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COMMERCIAL NAME: ESSEN CN 38 L Ti **Revision: 01**
STANDARD: AWS A5.4: 2012 E 308L-16 / ASME SFA5.4 E 308L-16 Edition 2015 **Date: 07/2016**

Chemical characteristic of the deposited metal	C	Mn	Si	Cr	Mo	Ni	Cu	P	S
	0.040% Max.	0.50 to 2.50%	1.00% Max.	18.00 to 21.00%	0.75% Max.	9.00 to 11.00%	0.75% Max.	0.040% Max.	0.030% Max.

APPLICATION FIELD	Rutile coated electrode for welding stainless steels with low content of carbon chemical composition similar or dissimilar, ferritic and martensitic steels being suitable for the industrial chemical, petrochemical, Sugarcane, pharmaceutical, pulp and paper, food, etc.															
TECHNICAL CHARACTERISTICS	Electrode that features a resistant deposit to intergranular corrosion, good appearance of the bead, easy removal of the slag, with a good yield and high deposition rate.															
MECHANICAL PROPERTIES	Tensile strength: 520 MPa (min.) Elongation: 30% (min.)															
OPERATIONAL CHARACTERISTICS	<p>Welding position: Flat, Vertical, Horizontal and On Head</p> <p>Current Type: CA - CC +</p> <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">Diameter (mm)</td> <td>Ø2,00 X 300</td> <td>Ø2,50 X 350</td> <td>Ø3,25 X 350</td> <td>Ø4,00 X 450</td> </tr> <tr> <td>Amps (A)</td> <td>40-70</td> <td>60 - 90</td> <td>90-130</td> <td>130-170</td> </tr> <tr> <td>Packaging (kg)</td> <td>4</td> <td>5</td> <td>5</td> <td>5</td> </tr> </table>	Diameter (mm)	Ø2,00 X 300	Ø2,50 X 350	Ø3,25 X 350	Ø4,00 X 450	Amps (A)	40-70	60 - 90	90-130	130-170	Packaging (kg)	4	5	5	5
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WELDING TECHNIQUE	Remove completely grease and other contaminants from the workpiece by grinding or mechanical brushing process, making the setting of device parameters according to the diameter to be used, it is recommended to work with the electrode in oscillating movements and the electrode inclined with respect to the metal base, after welding Decap apply the gel to Essen passivation and removal of residual solder carbonization.															