



COATED ELECTRODE FOR TOOLING

ESSEN WA 12

Classificações: **DIN EN 14700 E UM 3 60 T**

Special electrode indicated for the recovery of tools that work in both hot and cold environments. Extra tough, suitable for deburring tools, knives and guillotines, plate shear blades, drawing tools, filling corners, cutting knives, large and medium dies. The deposit has minimal penetration, which is a significant advantage for corner recovery. Essen WA 12 is characterized by excellent resistance and toughness combined with good wear resistance at high temperatures. AISI: H12-H01-H13-H10-H20 DIN: 17006Cr Mo W51-X38 Cr Mo V51 X32 Cr Mo V 33 – X30 W Cr V 93 – X30 WRC V 53

ALLOY TYPE:

C 0,60% Máx.	Mn 0,50% Máx.	Si 0,50 % Máx.	Mo 0,50% a 1,90%	V 0,90% Máx	W 4,00% Máx.	Cr 4,00 a 7,00%
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MECHANICAL PROPERTIES:

HARDNESS

56 a 58 HRC

Após tratamento térmico: 52 a 57 HRC

WELDING CURRENT:

CC+; CA



Flat



Vertical

PRODUCT CHARACTERISTICS:

DIAMETER (mm):	LENGTH (mm):	AMPERAGE (A):	PACKAGING (kg):
2,50	350	60 a 80	5,00
3,25	350	90 a 120	5,00
4,00	350	120 a 150	5,00
5,00	450	150 a 200	5,00

CUSTOMER SERVICE POLICY

The above information is for reference purposes only, it should not be considered as a guarantee or certificate. Many variables can influence the results of a welding operation. Uniweld Industria de Eletrodos LTDA is not responsible for any incorrect application of the product, We recommend that, if you have any questions, you contact our Technical Assistance department to get adequate support.