hardness with cooling job 450.HB Temperature resistance: 300°C				
OPERATIONAL CHARACTERISTICS	For C.A. or C.C. +				
	Welding Position: P.V.S.				
	Ø In mm	3,25x350mm	4,00x450mm	5,00x450mm	6,00x450mm
	Amperage Package	110-140 A 5 kg	150-180 A 5 kg	190-220 A 5 kg	220-250 A 6 kg
WELDING TECHNIQUES	Fatigated areas must be totally resolved. Hardened areas must be emered or applied a pillow with ESSEN CN 37 HL or ESSEN CN 29/9 R. Do not overload the electrode with excessive amperage. Big deposits in manganese steel, must be effectuated, with the part previously submerged in running water. If it is not possible, apply humid cloth or compressed air, trying to avoid the super heat. Working temperature can not exceed 300°C to control, use the thermic pencil for 575 F/302°C				