



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 DUR 350 KB
STANDARD: DIN EN 14700 AND A 1350 GP

Review: 01
Date: 04/2019

Chemical characteristic of the deposited metal	C 0.50% Max.	Si 0.60% Max.	Mn 2.00% Max.	Cr 2.00 to 5.00%
---	---------------------------	----------------------------	----------------------------	----------------------------

APPLICATION FIELD	It is a special electrode having base coating with excellent resistance to compression, friction, impact and abrasion, the recovery of gear teeth, filling guides, rollers, guide wheels, pins, shafts, rollers, rails, links, rolling parts machine, recovery of railway equipment, forging tools, used in the steel mills industry, railway, Metallurgy, Sugar and Alcohol, Ceramics, Foundry, Cement, Mining, etc.				
TECHNICAL CHARACTERISTICS	It is an electrode for the restoration fillers and protective wear, featuring easy weldability, high deposition rate, get perfect cords, featuring excellent durability and resistance equipment.				
MECHANICAL PROPERTIES	Toughness: 325-375 HB 34 to 40 HRC				
OPERATIONAL CHARACTERISTICS	Type of current used: DC +				
	Welding position: Flat and Vertical				
	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø X 450 4.00	Ø 5.00 to 450
	Amps (A)	70 to 100	90-130	130 and 180	180-230
	Packaging (kg)	5	5	5	5
WELDING TECHNIQUE	Completely remove residues of oxides, grease, and other contaminants from the workpiece by grinding or mechanical brushing process to prepare the site to be coated to the setting of device parameters according to the diameter to be used is recommended to work with the electrode with oscillating movements and inclined relative to the base metal.				