



## UNIWEELD IND. DE ELETRODOS LTDA

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**COMMERCIAL NAME:** ESSEN CN 34 S Ti

**Review:** 00

**STANDARD:** AWS A5.4: 2012 E 347-16 / ASME SFA5.4 E 347-1 Edition 2015

**Date:** 06/2017

Chemical characteristic of the deposited metal	C	Mn	Si	Cr	Mo	Ni	Nb	Cu	P	S
	0.080% Max.	0.50 2.50%	1.00% Max.	19.00 to 21.00%	0.75% Max.	9.00 to 11.00%	1.00% Max.	0.75% Max.	0.040% Max.	0.030% Max.

<b>APPLICATION FIELD</b>	Electrode suitable for welding steels of AISI 321 and similar alloy composition, stabilized with niobium. Other welding and construction of appliances and containers for chemicals, textiles, pulp, dye, etc. Deposit-based materials of the same type grain resistant to degradation without quenching after welding. Also for valve seats coatings (where no or low alloy steel), conductors acid gases, water and steam.															
<b>TECHNICAL CHARACTERISTICS</b>	Is an electrode that features a resistant deposit to intergranular corrosion, good appearance of the bead, easy removal of the slag, with a good yield and high deposition rate.															
<b>MECHANICAL PROPERTIES</b>	Tensile strength: 520 MPa (min.) Elongation: 30% (min.)															
<b>OPERATIONAL CHARACTERISTICS</b>	<b>Welding position:</b> Flat, Vertical, Horizontal and On Head															
	<b>Current Type:</b> CA - CC +															
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø X 300 2.00</th> <th>Ø X 350 2.50</th> <th>Ø X 350 3.25</th> <th>Ø X 450 4.00</th> </tr> </thead> <tbody> <tr> <td><b>Amps (A)</b></td> <td>40-70</td> <td>60 - 90</td> <td>90-130</td> <td>130-170</td> </tr> <tr> <td><b>Packaging (kg)</b></td> <td>4</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </table>	Diameter (mm)	Ø X 300 2.00	Ø X 350 2.50	Ø X 350 3.25	Ø X 450 4.00	<b>Amps (A)</b>	40-70	60 - 90	90-130	130-170	<b>Packaging (kg)</b>	4	5	5	5
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<b>WELDING TECHNIQUE</b>	Remove completely grease and other contaminants from the workpiece by grinding or mechanical brushing process, making the setting of device parameters according to the diameter to be used, it is recommended to work with the electrode in oscillating movements and the electrode inclined with respect to the metal base, after welding Decap apply the gel to Essen passivation and removal of residual solder carbonization.															