



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN CAST 99

Review: 01

STANDARD: AWS A5.15-90 Eni-CI / ASME SFA5.15 E Ni-CI Edition 2015

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Chemical characteristic of the deposited metal	C	Mn	Si	Fe	Ni	Cu	Al	S
	2.00% Max.	2.50% Max.	4.00% Max.	8.00% Max.	85.00% Min.	2.50% Max.	1.00% Max.	0.030% Max.

APPLICATION FIELD	Special electrode for welding recovery cold gray cast iron parts, the deposit is soft and easily machinable, suitable for filling waterproof surfaces. Suitable for joining cast iron with other materials such as steel, cast steel, copper, etc. Excellent resistance of the deposited material. Also suitable for parts difficult weldability and filling casting flaws and grooves. Good weldability in all positions, the deposited material and the transition zone are limáveis with good ductility.												
TECHNICAL CHARACTERISTICS	Is an electrode for the restoration and fillers, presenting a high deposition rate with moderate penetration to great advantage deposition and free of porosity, mechanically machining easy, featuring a great tensile strength and good elongation transition zone.												
MECHANICAL PROPERTIES	Tensile strength: 276-448 MPa Flow Limit: 262-414 MPa Stretching: 3 to 6% Toughness: 135-218 HB												
OPERATIONAL CHARACTERISTICS	Welding position: All the positions.												
	Current Type: AC, DC-												
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø X 350 2.50</th> <th>Ø X 350 3.25</th> <th>Ø 450 4,00X</th> </tr> </thead> <tbody> <tr> <td>Amps (A)</td> <td>60-100</td> <td>90-130</td> <td>140-180</td> </tr> <tr> <td>Packaging (kg)</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </table>	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø 450 4,00X	Amps (A)	60-100	90-130	140-180	Packaging (kg)	5	5	5
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WELDING TECHNIQUE	Make cleaning the area to be welded or restored grinder or rotating mechanical brush on the surface whose area is fatigued impregnated with mill scale and impurities that must be removed not to cause contamination, making the appropriately adjusting the amperage of the equipment according to the diameter It is used.												