



## UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN NICROWELD 5 C**

PATTERN: AWS E Ni Cr Mo-5

Alloy Elements Included	C	Ni	Cr	Mn	Fe	W
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APPLICATION FIELD	Special electrode for welding alloys like HASTELLOY and hot job tool's covering, like: impressions, pression plugs, cutting knives, hard steel 2240 – 400 HB. With 700°C still keep the hardness of 140HB.				
TECHNICAL CHARACTERISTICS	Resistant to job temperatures between 196 – 600°C, covered with steel plates connected. There is a high resistance to heat and thermic shock				
MECHANICAL PROPRIETIES	Traction Resistance: min. 690 Rt (MPa)				
OPERATIONAL CHARACTERISTICS	For: C.C +				
	Welding Position: Plain				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x450mm	5,00x450mm
Amperage Package	50-70 A 5 kg	75-100 A 5 kg	90-130 A 5 kg	110-170 A 5 kg	
WELDING TECHNIQUES	<p>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.</p> <p>* Registered Trademark of INCO – International Nickel Company</p>				