



**UNIWEELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME: ESSEN H 13**  
**STANDARD: SPECIAL PRODUCT**

**Revision: 00**  
**Date: 03/2019**

Chemical characteristic of the deposited metal	C	Si	P	S	Mn	Cr	Mo	Ni
	0.33 to 0.45%	1.00% Max.	0.04% Max.	0.015% Max.	1.50% Max.	15.5 to 17.5%	0.80 to 1.30%	1.00% Max.

<b>APPLICATION FIELD</b>	It is a special rod for welding steel excellent resistance to abrasion tool suitable for cutting dies coating, cutting knives plates, dies for precision cutting, tools for pressing guides for tool machines, ceramic molds and other parts require maximum resistance to abrasion and cut retention.			
<b>TECHNICAL CHARACTERISTICS</b>	It is a stick that features easy weldability, stable arc with good deposition rate and flow of the material, excellent quality and finish and featuring obtaining perfect cords. Indicated in the maintenance of applications in the automotive industries, food industries, cutting tools and industrial maintenance.			
<b>MECHANICAL PROPERTIES</b>	<b>Toughness:</b> ≥ 45 HRC			
<b>OPERATIONAL CHARACTERISTICS</b>	<b>Type of current used:</b> CA +			
	<b>Welding position:</b> flat			
	<b>Diameter (mm)</b>	X1000 Ø1,00	X1000 Ø1,20	X1000 Ø1,60
<b>Packaging (kg)</b>	1	1	1	1