



**UNIWEELD IND. DE ELETRODOS LTDA**

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**COMMERCIAL NAME: ESSEN TUB FL 55**  
**STANDARD: SPECIAL PRODUCT**

**Review: 01**  
**Date: 05/2019**

<b>Chemical characteristic of the deposited metal</b>	<b>C</b> 0.40 to 1.00%	<b>Si</b> 0.40 to 1.00%	<b>Mn</b> 0.70 to 1.50%	<b>Cr</b> 6.00 to 7.50%
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<b>APPLICATION FIELD</b>	Wheel crane, Blowers, rails, etc.				
<b>TECHNICAL CHARACTERISTICS</b>	Self tubular wire protected, which produces a deposit with wear resistance by metal to metal rubbing or shearing as well as a median abrasion. It may be used carbon steel, low alloy steel and alloy steel to manganese.				
<b>MECHANICAL PROPERTIES</b>	<b>Toughness:</b> 50 to 55 HRC				
<b>OPERATIONAL CHARACTERISTICS</b>	<b>Type of current used:</b> CC +				
	<b>Welding position:</b> Flat and Horizontal				
	<b>Stick out:</b> 15 mm				
	<b>Protective gas:</b> Do not use				
	<b>Reel (mm)</b>	Ø1,60	2.40 Ø	Ø 2.80	
	<b>Amps (A)</b>	Between 150 and 230	260-350	280-420	
	<b>Voltage (V)</b>	18 to 25	20 to 30	25 to 35	
	<b>Packaging (kg)</b>	12.50	20 or 25	20 or 25	