



UNIWEELD IND. DE ELETRODOS LTDA

Address: 1788, XV de Dezembro Avenue – Tanque do Moinho
 Zip Code: 12.910-691 – Bragança Paulista – São Paulo – Brazil
 Phone: (+55 11) 4035-8877 – Fax: (+55 11) 4603-2511
 E-mail: uniweld@uniweld.com.br
 Website: www.uniweld.com.br

Contact Uniweld

(+55 11) 4035-8877

sales@uniweld.com.br

Comercial Designation: **ESSEN OH 1**

PATTERN: DIN E 2-UM 65 S

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	V	Mo
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APPLICATION FIELD	Electrode indicated for welding on the following kinds of tools: false for cutting tools: (Bi metal) tint, cutting punctures, spigot tools, plane, drill, melters, knives with high efficiency to cut papers and fine similar materials, rotative and plain cylinders for impressions, etc.			
TECHNICAL CHARACTERISTICS	The proprieties of electrode ESSEN OH 1 and the chemical composition of this correspond to steel tools with medium alloy spicy in oil. The deposited material discerns for its little contraction or alteration of measure, good durability of the cutting wire and high resistance against wastage. Indicated to basis metal AISI: 01- 02- 07- S1- 6F7 DIN: 17006: 100 Mn Cr W4 – 90 Mn VB – 105W Cr6 45W Cr V7 – 50 Ni Cr 13 – 60 W Cr V7			
MECHANICAL PROPRIETIES	Normalized: 64-65°C Mix Properly: 782-820°C Hardness: 64-65 HRC			
OPERATIONAL CHARACTERISTICS	For: C..A or C.C-			
	Welding Position: ---			
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm
Amperage Package	60-80 A 4 kg	90-120 A 4 kg	120-150 A 5 kg	
WELDING TECHNIQUES	<p>There are four different ways to apply these electrodes in cutting tools:</p> <ul style="list-style-type: none"> A) Technical orientation for welding to recover tools already mixed properly and covered (without) posterior treatment of temper. B) Manufacturing new tools through the corner filling up or job surfaces (without) posterior temper. C) Manufacturing new tools through the corner filling up or job surfaces (with) posterior temper. D) Welding the tools (with) complete posterior thermic treatment. 			