



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: MS ESSEN 70 Mo B

Revision: 00

STANDARD: AWS A5.5: 2014 E 9018-G / ASME SFA5.5 E 9018-G Edition 2015

Date: 12/2018

Chemical characteristic of the deposited metal	C ND	Mn* 1.00% Min.	Si* 0.80% Min.	P 0.03% Max.	S 0.03% Max.	Ni* 0.50% Min.	Cr* 0.30% Min.	Mo* 0.20% Min.	V* 0.10% Min.	Cu* 0.20% Min.
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Note (*): To meet the requirements alloy of the group G, the alloy must contain at least one of the elements listed in the table.

APPLICATION FIELD	Special electrode with low hydrogen basic coating on the Mo and V. beneficiáveis suitable for welding steels and fine grain high strength. Ideal for spears cranes, heat exchangers, mirrors, pipes, boiler shells, tanks. tenacious and resistant to cracking deposit.										
TECHNICAL CHARACTERISTICS	Developed beneficiáveis for welding steels and high strength fine-grained, with a stable arc, with a mean penetration, good appearance of the bead, easy removal of slag and featuring a good welding performance.										
PROPERTIES MECHANICAL	<p>Tensile strength: 620 MPa (Min)</p> <p>Yield strength: 530 MPa (Min)</p> <p>Stretching: 17% (Min)</p> <p>Impact strength (CHARPY V Joule ° C): 27J at - 50 ° C</p>										
OPERATIONAL CHARACTERISTICS	welding position: Flat, Horizontal, Vertical and On Head.										
	Type of current: AC, DC +										
	<table border="1"> <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> <tr> <th>Amps (A)</th> <td>60 to 90</td> <td>100 to 140</td> <td>140 and 180</td> <td>180-220</td> </tr> </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	100 to 140	140 and 180	180-220
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WELDING TECHNIQUE	Make cleaning the area to be welded with mechanical grinder or rotating brush impregnated with mill scale and impurities must be removed not to cause contamination, making the amperage adjustment according to the diameter to be used.										