



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN TUB CR 68
STANDARD: SPECIAL PRODUCT

Revision: 01
Date: 04/2019

Chemical characteristic of the deposited metal	C	Si	Mn	Cr	Mo	Nb	V
	2.50 to 3.80%	0.20 to 1.00% max.	0.20 to 1.00% max.	16.00 to 19.00%	0.30 to 0.80%	2.70 to 4.00%	0.25 to 0.75%

APPLICATION FIELD	It is a special cored wire, auto protected, depositing a rich alloy carbides of high hardness chromium indicated and developed for coating parts and equipment where severe abrasion wear occurs. Especially for coating knives and hammers in the Sugar and Alcohol Industry. It is also used in cement industries, ceramics, mining, steelworks, Agriculture and etc.						
TECHNICAL CHARACTERISTICS	It is a wire that features easy weldability, stable arc, high deposition rate, deposit free of slag, allowing to obtain perfect cords, featuring excellent durability and resistance equipment.						
MECHANICAL PROPERTIES	Toughness: 56 to 63 HRC						
OPERATIONAL CHARACTERISTICS	Type of current used: CC +						
	Welding position: flat						
	Stick out: 15 mm						
	shielding gas: Do not use						
	Reel (mm)	1.60 mm Ø	2.40 Ø				
	Amps (A)	150 to 250	200 to 300				
Voltage (V)	19 to 27	24 to 30					
Packaging (kg)	12.50	20 or 25					
WELDING TECHNIQUE	If necessary to clean the area to be coated grinder or rotating mechanical brush cutting electrode and chamfer or graphite, the surface whose area is fatigued impregnated with mill scale and impurities which must be removed not to cause contamination making the appropriately regulating the voltage and amperage of the equipment according to the used diameter.						