



UNIWELED IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: **ESSEN CCR 65**
 STANDARD: **SPECIAL PRODUCT**

Review: 01
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Chemical characteristic of the deposited metal	C	Si	Mn	Cr	W	Nb	V	Mo
	3.00 to 4.70%	1.50 to 3.50%	0.50 to 1.50%	From 18.00 to 22.0%	1.00 to 2.20%	5.00 to 9.00%	1.00 to 1.60%	5.00 to 7.00%

APPLICATION FIELD	It is a special electrode complex carbides with elements Cr, Nb, Mo, V, W, obtaining a high yield to be used in parts by abrasion, abrasion and impact, suitable for work in mixers ores, dredgers, jets sand, carrier threads hammer coating, buckets and parts subject to extensive abrasion combined with high temperatures up to 500 ° C, used in steel industries, Sugarcane, ceramics, casting, cement, mining, etc.				
TECHNICAL CHARACTERISTICS	It is an electrode for the restoration fillers and protective wear, with a high deposition rate, with easy weldability, enabling to obtain perfect and smooth strings, with excellent characteristic durability of equipment that are subject to severe wet abrasion.				
MECHANICAL PROPERTIES	Toughness: 57 to 62 HRC Working temperature: 500° C				
OPERATIONAL CHARACTERISTICS	Type of current used: DC +				
	Welding position: flat				
	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø X 450 4.00	Ø X 450 5.00
	Amps (A)	70 to 100	110 to 150	140 and 180	180-230
	Packaging (kg)	5	5	5	5
WELDING TECHNIQUE	Completely remove residues of oxides, grease, and other contaminants from the workpiece by grinding or mechanical brushing process, which area this fatigued, impregnated for scale and impurities, making the setting of device parameters according to the diameter to be used is recommended to work with electrode with oscillating movement and inclined relative to the base metal, the application of multiple layers applied with the pad electrode 14 Essen MN or CN Essen 37 HL.				