



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 SG 500**

PATTERN: Electrode of Grafite

ALLOY ELEMENTS INCLUDED

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| APPLICATION FIELD | Charcoal and coppered (grafite) electrode special for cutting chamfer utilizing electrical arch and compressed air. The chamfer or cutting process with the charcoal, has important advantages: its application is simple and without problems in almost all metals, independent of the surface and service position. Ideal for chamfers or cuttings in parts with exchange secretion, removal of small or big defects of casting, training and corrosion of fused parts, removal of defective weldings, cleanness of ingots and other purposes. | | | | |
| TECHNICAL CHARACTERISTICS | The equipment must be continuous current, the part must be connected to the negative pole and the electrode on the positive pole, the compressed air can be a compressor or an oxygen tube. The cuttings present good aspect, free of carbonization. | | | | |
| MECHANICAL PROPRIETIES | Pression 6 to 8 kg / mm ² | | | | |
| OPERATIONAL CHARACTERISTICS | For C.C- or C.C.+ | | | | |
| | Welding Position: --- | | | | |
| | ∅ In mm | 4,00mm | 5,00mm | 6,00mm | 8,00mm |
| | Amperage Package | 100-200 A Peças | 150-300 A Peças | 150-400 A peças | 200-405 A peças |
| WELDING TECHNIQUES | The cutting speed depends on the angle of the electrode in accordance with the part. It is possible to get a great efficiency when applied from 25 to 45. The distance is between 3 and 5mm. On the cutting job, it is recommended perpendicular movements. The compressed air flowing out must be between 6 and 8 kg/mm ² . An inferior flowing out is recommended, prejudice the cutting and becomes difficult the metal separation. | | | | |