



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN CN 31 Ti

Review: 01

STANDARD: AWS A5.4: 2015 E 310-16 / ASME SFA5.4 E 310-16 Edition 2015

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Chemical characteristic of the deposited metal	C	Si	Mn	P	S	Cu	Cr	Ni	Mo
	0.08 to 0.20%	0.75% Max.	1.00 to 2.50%	0.030% max.	0.030% Max.	0.75% Max.	25.00 to 28.00%	20.00 to 22.50%	0.75% Max.

APPLICATION FIELD	Rutile electrode for welding steels of similar chemical composition, type alloy 25Cr / 20Ni. Deposit highly resistant to heat. Resistant for scale formation at temperatures up to 1200° C. Suitable for welding parts of furnaces, heat shields parts subjected to high temperatures in general.															
TECHNICAL CHARACTERISTICS	The deposited metal is austenitic resisting working temperatures up to 1200° C and cold toughness of less than 195° C. Ideal for welding steels when we do not have the material composition.															
MECHANICAL PROPERTIES	Tensile strength: 550 MPa (min.) Stretching: 30% (min.)															
OPERATIONAL CHARACTERISTICS	Type of current used: DC + AC															
	Welding position: Flat, Horizontal, Vertical and head About															
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø2,50 X 350</th> <th>Ø3,25 X 350</th> <th>Ø4,00 X 350</th> <th>Ø5,00x350</th> </tr> </thead> <tbody> <tr> <td>Amps (A)</td> <td>60-80</td> <td>85-110</td> <td>110-140</td> <td>140-180</td> </tr> <tr> <td>Packaging (kg)</td> <td>5</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </table>	Diameter (mm)	Ø2,50 X 350	Ø3,25 X 350	Ø4,00 X 350	Ø5,00x350	Amps (A)	60-80	85-110	110-140	140-180	Packaging (kg)	5	5	5	5
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WELDING TECHNIQUE	As in all the welds, the quality of the deposit varies according to the experience and skill of the welder; in cleaning and joint preparation, handling of the electrode, according regulating amperage using the smallest possible diameter electrode, avoiding overheating of the piece, using only stainless hand brush for cleaning and restart the welding.															

