



UNIWELED IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN MS 620

Revision: 01

STANDARD: AWS A5.1: 2012 E 6020 / ASME SFA5.1 E 6020 Edition 2015

Date: 06/2016

Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Ni	Cr	Mo	V
	0.20% Max.	1.20% Max.	1.00% Max.	ND	ND	0.30% Max.	0.20% Max.	0.30% Max.	0.08% Max.

APPLICATION FIELD	Coated electrode specially designed for welding angle with high penetration of electric arc with gentle spray, suitable for pressure vessels, based heavy machinery structural components, manufacture of welded profiles, etc., used in the petrochemical, Chemistry, Metallurgy, Naval, Railway.															
TECHNICAL CHARACTERISTICS	It is an electrode that has a good weldability, good yield with high rate of deposition, featuring good aspect of the cord, easy slag removal, easy to open and re-ignition of electric arc, becoming an easier and more productive work.															
MECHANICAL PROPERTIES	Tensile strength: 430 MPa (min) Yield strength: 330 MPa (min) Stretching: 22% (min)															
OPERATIONAL CHARACTERISTICS	welding position: Flat, Horizontal															
	Type of current: AC, DC +, DC-															
	<table border="1"> <thead> <tr> <th>Diameter (mm)</th> <th>Ø X 350 2.50</th> <th>Ø X 350 3.25</th> <th>Ø X 350 4.00</th> <th>Ø X 450 5.00</th> </tr> </thead> <tbody> <tr> <td>Amps (A)</td> <td>60 to 90</td> <td>90-130</td> <td>130-170</td> <td>170-240</td> </tr> <tr> <td>Packaging (kg)</td> <td>5</td> <td>5</td> <td>5</td> <td>5</td> </tr> </tbody> </table>	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø X 350 4.00	Ø X 450 5.00	Amps (A)	60 to 90	90-130	130-170	170-240	Packaging (kg)	5	5	5	5
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WELDING TECHNIQUE	Making the removal of waste oxides, greases, for scale and other contaminants in the area to be welded with grinder or mechanical brush, it regulates the amperage in relation to the diameter of the electrode that will be used to maintain the short arc and the electrode inclined in relation to base metal, not swing the electrode more than 2 times the diameter of the soul.															