



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN CN 39 L Ti

Revision: 01

STANDARD: AWS A5.4: 2012 E 309L-16 / ASME SFA5.4 E 309L-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.	22.00 to 25.00%	0.75% Max.	12.00 to 14.00%	0.75% Max.	0.040% Max.	0.030% Max.

APPLICATION FIELD	Special electrode for welding stainless steels resistant to severe corrosion conditions. Suitable also for steels and cast steels with chromium / nickel steel nature equal or similar.															
TECHNICAL CHARACTERISTICS	Electrode that features a granular resistant deposit Inter 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	Welding position: Flat, Vertical, Horizontal and On Head															
	Current Type: CA - CC +															
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø2,00 X 300</th> <th>Ø2,50 X 350</th> <th>Ø3,25 X 350</th> <th>Ø4,00 X 450</th> </tr> </thead> <tbody> <tr> <td>Amps (A)</td> <td>40-70</td> <td>60 - 90</td> <td>90-140</td> <td>130-180</td> </tr> <tr> <td>Packaging (kg)</td> <td>4</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </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	90-140	130-180	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.															