



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN 28

Review: 01

STANDARD: AWS A5.6: 2008 ECU / ASME SFA5.6 ECU Edition 2015

Date: 04/2019

Chemical characteristic of the deposited metal	Pb 0.01% Max.	Mn 0.10% Max.	Fe 0.20% Max.	Si 0.10% Max.	Al 0.10% Max.	Cu Rest
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APPLICATION FIELD	Essen 28 electrode deposits with excellent mechanical properties with high corrosion resistance. Intended marriage or drivers, bars, taps, couplings, roller trains. Used in the food industry, pulp and paper, textiles, shipbuilding, steel, boilers, foundries, mining, automotive, earth moving.				
TECHNICAL CHARACTERISTICS	The deposit Essen electrode 28 exhibits excellent color combination. On the roads of electrified iron in contact restoration of the electric system, maritime points, contacts of electric winches and cranes. In the manufacture of electric motors. Suitable for base metals Copper and Copper Electrolytic.				
MECHANICAL PROPERTIES	Tensile strength: 170 MPa (min.) Stretching: 20% (min.)				
OPERATIONAL CHARACTERISTICS	welding position: flat				
	Type of current: DC +.				
	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø X 450 4.00	Ø X 450 5.00
	Amps (A)	90 to 120	120 to 140	130-160	160 and 200
	Packaging (kg)	15	15	25	25
WELDING TECHNIQUE	Clean the area to be welded, by mechanical means, do not use grinding parts the upper walls 4,00mm preparing the joint bevel 90. Adjust the amperage according to the electrode diameter. Preheat the piece to about 600 ° C, keep the electrode upright.				