



**UNIWEELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME:** ESSEN CN 36 L Si

**Revision:** 01

**STANDARD:** AWS A5.9: 2012 ER 316LSi / ASME SFA5.9 ER 316LSi Edition 2015

**Date:** 02/2019

Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
	0.030% Max.	1.00 The 2.50%	0.65 The 1.00%	0.030% max.	0.030% max.	18.00 The 20.00%	11.00 The 14.00%	2.00 The 3.00%	0.75% Max.

<b>APPLICATION FIELD</b>	<p>Wire Chromium-Nickel-Molybdenum, suitable for welding austenitic stainless steel of the type 18% Cr-8% Ni and 18% Cr-10% Ni-3% Mo.</p> <p>Shows high corrosion resistance, and even in acidic environments containing chlorides. Due to low carbon content, this rod is recommended when there is a risk of intergranular corrosion. The silicon content This improves weldability and the degree of Molybdenum improves corrosion resistance.</p> <p>Used for applications with high working temperatures in storage tank, high and low pressure containers, distillers, digesters, hospital equipment, industries chemical, petrochemical, pharmaceutical, food, paper and cellulose, Sugar and Ethanol, etc.</p>																				
<b>TECHNICAL CHARACTERISTICS</b>	<p>This wire obtains a good deposition rate, stable arc, allowing a good finish of the cord, low splash index, easy removal of the slag and providing and facilitating efficiency in operation.</p>																				
<b>MECHANICAL PROPERTIES</b>	<p><b>Tensile strength:</b> 490 MPa (min.)  <b>Stretching:</b> 30% (Min)</p>																				
<b>OPERATIONAL CHARACTERISTICS</b>	<p><b>Type of current:</b> CA +  <b>welding position:</b> All the positions  <b>shielding gas:</b> Argon 100% (12 to 18 liters / min)  <b>stickout:</b> 15 to 20 mm</p> <table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø0,80</th> <th>Ø0,90</th> <th>Ø1,00</th> <th>Ø1,20</th> </tr> </thead> <tbody> <tr> <td><b>Amps (A)</b></td> <td>70-80</td> <td>80-90</td> <td>100-110</td> <td>110-120</td> </tr> <tr> <td><b>Voltage (V)</b></td> <td>15-22</td> <td>22-32</td> <td>32-42</td> <td>42-52</td> </tr> <tr> <td><b>Packaging (kg)</b></td> <td>15</td> <td>15</td> <td>15</td> <td>15</td> </tr> </tbody> </table>	Diameter (mm)	Ø0,80	Ø0,90	Ø1,00	Ø1,20	<b>Amps (A)</b>	70-80	80-90	100-110	110-120	<b>Voltage (V)</b>	15-22	22-32	32-42	42-52	<b>Packaging (kg)</b>	15	15	15	15
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<b>WELDING TECHNIQUE</b>	<p>Make cleaning the area to be welded with grinder or using mechanical rotary brush impregnated with mill scale and impurities must be removed not to cause contamination, making the appropriately adjusting the amperage and voltage of the machine according to the diameter to be used to avoid overloading the tank wire and regulate the flow of gas.</p>																				