



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN K7

Review: 01

STANDARD: AWS A5.7: 2007 Ercu / ASME SFA5.7 Ercu Edition 2015

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Chemical characteristic of the deposited metal	Cu	Sn	Mn	Si	P	Al	Pb
	98.0% Min.	1.00% Max.	0.50% Max.	0.50% Max.	0.15% Max.	0.010% Max.	0.020% Max.

APPLICATION FIELD	It is a special rod for welding copper or alloys of high copper content, due to its high purity has an excellent electrical conductivity, used in pipes in refrigeration and air conditioning, electrical installations (welding connectors and terminals) and hydraulic (welding copper pipes), etc.			
TECHNICAL CHARACTERISTICS	It is a stick that features easy weldability, presents a good fluidity of the deposited metal, capable of producing perfect cords and featuring a good performance in welding.			
MECHANICAL PROPERTIES	Resistance to traction: 170 MPa (min.)			
OPERATIONAL CHARACTERISTICS	Process: Oxyacetylene / TIG			
	shielding gas: Oxyacetylene: Use Flame Fuel / TIG: Argon 100%			
	Welding position: flat			
	Diameter (mm) Rod	Ø1,60 x 1000	X1000 Ø2,50	X1000 Ø3,25
Packaging (kg)	5	5	5	5
WELDING TECHNIQUE	Completely remove residues of oxides, grease and other contaminants in the area to be welded, the cleaning area is indispensable and may cause difficulty in welding, and applying the dry rod to not overload the flame. Using suitable flow when using oxyacetylene process, facilitating the dissolution of oxides and other compounds that may be adhered to the base metal surface, improving the viscosity to penetrate the gasket and providing a better finish.			