



**UNIWELED IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME: ESSEN B 26 Al**

**Review: 01**

**STANDARD: AWS A5.6: 2008 ECuAl-A2 / ASME SFA5.6 ECuAl-A2 Edition 2015**

**Date: 07/2016**

Chemical characteristic of the deposited metal	Al	Pb	Fe	Si	Mn	Cu
	6.50 to 9.50%	0.02 Max.	0.50 5.00%	1.50% Max.	0.50 Max.	Rest

<b>APPLICATION FIELD</b>	Special aluminum bronze electrode antifriction coating, corrosion and cavitation, it is also ideal for high strength union parts aluminum bronze containers and welding copper to steel. Used for aluminum bronze (up to 10% Al), housings and parts for pumps acids, ships propellers and parts subject to corrosion by salt water.															
<b>TECHNICAL CHARACTERISTICS</b>	It is a special electrode for multimaterial applied in petrochemical industries, automotive, marine, mining, embankment, dam, sugar alcohol, cooling, hydro and electric term, electronics and textiles. Suitable for metals basis: Copper and its alloys - brass - bronze - alpaca Steel: Cast - Laminated - wrought Iron: Laminated - casting - Galvanized															
<b>MECHANICAL PROPERTIES</b>	<b>Tensile strength:</b> 410 MPa (min.) <b>Stretching:</b> 20% (min.) <b>Toughness:</b> 130-150 HB															
<b>OPERATIONAL CHARACTERISTICS</b>	<b>Welding position:</b> Flat															
	<b>Type Current Used:</b> AC or DC +															
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø 2,50x350</th> <th>Ø 3,25x350</th> <th>Ø 4,00x350</th> <th>Ø 5,00x350</th> </tr> </thead> <tbody> <tr> <td><b>Amps (A)</b></td> <td>80-100</td> <td>100-120</td> <td>120-140</td> <td>140-180</td> </tr> <tr> <td><b>Packaging (kg)</b></td> <td>5</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </table>	Diameter (mm)	Ø 2,50x350	Ø 3,25x350	Ø 4,00x350	Ø 5,00x350	<b>Amps (A)</b>	80-100	100-120	120-140	140-180	<b>Packaging (kg)</b>	5	5	5	5
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<b>TECHNICAL WELDING</b>	thoroughly clean the area to be soldered by removing traces of oil and grease. In joining welds prepare the gasket between the pieces chamfer 200-300°C to initiate welding, cold hamper the opening of the arc parts, causing cracks or porosity in the deposit if the cooling is not slow.															