

Electrode UONI-13/55



Type E50A

Electrodes brand UONI-13/55 designed for manual arc welding is particularly responsible designs and low-carbon steels, when the metal welds make demands on the plasticity and impact strength, especially when working in conditions of low temperatures. Welding in all-dimensional position than vertical top-down, direct current reverse polarity and variable currents of power supply with a voltage idling (70 ± 10) V.

The recommended value of current (A)

Diameter, mm	seam position		
	lower	vertical	ceiling
2,5	55-80	50-65	45-65
3,0	90-120	80-100	70-90
4,0	130-150	130-140	110-130
5,0	180-210	160-180	-

Melting electrodes

- Coefficient of surfacing, g / Ah: 9.0
- Depletion of electrodes on 1kgs surfaced metal kg: 1.7

The main characteristics of the metal and weld metal surfaced

The mechanical properties of metal weld, not less

- Temporary breaking strength, MPa: 490
- Relative elongation, %: 20
- Impact strength, J / cm², at a temperature of +20 ° C: 130
- Impact strength, J / cm², at a temperature of -40 ° C: 35

Chemical composition surfaced metal%

- Carbon, no more: 0.12
- Manganese: 0,70-1,20
- Silicon: 0,20-0,50
- Sulfur, no more: 0,030
- Phosphorus, no more: 0,030

GOST 9466-75

GOST 9467-75

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