



## UNIWEELD IND. DE ELETRODOS LTDA

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## Contact Uniweld

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COMERCIAL DESIGNATION: **ESSEN MS 620**

PATTERN : AWS E 6020

ALLOY ELEMENTS INCLUDED	C	Si	Mn
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APPLICATION FIELD	This electrode is specially developed for welding thick metal sheets in horizontal and plain positions. Its high efficiency on production is connected with deposit quality. Ideal for making welded profiles, structures for naval constructions and railways.			
TECHNICAL CHARACTERISTICS	Electrode with double utility, works as a welding electrode with high penetration, when used in alternating or continuous current on the negative pole, and as cutting electrode, with strong blowing, when used on the positive pole.			
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: HI - HIII - St 34KT - S 41KT Steel for naval construction: A - D			
MECHANICAL PROPRIETIES	Traction Resistance: 44-52 Kp/mm <sup>2</sup> Elasticity Limit: 35-40 Kp/mm <sup>2</sup> Extension L = 5 d %: 22-27 Resilience Kpm/cm <sup>2</sup> : DVM 08-14 07-12			
OPERATIONAL CHARACTERISTICS	For C.A or C.C. -			
	Welding Position: plain			
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage	70-90A	100-130A	140-170A	180-230A
Package	5 kg	5 kg	5 kg	5 kg
WELDING TECHNIQUES	Welding Techniques: For this kind of electrode the junction preparation is not so important because it is considered an electrode with high penetration and works on any surface, even if it is not enough cleaned.			