



**UNIWELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME:** ESSEN TUB CR 67  
**STANDARD:** SPECIAL PRODUCT

**Review:** 01  
**Date:** 04/2019

Chemical characteristic of the deposited metal	C	Si	Mn	Cr	Mo	Nb
	2.80 to 4.20%	0.30 to 1.00%	0.30 to 1.00%	17.00 to 21.00%	0.40 to 1.00%	0.80 to 1.20%

<b>APPLICATION FIELD</b>	Special cored wire, auto protected, depositing a rich alloy carbides of high hardness chromium indicated and developed for coating parts and equipment where there is wear by severe abrasion, especially for coating knives and hammers in Sugar and Ethanol industries and also used in Cement industries, ceramics, mining, steelworks, Agriculture and etc.					
<b>TECHNICAL CHARACTERISTICS</b>	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.					
<b>MECHANICAL PROPERTIES</b>	<b>Toughness:</b> 56 to 61 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>	Ø1,60	Ø2,00	Ø2,40		
	<b>Amps (A)</b>	150 to 250	200 to 300	250 to 350		
	<b>Voltage (V)</b>	18 to 25	19 to 27	28 to 35		
<b>Packaging (kg)</b>	12.50	12.50	20 or 25			
<b>WELDING TECHNIQUE</b>	Make cleaning 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 suitably adjusting the amperage and voltage of the machine according to the used diameter.					