



**UNIWEELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME: ESSEN TUB BM 25**  
**STANDARD: SPECIAL PRODUCT**

**Revision: 01**  
**Date: 04/2019**

Chemical characteristic of the deposited metal	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Mo</b>
	0.50% Max.	1.00% Max.	1.20 to 3.00%	1.20 to 3.00%	0.20 to 0.60%

<b>APPLICATION FIELD</b>	It is a special tubular wire with gas protection, directed and developed to coat parts where there is wear by severe abrasion as hammers and knives picotadoras in Sucroalcoleira industries.				
<b>TECHNICAL CHARACTERISTICS</b>	It is a wire that features easy weldability, stable arc, high deposition rate, allowing to obtain perfect cords, featuring excellent durability and resistance equipment.				
<b>MECHANICAL PROPERTIES</b>	<b>Toughness:</b> 360-415 HB 38 to 44 HRC				
<b>OPERATIONAL CHARACTERISTICS</b>	<b>Type of current used:</b> CC +				
	<b>Welding position:</b> flat				
	<b>Stick out:</b> 15 mm				
	<b>shielding gas:</b> Do not use				
	<b>Reel (mm)</b>	1.60 mm Ø	Ø 2,40mm		
	<b>Amps (A)</b>	150 to 250	220-250		
<b>Voltage (V)</b>	19 to 27	32 to 36			
<b>Packaging (kg)</b>	12.50	20 or 25			
<b>WELDING TECHNIQUE</b>	If necessary to clean the area to be coated grinder or rotating mechanical brush cutting electrode and chamfer or graphite, the surface whose area is fatigued impregnated with mill scale and impurities which must be removed not to cause contamination making the appropriately regulating the voltage and amperage of the equipment according to the used diameter.				