



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN TUB CR 63
STANDARD: SPECIAL PRODUCT

Revision: 00
Date: 04/2019

Chemical characteristic of the deposited metal	C	Si	Mn	Cr
	3.00 to 5.00%	1.50% Max.	0.70% Max.	18.00 to 23.00%

APPLICATION FIELD	Special cored wire, auto protected, depositing a rich alloy chromium carbide high hardness indicated and developed for coating parts and equipment where there is wear by severe abrasion, especially for coating knives and hammers in Sucroalcoleira industries and also used in Cement industries, ceramics, mining, steelworks, Agriculture and etc.																								
TECHNICAL CHARACTERISTICS	It is a wire that features easy weldability, stable arc, high deposition rate, deposit free of slag, allowing to obtain perfect cords, featuring excellent durability and resistance equipment.																								
MECHANICAL PROPERTIES	Toughness: 55 to 60 HRC																								
OPERATIONAL CHARACTERISTICS	Type of current used: CC +																								
	Welding position: flat																								
	Stick out: 15 mm																								
	shielding gas: Do not use																								
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WELDING TECHNIQUE	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, do properly adjusting the amperage and voltage of the machine according to the used diameter.																								