



## UNIWEELD IND. DE ELETRODOS LTDA

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## Contact Uniweld

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COMERCIAL DESIGNATION: **ESSEN Ni Cr 8 GS**

PATTERN: SPECIAL PRODUCT

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Ni
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APPLICATION FIELD	Electrode for welding and iron /gray fused iron, nodule and mehanite revestment. For revestment of tools in automotive industries and auto-parts in special fused iron impressions. Filling up and recovery in metallurgical companies. It is also indicated for bobbins friezes reconstructions in suggar mills and other fused iron components in the suggar mill industry				
TECHNICAL CHARACTERISTICS	The advantage of this electrode is its deposit free of porosity, highly auto-sliding and mechanically used in factoring. Indicated to basis metal: Fused iron: gray, connected, nodule, mehanite				
MECHANICAL PROPRIETIES	Hardness: HRc. 38 Used with tools Accepts high polish				
OPERATIONAL CHARACTERISTICS	For C.C.+				
	Welding Position: P.				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00x450mm
Amperage Package	65-75 A 5 kg	80-110 A 5 kg	110-130 A 5 kg	140-160 A 5 kg	
WELDING TECHNIQUES	As in all welding processes, the quality and aspect of the deposit vary according to the experience and hability of the welder, in cleanness and part preparation, the amperage regulation in accordance with the electrode's diameter and dimensions of the part, in handling the electrode, depositing passes interpolated to avoid the super heat and hammering to soften the tensions.				