



UNIWEELD IND. DE ELETRODOS LTDA

Address: 1788, XV de Dezembro Avenue – Tanque do Moinho
 Zip Code: 12.910-691 – Bragança Paulista – São Paulo – Brazil
 Phone: (+55 11) 4035-8877
 E-mail: uniweld@uniweld.com.br
 Website: www.uniweld.com.br

Contact Uniweld

(+55 11) 4035-8877

COMMERCIAL NAME: ESSEN DUR 500 SPECIAL
STANDARD: SPECIAL PRODUCT

Review: 01
Date: 05/2017

Chemical characteristic of the deposited metal	C 1.00% Max.	Si 1.20% Max.	Mn 0.50 1.50%	Cr 5.00 to 8.00%	Ni 0.50% Max.
--	---------------------------	----------------------------	----------------------------	-------------------------------	----------------------------

APPLICATION FIELD	Special electrode for hard coatings resistant to severe abrasion parts, parts dredgers, conveyor rollers and all the parts subject to greater wear, especially in mining. Advised to repair and recovery of cutting tools in cold hammers, punches and dies. Hardenable material deposited in oil 820 ° -850 ° C. Only machinable with emery. Perform welding without oscillation.																		
TECHNICAL CHARACTERISTICS	SPECIAL ESSEN DUR 500 is an electrode for hard surfacing for the restoration to wear, has a high deposition rate with good penetration and moderate impact resistance and excellent abrasion resistance, machinable with emery. Suitable for base metals: steel castings, rail steels, hardenable steels, tool steels.																		
MECHANICAL PROPERTIES	Toughness: 50 to 60 HRC Treatment: up to 500° C Working Temperature: annealing and annealing at 820°- 850° C																		
OPERATIONAL CHARACTERISTICS	Type of current used: AC+																		
	Welding position: Flat, horizontal.																		
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø X 350 2.50</th> <th>Ø 3,25X350</th> <th>Ø 4,00X450</th> <th>Ø 5,00x450</th> <th>Ø 6,00x450</th> </tr> </thead> <tbody> <tr> <td>Amps (A)</td> <td>70 to 100</td> <td>100 to 160</td> <td>140-200</td> <td>180-220</td> <td>210-255</td> </tr> <tr> <td>Packaging (kg)</td> <td>4</td> <td>5</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </table>	Diameter (mm)	Ø X 350 2.50	Ø 3,25X350	Ø 4,00X450	Ø 5,00x450	Ø 6,00x450	Amps (A)	70 to 100	100 to 160	140-200	180-220	210-255	Packaging (kg)	4	5	5	5	5
	Diameter (mm)	Ø X 350 2.50	Ø 3,25X350	Ø 4,00X450	Ø 5,00x450	Ø 6,00x450													
Amps (A)	70 to 100	100 to 160	140-200	180-220	210-255														
Packaging (kg)	4	5	5	5	5														
WELDING TECHNIQUE	Completely remove residues of oxides, grease, and other contaminants from the workpiece by the grinding process or mechanical brush, preparing the site to be coated or joined, to the setting of device parameters according to the diameters to be used.																		