



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN DUR 600 Special Review: 00
STANDARD: SPECIAL PRODUCT Date: 04/2019

Chemical characteristic of the deposited metal	C 0.50 2.00%	Si 0.50 1.50%	Mn 0.50 1.50%	Cr 6.00 to 8.50%
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APPLICATION FIELD	It is a special electrode for hard coating, allowing deposition with excellent resistance to abrasion, in the manufacture of parts and prolonging the lifespan of the following equipment on a base and clamping (lateral) in milling beads, carrier rollers, blade mixers, hammer mill, fountain tool or cold cut, used in steel mills, Sugar and Alcohol industries, Ceramics, Foundry, Cement, Mining, etc.				
TECHNICAL CHARACTERISTICS	It is an electrode for the restoration and fillers protective wear, with a high rate of deposition aspect of the great finish cord with moderate penetration, resistant against abrasion and impact resistant, specially developed for overbase and catching passes in friezes milling.				
MECHANICAL PROPERTIES	Toughness: 53-58 HRC				
OPERATIONAL CHARACTERISTICS	Type of current used: DC +				
	Welding position: flat				
	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø X 450 4.00	
	Amps (A)	70 to 100	90-130	130 and 180	
	Packaging (kg)	5	5	5	
WELDING TECHNIQUE	Make cleaning the area to be soldered or coated with grinding or mechanical rotary brush cutting electrode and chamfer or graphite on the surface whose area is fatigued impregnated with mill scale and impurities that must be removed not to cause contamination, making adjustment suitably amperage of the equipment according to the used diameter.				