



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN Mn 14

Review: 01

STANDARD: AWS A5.13: 2000 E FeMn-A / ASME SFA5.13 E FeMn-A Edition 2015

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Chemical characteristic of the deposited metal	C	Mn	Si	Ni
	0.50 to 1.0%	12.0 to 16.0%	1.30% Max.	2.50 to 5.0%

APPLICATION FIELD	It is a special electrode for joining and coating of parts and equipment which occurs wear by severe abrasion, manganese steel (HADFIELD) developed for the following jaws parts, cone crushers, excavators teeth, impact blades, buckets of components, crossing tracks , crushers, hammer mill, earthmoving machines, etc.			
TECHNICAL CHARACTERISTICS	It is an electrode easy weldability, stable arc, good deposition rate, get perfect cords, featuring excellent durability and resistance equipment.			
MECHANICAL PROPERTIES	Toughness: 200 to 250 HB / job After reaching 450 HB			
OPERATIONAL CHARACTERISTICS	Type of current used: DC+			
	Welding position: Flat, Vertical, Horizontal and On Head			
	Diameter (mm)	3.25 X 350	4.00 X 450	5.00 X 450
	Amps (A)	90-130	140 and 180	180-220
	Packaging (kg)	5	5	5
WELDING TECHNIQUE	<p>Completely remove residues of oxides, grease and other contaminants from the workpiece by the grinding process or mechanical brush, preparing the site to be welded, making the setting of device parameters according to the diameter to be used.</p> <p>In the case of application of multiple layers, making the application pad with LH or Essen CN 37 CN 29/9 R Essen, the application of the material should be made with the previously immersed in running water piece exposing only the surface to be coated, if it is not possible to use moist, minimizing heating and cooling of the strands uniformly, not exceeding the working temperature of around 300° C.</p>			