



UNIWELD IND. DE ELETRODOS LTDA

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COMERCIAL DESIGNATION: **ESSEN B 29**

PATTERN: AWS E Cu Al = B

Alloy Elements Included	Al	Si	Mn	Fe	Cu
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Application Field	Special copper electrode for welding and bronze, aluminium copper and its alloys covering. Ideal for automotive, mechanical, naval, mining, earthwork, chemical, petrochemical, nutritive, textile, sugar mill and ethanol industries.				
Mechanical Proprieties	Ideal to retest steel, fused steel, specially for wiredraw and extension tools, and the big solicitations which must leave some vestigies on the job, tools for big solicitations in automotive industries, to manufacture bumpers and impressions, ship's airscrews, centrifuge bombs, turbines, gearing valves with high resistance to corrosion in salty water (the hardest bronze alloy in the market). Indicated to Basis Metals: Copper and its alloys Steel : fused Iron: Fused				
Mechanical Proprieties	Traction Resistance: 125 Kg/mm ² Hardness: 300 HB				
Mechanical Proprieties	For C.A. or C.C. +				
	Welding Position: Plain				
	Ø In mm	3,25x350mm	4,00x350mm	5,00x350mm	
Amperage	80-110A	110-130 A	130-150A		
Package	5 kg	5 kg	5 kg		
Welding Techniques	Clean the area to be welded, through mechanical resources, do not use emery in parts with walls superior to 4,00prepare the junction, chamfering 90°. Regulate the amperage in accordance to the diameter of the electrode. Pre-heat the part around 600°C, keep the electrode in a vertical position.				