



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN WA 12**

PATTERN: DIN E 3-UM 60 T

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	Mo
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APPLICATION FIELD	Special electrode indicated for welding on the following kinds of all kinds of tools: fusion matrix under pressure (aluminium), parts submitted to high temperature, turning tools. Fix, calibrate, extra deep impressions, pull back, cutting scissors' laminas, tools, extrusion piston, hammers, sharp edgers, knives filling up, hot and cold cutting corners, scissors, big matrix and measures, all kinds of tools that work with impact, friction, abrasion, pressure, as well as revetments of high responsibility in forging.				
TECHNICAL CHARACTERISTICS	These kinds of electrodes are described by its great resistance and tenacity, connected with good resistance to the wastage in high temperatures. AISI: H12—H01—H13—H10—H20 DIN: 17006: X37 Cr Mo W51-x38 Cr Mo V51 – X40 Cr Mo v51 X32 Cr Mo V 33 – x30 w Cr V 93 - x 30 WRC v 53				
MECHANICAL PROPRIETIES	Hardness: 56-58 HRc Normalize between:800-840°C Temperature: 1000-1050°C Reveniment according to necessity				
MECHANICAL PROPRIETIES	For: C.A. or C.C-				
	Welding Position: P.V.S.				
	∅ In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00x350mm
Amperage	60-80 A	90-120 A	120-150 A	150-170 A	
Package	5 kg	5 kg	5 kg	5 kg	
WELDING TECHNIQUES	There are four different ways to apply these electrodes in cutting tools: A) Technical orientation for welding to recover tools already mixed properly and covered without posterior temperature treatment . B) Manufacturing new tools through the corner filling up or job surfaces with 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.				