



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN DUR 700
STANDARD: PRODUCT SPECIAL

Revision: 00
Date: 07/2019

Chemical characteristic of the deposited metal	C	Si	Mn	Cr
	2.00 5.00%	1.00 to 2.50%	0.40 to 1.20%	5.00 to 7.0%

APPLICATION FIELD	Special electrode of chromium carbide, coating with high resistance to abrasion, moderate shock especially sand used in mining and coal dredger teeth, excavators, mixers, screening buckets etc.				
TECHNICAL CHARACTERISTICS	It is intended to restore an electrode protective wear and fillers, presenting a high deposition rate, aspect of great finish bead, resistant to abrasion and provided good welding performance.				
MECHANICAL PROPERTIES	Toughness: 54 to 60 HRC				
OPERATIONAL CHARACTERISTICS	Type of current used: DC+				
	Welding position: Flat, horizontal.				
	Diameter (mm)	Ø X 350 3.25	Ø X 350 4.00	Ø X 450 5.00	
	Amps (A)	90 to 120	120 and 160	160 and 200	
Packaging (kg)	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 or joined, to the setting of device parameters according to the diameters to be used is recommended to work with the electrode with oscillating movements and inclined to the base metal.				