



## UNIWEELD IND. DE ELETRODOS LTDA

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Comercial Designation: **ESSEN B 26 Mn**

**PATTERN: PRODUTO ESPECIAL**

Alloy Elements Included	Mn	Ni	Fe	Al	Cu
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APPLICATION FIELD	Special electrode, extruded, bronze aluminium <b>manganes</b> , for welding and hard covering on steel, fused steel, copper and its alloys. Covering in valves, cursors, equipments for the chemical industry, shipyards, valves seats, bombs, drawers, turbines, matrix, copper and steel union. (Throw oxygen to high furnaces).				
TECHNICAL CHARACTERISTICS	ESSEN B 26 Mn is an electrode which deposits bronze aluminium <b>manganes</b> , with great mechanical proprieties and high resistance to corrosion. Presents an excellent aspect of the deposited string, free of sparkling. Ideal for mining, metallurgical, earthwork, sugar mills, ceramic, textile, naval, chemical, automotive and railway industries. Indicated to Basis Metals: Copper and its alloys – bronze brass alpaca Steel : fused, laminated or Forjed Iron: Laminated Fused or Galvanized				
MECHANICAL PROPRIETIES	Traction Resistance: 98-75 Kg/mm <sup>2</sup> Elasticity Limit: 17-19 Kg/mm <sup>2</sup> Extension (L = 5 d): 27% Hardness 190-230 HB				
OPERATIONAL CHARACTERISTICS	For C.A. or C.C. +				
	Welding Position: Plain				
	Ø In mm	2,50x350mm	3,25x350mm	4,00x350mm	5,00x350mm
Amperage	80-100 A	100-120 A	120-140 A	140-180 A	
Package	5 kg	5 kg	5 kg	5 kg	
WELDING TECHNIQUES	Rigorously clean the welding area, removing vestigies of oil. In union weldings, prepare the junction, chamfer the parts between 200-300°C to start the welding process, cold parts cause difficulty to open the arch, provoking porosity in the deposit or scratches if the cooling process is not slow.				