UNIWELD IND. DE ELETRODOS LTDA
Address: 1788, XV de Dezembro Avenue – Tanque do Moinho
Zip Code: 12.910-691 – Bragança Paulista – São Paulo – Brazil
Phone: (+55 11) 4035-8877
E-mail: uniweld@uniweld.com.br
Website: www.uniweld.com.br

Contact Uniweld
(+55 11) 4035-8877

COMMERCIAL NAME: ESSEN CN 38 L IG
STANDARD: AWS A5.9: 2012 ER 308L / ASME SFA5.9 ER 308L Edition 2015

Revision: 01
Date: 12/2018

Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
	0.030% Max.	1.00 to 2.50%	0.30 to 0.65%	0.030% max.	0.030% max.	19.50 to 22.00%	9.00 to 11.00%	0.75% Max.	0.75% Max.

APPLICATION FIELD	Nickel-chromium wire or rod for welding corrosion resistant nickel-chromium austenitic alloys. The alloy has a low carbon content which makes this alloy particularly recommended when there is a risk of intergranular corrosion. Suitable for pipes, boilers, valves, sterilizers, pumps, mixers, tanks, containers in chemical, petrochemical, pharmaceutical, food, etc.				
TECHNICAL CHARACTERISTICS	This product 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.				
MECHANICAL PROPERTIES	**Tensile strength:** 520 MPa (min.) **Stretching:** 35% (Min)				
OPERATIONAL CHARACTERISTICS	**Type of current:** CA +				
	welding position Mig: All the positions **Tig welding position**: All the positions				
	Mig shielding gas: Air or 100% CO2 (12 to 18 liters / min) **Tig shielding gas:** Air 100%				
	stickout:15 to 20 mm				
	Diameter (mm) Mig	Ø0,80	Ø0,90	Ø1,00	Ø1,20
	Diameter (mm) Tig	Ø1,60	Ø2,00	Ø2,40	Ø3,20
	Amps (A) mig	70-80	80-90	100-110	110-120
	Amps (A) Tig	160-200	200-220	220-240	240-260
	Voltage (V) mig	15-22	22-32	32-42	42-52
	Packaging (kg) Mig	15	15	15	15
	Packaging (kg) Tig	5	5	5	5
WELDING TECHNIQUE	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.				