



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN NIBORWELD**

PATTERN: AWS ER Ni Cr B

ALLOY ELEMENTS INCLUDED	Ni	Cr	B			
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APPLICATION FIELD	Special small rod fused and rectified, for application in oxi-acetilenic and TIG processes. Specially indicated for deep perforation tools, parts of bombs, threads without end and repairing cutting tools. In thick parts pre-heat in 400C.					
MECHANICAL PROPRIETIES	Hardness: 57-60 HRc					
OPERATIONAL CHARACTERISTICS	For oxi-acetilenic or TIG					
	Welding Position: Plain					
	Ø In mm	4,00x450mm	5,00x450mm	6,00x450mm		
	Package	5 kg	5 kg	5 kg		
WELDING TECHNIQUES	Cleanness of the area is indispensable and essential to keep the extension of the arch always short, not to overload the electrode with excessive amperage, welding only when the electrode is very dry, prepare the junctions following the rules, thickness superior to 350mm, must be chamfered.					