



UNIWELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN HM 23 S

Review: 01

STANDARD: AWS A5.1: 2012 E 7024 / ASME SFA5.1 E 7024 Edition 2015

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Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Ni	Cr	Mo	V
	0.15% Max.	1.25% Max.	0.90% Max.	0.035% max.	0.035% Max.	0.30% Max.	0.20% Max.	0.30% Max.	0.08% Max.

APPLICATION FIELD	Special electrode carbon steel coated with high iron content powder which enables welding with high yield. Used in building profiles and fillers in general, suitable for boilers in general, pipes, galvanized sheets, agricultural equipment, sawmills, steel structures, shipbuilding, together without preparation and tack, ideal as a contact electrode to weld beads and thread.	
TECHNICAL CHARACTERISTICS	Presents a stable arc with low splash index, easy slag removal, easy opening bow and reignition, depositing strands plans and good finish, causing no bites in the base metal due to low penetration and making work more productive and facilitated.	
MECHANICAL PROPERTIES	Tensile strength: 490 MPa (min.) Yield strength: 400 MPa (min.) Stretching: 17% (min.)	
OPERATIONAL CHARACTERISTICS	welding position: Flat and Horizontal	
	Type of current: AC, DC +, DC-	
	Diameter (mm)	Ø X 300 2.00 Ø X 350 2.50 Ø X 350 3.25 Ø X 350 4.00
	Amps (A)	45 and 80 70 to 100 90-130 130-170
	Packaging (kg)	15 20 20 20
WELDING TECHNIQUE	Thoroughly clean welding area with a grinder or mechanical brushing removing all traces of contamination, for scale, oils, oxides, regulate the amperage in relation to the diameter of the electrode that will be used, it is recommended to work with oscillating movements and electrode slightly inclined to the base metal.	