



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN CN 39 Mo Ti **Revision: 01**
STANDARD: AWS A5.4: 2012 E 309LMo-17 / ASME SFA5.4 And 309LMo-17 Edition 2015
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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%	2.00 to 3.00%	12.00 to 14.00%	0.75% Max.	0.040% Max.	0.030% Max.

APPLICATION FIELD	Tanks, Vessels, Stainless coatings on carbon steel resistant to corrosion and heat, Die & Tools Forging, axles, gears, bearings, guides, rollers and lamination cylinders, press guides, tools, containers and Extrusion Discs or Continuous Casting and Cushion Hard Coatings.				
TECHNICAL CHARACTERISTICS	Rutile electrode coating areemelhante to 309 with the exception of adding 2.0 to 3.0% molybdenum increases the resistance to weld metal corrosão.O lower the carbon content reduces the possibility of corrosion and intergranular ferrite content increases, reducing the potential for solidification cracking when deposited carbon steel or low alloy.				
MECHANICAL PROPERTIES	Tensile strength: 550 MPa (min) Stretching: 30% (Min)				
OPERATIONAL CHARACTERISTICS	Welding Position: All Positions				
	Current Type: CA - CC +				
	Diameter (mm)	Ø2,00 X 300	Ø2,50 X 350	Ø3,25 X 350	Ø4,00 X 450
	Amps (A)	50-90	60 - 90	90-130	130-170
	Packaging (kg)	4	5	5	5
WELDING TECHNIQUE	Remove completely grease and other contaminants from the workpiece by the grinding process or mechanical brush, making the setting of device parameters according to the diameter to be used.				