



UNIWEELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN MS 612 R**

PATTERN: AWS E 6012

ALLOY ELEMENTS INCLUDED	C	Si	Mn
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APPLICATION FIELD	Special steel carbon electrodes with thin covering for construction jobs of steel in general, indicated for welding machines and equipments, profiles of different gauges and separated tacks, bridges, coachworks, pipelines, descendant vertical welding even if it has many overlaid strings, as for bad prepared junctions and places with restrict access.			
TECHNICAL CHARACTERISTICS	Electrode with thin cover like rutilic-cellulosic for welding in descendant vertical position. This electrode is welded in continuous or alternating current. Due to its special covering it is practically insensible to impurities not metallical, as it is in small oxidations of the basis metal. The material deposited has excellent characteristics and good viscosity with scoria self-detached. Indicated to Basis Metals: Steel for construction: ST 33 – ST 52 – ST 37t – ST 52t Pipeline Steel: ST 35,8 – ST 45,8 Steel for boilers: ST 34 KT – ST 41 KT Steel for naval construction: A-B-C-D-E			
MECHANICAL PROPRIETIES	Traction Resistance: 46-50 Kp/mm ² Elasticity Limit: 38-42 Kp/mm ² Extension L = 5 d. %: 17-20 % Resilience Kpm/cm ² : D.V.M. 8-12 6-11			
OPERATIONAL CHARACTERISTICS	For C.A. ou C.C.-			
	Welding Position: P.V.S.D.			
	Ø In mm	2,00x350mm	2,50x350mm	3,25x350mm
Amperage Package	25-60 A 5 kg	35-85 A 5 kg	80-140 A 5 kg	110-190 A 5 kg
WELDING TECHNIQUES	A preparação da junta é importante em qualquer soldagem, emendas sem chanfro ou chapas finas, obedecer as regras fundamentais como abaixo especificado.			
	THICKNESS OF THE METAL SHEET IN MM	OPENING BETWEEN THE METAL SHEETS IN MM	Ø MM MM Of The Electrode To Be Utilized	
	1,50	0,50	2,00	
	2,00	1,00	2,00	
	2,50	1,20	2,50	
	3,00	1,50	2,50 - 3,25	
3,50	1,50	3,25		