



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 WKZ 50**

PATTERN: DIN E 3-UM 45 T

ALLOY ELEMENTS INCLUDED	C	Si	Mn	Cr	V	W
-------------------------	---	----	----	----	---	---

APPLICATION FIELD	Electrode indicated for welding on the following kinds of tools: fusion matrix under pressure (aluminium), extrusion pins, cylinders to laminate rings, parts submitted to high temperature, sharp edgers, knives filling up, hot and cold cutting corners, extrusion pistons, big and medium matrix, cutting scissors, hammers, anvils and all kinds of tools that work with heating, as well as revetments of high responsibility in forging parts that work with violent impacts, pressure wastages, etc.				
TECHNICAL CHARACTERISTICS	These kind of electrode is described by its great resistance and tenacity, connected with good resistance to the wastage in high temperatures. Indicated to basis metal: AISI: H11- H13- H10- H20- H12 DIN: 17006: X 38Cr Mo V 51– X 40Cr Mo V 51 X 32Cr Mo V 33– X 30 W Cr V 53- 30 W Cr V 93 X 37 Cr Mo W 51				
MECHANICAL PROPRIETIES	Normalized: 800-840°C Mixed Properly: 1060-1120°C Hardness: 42-47 HRc				
OPERATIONAL CHARACTERISTICS	For: C.A or C.C-				
	Welding Position: ---				
	∅ 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 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.				