



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN MS 1118 M IG**

PATTERN: AWS ER 110 S 1

ALLOY ELEMENTS INCLUDED	C	Mn	Cr	Ni	Mo
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APPLICATION FIELD	Wire or small rod specially coppered to be used in low hydrogen revestments. Indicated for welding low alloy steel used in naval construction and militar, like HY 80 and HY 100. Applied in all kinds of steel with high mechanical resistance. Welded in all positions.				
MECHANICAL PROPRIETIES	Traction resistance: min. 760 RT (MPa)				
OPERATIONAL CHARACTERISTICS	For process TIG		Small rods of 1.000mm		
	Welding Position: ---				
	∅ In mm	0,80 MIG 1,60 Small Rod	1,00 MIG 2,40 Small Rod	1,20MIG 3,20 Small Rod	1,60MIG
Embalagem	Bobbin 15-18 kg Small Rod 10kg	Bobbin: 15-18kg Small Rod 10kg	Bobbin: 15-18kg Small Rod 10kg	Bobbin 15-18kg Small Rod 10kg	
WELDING TECHNIQUES	Remove the ink, grease, rudiness of the area to be welded. Regulate the necessary flowing out gas, avoid oscilant movements (zig-zag) during the welding process so it will not fail to protect the arch when it touches the corners. Keep the torch in a correct distance in accordance to the chamfer. Regulate the fount according to the thickness of the part and O the small rod. To stablish the opening of the arch use a small copper plate, use CHEM-SHARP automatically to apoint the tungstenium electrode.				