



**UNIWEELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME: ESSEN 800**  
**STANDARD: DIN EN 14700 AND A 10 CGP 60**

**Revision: 01**  
**Date: 01/2019**

Chemical characteristic of the deposited metal	C	Si	Mn	Cr	P	S	Ni	V
	2.80 to 4.80%	1.20 to 3.90%	0.70 to 2.60%	26.00 to 34.00%	0.040% max.	0.040% max.	1.00% Max.	1.00% Max.

<b>APPLICATION FIELD</b>	It is a stated and developed electrode for the surface treatment of mills rolls in cane sugar and alcohol, with the application of this material gets a production yield exceeding the resultant work loss, in order to increase the production becoming rough the rollers producing a moisture reduction and decrease in percentage of residual sucrose, which is extremely significant where it appears to drop from 5 to 2, this causes a substantial saving in tonne of cane crushed by decreasing the cane slip with maximum exploitation of the marc .																		
<b>TECHNICAL CHARACTERISTICS</b>	A special electrode with high chrome content suitable for the coating of moldings of mills rolls, this electrode is deposited while the rolls of the mills are turning meaning more economy and performance without any need to stop for the application of the material in up to 30% roll wear with chromium deposition of metallic globules at the beads becoming rough and highly rugged and can be used in low amperage without undergoing any modification in the coating, with the addition of chromium carbides become high resistance to abrasion, corrosion and impact caused by the grinding of sugarcane.																		
<b>MECHANICAL PROPERTIES</b>	<b>Toughness:</b> 55 to 62 HRC																		
<b>OPERATIONAL CHARACTERISTICS</b>	<p><b>Type of current used:</b> DC +</p> <p><b>Welding position:</b> Flat and Vertical</p> <table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø 3,25X350</th> <th>Ø 4,00X450</th> <th>Ø 5,00X450</th> <th>Ø 6,00X450</th> <th>Ø 7,00X450</th> </tr> </thead> <tbody> <tr> <td><b>Amps (A)</b></td> <td>100 to 140</td> <td>140 and 180</td> <td>170-210</td> <td>200 to 250</td> <td>250 to 300</td> </tr> <tr> <td><b>Packaging (kg)</b></td> <td>15</td> <td>20</td> <td>20</td> <td>20</td> <td>20</td> </tr> </tbody> </table>	Diameter (mm)	Ø 3,25X350	Ø 4,00X450	Ø 5,00X450	Ø 6,00X450	Ø 7,00X450	<b>Amps (A)</b>	100 to 140	140 and 180	170-210	200 to 250	250 to 300	<b>Packaging (kg)</b>	15	20	20	20	20
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<b>WELDING TECHNIQUE</b>	A very important factor for the product performance maximum is the time consumption of each electrode whose optimal indication is 3 to 4 minutes per rod, applying the material to excessive amperage consequently would lead to an increased consumption of the electrode with low efficiency the same, since there will be a lesser amount of deposition of metallic globules in the grinding rollers, a too very low amperage will promote a longer electrode consumption with a low efficiency.																		