



**UNIWEELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME: ESSEN DUR 350 TI**  
**STANDARD: DIN EN 14700 AND A 1350 GP**

**Revision: 01**  
**Date: 04/2019**

<b>Chemical characteristic of the deposited metal</b>	<b>C</b> 0.50% Max.	<b>Si</b> 0.60% Max.	<b>Mn</b> 2.00% Max.	<b>Cr</b> 2.00 to 5.00%
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<b>APPLICATION FIELD</b>	Is an electrode having rutile coating with good resistance to compression, friction, impact and abrasion, the recovery of gear teeth, guides, filling, rollers, guide wheels, pins, shafts, rollers, rails, rolling parts of the machine, recovery railway equipment, forging tools, used in the steel mills industry, railway, Metallurgy, Sugar and Alcohol, Ceramics, Foundry, Cement, Mining, etc.				
<b>TECHNICAL CHARACTERISTICS</b>	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.				
<b>MECHANICAL PROPERTIES</b>	<b>Toughness:</b> 325-375 HB 34 to 40 HRC				
<b>OPERATIONAL CHARACTERISTICS</b>	<b>Type of current used:</b> AC+				
	<b>Welding position:</b> Flat and Vertical				
	<b>Diameter (mm)</b>	Ø X 350 2.50	Ø X 350 3.25	Ø X 450 4.00	Ø 5.00 to 450
	<b>Amps (A)</b>	70 to 100	90-130	130 and 180	180-230
	<b>Packaging (kg)</b>	5	5	5	5
<b>WELDING TECHNIQUE</b>	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.				