



**UNIWELD IND. DE ELETRODOS LTDA**

Address: 1788, XV de Dezembro Avenue – Tanque do Moinho  
 Zip Code: 12.910-691 – Bragança Paulista – São Paulo – Brazil  
 Phone: (+55 11) 4035-8877  
 E-mail: [uniweld@uniweld.com.br](mailto:uniweld@uniweld.com.br)  
 Website: [www.uniweld.com.br](http://www.uniweld.com.br)

**Contact Uniweld**

**(+55 11) 4035-8877**

**COMMERCIAL NAME: ESSEN RAPID 68 S**  
**STANDARD: SPECIAL PRODUCT**

**Revision: 01**  
**Date: 02/2019**

Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Cr	Mo	V
	0.30 to 0.80%	1.00% Max.	1.00% Max.	0.040% Max.	0.030% Max.	2.00 to 4.00%	1.70 to 3.50%	0.20% Max.

<b>APPLICATION FIELD</b>	It is a special electrode suitable for the recovery and production of cutting tools, punches, dies, dies, etc. Its deposit has high hardness and can be deposited in thermally treated. Its metallurgical structure and chemical composition provide a weld deposit applicable for both cold work as hot.															
<b>TECHNICAL CHARACTERISTICS</b>	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.															
<b>MECHANICAL PROPERTIES</b>	Hardness HRC = 60 Annealed = 30 HRC After heat treatment hardness HRC = 65															
<b>OPERATIONAL CHARACTERISTICS</b>	<b>welding position:</b> All the positions															
	<b>Type of current:</b> AC, 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><b>Amps (A)</b></td> <td>60 to 80</td> <td>90 to 120</td> <td>130 to 150</td> <td>180-220</td> </tr> <tr> <td><b>Packaging (kg)</b></td> <td>4 kg</td> <td>5 kg</td> <td>5 kg</td> <td>5 kg</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	<b>Amps (A)</b>	60 to 80	90 to 120	130 to 150	180-220	<b>Packaging (kg)</b>	4 kg	5 kg	5 kg	5 kg
	Diameter (mm)	Ø X 350 2.50	Ø X 350 3.25	Ø X 350 4.00	Ø X 450 5.00											
<b>Amps (A)</b>	60 to 80	90 to 120	130 to 150	180-220												
<b>Packaging (kg)</b>	4 kg	5 kg	5 kg	5 kg												
<b>WELDING TECHNIQUE</b>	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.															