

	<p><b>UNIWELED IND. DE ELETRODOS LTDA</b>          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: <a href="mailto:uniweld@uniweld.com.br">uniweld@uniweld.com.br</a>          Website: <a href="http://www.uniweld.com.br">www.uniweld.com.br</a></p>	<p><b>Contact Uniweld</b>  <b>(+55 11) 4035-8877</b></p>
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<p><b>COMMERCIAL NAME:</b> ESSEN AM 45  <b>STANDARD:</b> AWS A5.10: 2012 ER 5183 / ASME SFA5.10 ER 5183 Edition 2015</p>	<p>Revision: 02          Date: 05/2019</p>
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<b>Chemical characteristic of the deposited metal</b>	<b>Si</b>	<b>Fe</b>	<b>Cu</b>	<b>Mn</b>	<b>Mg</b>	<b>Cr</b>	<b>Zn</b>	<b>Ti</b>	<b>Al</b>
	0.40% Max.	0.40% Max.	0.10% Max.	0.50 to 1.00%	4.30 to 5.20%	0.05 to 0.25%	0.25% Max.	0.15% Max.	Rest

<b>APPLICATION FIELD</b>	<p>This material may be rod-shaped or wire, for welding Tig process, Mig and oxy-acetylene, for welding of aluminum and its alloys in pieces of equipment for processing and handling of food, boats for navigation, silos, bus bodies and vans, household utensils, drums and tanks, pipes, fittings, rail wagons, suitable for chemical, petrochemical, aerospace, automotive, food, boiler. base metal 3003 and 6061.</p>														
<b>TECHNICAL CHARACTERISTICS</b>	<p>It has greater resistance non-treatable aluminum alloys. It is used for storage of chemical tanks, pressure vessels, as well as applications in cars, dump trucks and bridges, good resistance to corrosion. Magnesium when added to aluminum, has excellent weldability, good structural strength and is not prone to hot cracking.</p>														
<b>OPERATIONAL CHARACTERISTICS</b>	<p><b>To Oxyacetylene:</b> Use flame fuel or oxidant  <b>welding position:</b> flat  <b>Gas used:</b> Pure argon or He + to 0 - 5% Air  <b>Type of current:</b> Tig and Mig AC</p> <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 5px;"> <tr> <td style="width: 20%;"><b>Diameter of rod (mm)</b></td> <td style="width: 10%;">1.60</td> <td style="width: 10%;">2.40</td> <td style="width: 10%;">3.25</td> <td style="width: 10%;">4.00</td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> <tr> <td><b>Reel Diameter in (mm)</b></td> <td>1.00</td> <td>1.20</td> <td>1.60</td> <td>2.40</td> <td></td> <td></td> </tr> </table>	<b>Diameter of rod (mm)</b>	1.60	2.40	3.25	4.00			<b>Reel Diameter in (mm)</b>	1.00	1.20	1.60	2.40		
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<b>TECHNIQUE WELDING</b>	<p>Cleaning by mechanical process, not using sandpaper or emery preparing the joint to be welded, chamfering parts with greater thickness 4 mm, indirectly heating the workpiece, the grease brazing process flow area to be welded and observe when the flow signal is liquefied is the hot aluminum is to receive the rod, that in the case of oxy-acetylene welding, TIG and MIG process does not require flux.</p>														