



UNIWEELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN TUB RAPID 68 S
STANDARD: SPECIAL PRODUCT

Review: 01
Date: 06/19

Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Cr	Mo	V
	0.30 to 0.80%	0.50 to 1.50%	0.50% Max.	0.030% Max.	0.030% Max.	3.00 to 5.00%	0.80 to 1.80%	0.30% Max.

APPLICATION FIELD	Suitable for coating carbon steel, manganese steel, stainless steels, tool steels and cast iron. The main applications are: punches, stamping dies, forging, cutting and pressing, cutting knives and scissors. The maximum working temperature must not exceed 550° C.							
TECHNICAL CHARACTERISTICS	Special tubular wire tool steel developed for applications requiring toughness minutes, combined with high resistance to shock and cracking, good as moderate abrasion resistance. The hardness of the deposit can be changed by heat treatment.							
MECHANICAL PROPERTIES	Hardness HRC = 57 to 62							
OPERATIONAL CHARACTERISTICS	Stick out: 15 mm							
	shielding gas: CO2 15 - 20 l / min.							
	Diameter (mm)	1.20 Ø	Ø 1.60					
	Amps (A)	140 and 180	180-220					
	Voltage (V)	18 to 24	22 to 30					
Packaging (kg)	12.50	12.50						