



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN CCR 63
STANDARD: DIN EN 14700 AND A 10 60 G

Review: 01
Date: 02/2019

Chemical characteristic of the deposited metal	C 3.00 to 4.80%	Mn 0.50 to 1.50%	Si 1.90 to 4.00%	Cr 27.0 to 35.0%
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APPLICATION FIELD	It is a special electrode suitable for welding and coating excavator buckets, screw conveyors, coating hammers, shredder knives, sandblasting nozzles, mixers for minerals and is indicated for the Sucoalcoleira industries, cement, ceramics, mining, steelworks, etc. .																		
TECHNICAL CHARACTERISTICS	It is an electrode developed for parts subject to abrasive wear, with easy weldability, enabling to obtain perfect cords, featuring excellent durability and resistance equipment.																		
MECHANICAL PROPERTIES	Toughness: 57 to 62 HRC																		
OPERATIONAL CHARACTERISTICS	Type of current: DC +																		
	welding position: flat																		
	<table border="1"> <tr> <td>Diameter (mm)</td> <td>Ø X 350 2.50</td> <td>Ø X 350 3.25</td> <td>Ø X 450 4.00</td> <td>Ø X 450 5.00</td> <td>Ø X 450 6.00</td> </tr> <tr> <td>Amps (A)</td> <td>80 to 110</td> <td>110-140</td> <td>140 and 180</td> <td>180-230</td> <td>230 to 260</td> </tr> <tr> <td>Packaging (kg)</td> <td>4</td> <td>5</td> <td>5</td> <td>5</td> <td>5</td> </tr> </table>	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø X 450 4.00	Ø X 450 5.00	Ø X 450 6.00	Amps (A)	80 to 110	110-140	140 and 180	180-230	230 to 260	Packaging (kg)	4	5	5	5	5
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WELDING TECHNIQUE	Make cleaning the area to be soldered or plated with grinder or using mechanical rotary brush, which area this fatigued impregnated with mill scale and impurities must be removed not to cause contamination, making the appropriately adjusting the amperage as the diameter to not overload the electrode with excessive amperage provide better deposit material, the application pad to apply multiple layers Essen CN 37 HL electrode.																		