



UNIWELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN TUB MF 86
STANDARD: SPECIAL PRODUCT

Revision: 01
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Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Ni	V	Cr	Mo
	0.10 0.20%	0.50 1.20%	0.20 to 0.80%	0.030% max.	0.030% max.	1.50 to 2.20%	0.20% Max.	5.50 to 6.50%	1.50 to 2.40%

APPLICATION FIELD	Suitable for recovery and repair of forging hammers.	
TECHNICAL CHARACTERISTICS	Tubular wire depositing an alloy of Ni-Cr-Mo-V low carbon content, excellent for filler surfaces forging hammers. The deposited metal has an excellent wear resistance at high temperatures up to 650° C and thermal shock, good mechanical strength.	
MECHANICAL PROPERTIES	Toughness: 40 - 45 HRC	
OPERATIONAL CHARACTERISTICS	Type of current: CC; HERE	
	Welding position: flat	
	shielding gas: 100% CO2	
	Stick-out: 15 to 22 mm	
	Diameter (mm)	2.40 Ø
	Amps (A)	350-550
Voltage (V)	30 to 40	
Packaging (kg)	12.50	
WELDING TECHNIQUE	<p>Prepare the area to be welded eliminating surface contamination such as oils, greases and fats, removing fatigued material, cracks, pores and cracks. Check all the parts that involve the process, check the welding parameters.</p> <p>It is recommended preheat and interpass temperature control to prevent cold cracks. Preheating 350-420° C, observing the chemical composition and dimensions of the part. Place the wire in the temperature range above, raising the temperature about 500 ° C and in ovens at this same temperature for a further 4 hours.</p> <p>Cool slowly to room temperature.</p>	