



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN MS 85 B

Revision: 00

STANDARD: AWS A5.5: 2014 and 11018-G / ASME SFA5.5 E 11018-G Edition 2015

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Feature Chemistry 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	It is a special electrode low hydrogen with basic coating. Deposit a special alloy with nickel, providing excellent mechanical and welding properties. Beneficiáveis suitable for welding steels of fine grains and high strength.																		
TECHNICAL CHARACTERISTICS	Special electrode basic coating of low hydrogen welding used for weathering steels in contact with atmosphere saturated in SO ₂ . Suitable for welding the weather resistant steel with COLOR-MET PATINAX, YAM-TEM, NTU, SAC 50, etc.																		
PROPERTIES MECHANICAL	Tensile strength: 760 MPa (min) Yield strength: 670 MPa (min) Stretching: 15% (Min)																		
OPERATIONAL CHARACTERISTICS	welding position: All the positions																		
	Type of current: DC + AC																		
	<table border="1"> <tr> <th>Diameter (mm)</th> <td>Ø 2.50</td> <td>Ø 3.25</td> <td>Ø 4.00</td> <td>5.00 Ø</td> <td>Ø6,00</td> </tr> <tr> <th>Amps (A)</th> <td>70-100</td> <td>100-130</td> <td>130-170</td> <td>170-220</td> <td>220 -280</td> </tr> <tr> <th>Packaging (kg)</th> <td>5</td> <td>5</td> <td>5</td> <td>5</td> <td>5</td> </tr> </table>	Diameter (mm)	Ø 2.50	Ø 3.25	Ø 4.00	5.00 Ø	Ø6,00	Amps (A)	70-100	100-130	130-170	170-220	220 -280	Packaging (kg)	5	5	5	5	5
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WELDING TECHNIQUE	Thoroughly clean the area to be welded with grinder or mechanical brushing removing all traces of contamination, for scale, oils and oxides, regulate the amperage in relation to the diameter of the rod that will be used to maintain the short arc with the nozzle perpendicular to the metal base.																		