



**UNIWEELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME: ESSEN CN 36 L Ti**

**Revision: 01**

**STANDARD: AWS A5.4: 2012 E 316L-16 / ASME SFA5.4 E 316L-16 Edition 2015**

**Date: 07/2016**

Chemical characteristic of the deposited metal	C	Mn	Si	Cr	Mo	Ni	Cu	P	S
	0.040% Max.	0.50 to 2.50%	1.00% Max.	17.0 to 20.0%	2.00 to 3.00%	11.0 to 14.00%	0.75% Max.	0.040% Max.	0.030% Max.

<b>APPLICATION FIELD</b>	Rutile coated electrode for welding stainless steels with low carbon content, suitable for welding austenitic alloys of similar chemical composition or dissimilar resistant to chemical substance, resistant to intergranular corrosion and is suitable for industries chemical, petrochemical, sugarcane, Pharmaceutical, Pulp and Paper, Food and etc.															
<b>TECHNICAL CHARACTERISTICS</b>	Is an electrode that has a high deposition rate with moderate penetration, easy slag removal, good bead appearance and resistant to intergranular corrosion.															
<b>MECHANICAL PROPERTIES</b>	Tensile strength: 520 MPa (min.) Elongation: 35% (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.															