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# UNITOR RANGE OF MAINTENANCE ELECTRODES

The Unitor Arc Welding Electrodes range for Shipboard Welding includes electrodes for



- \* Mild and low alloy steels
- \* Cast steels
- \* Heat resistant steel
- \* Low temperature steel
- \* Weathering steel
- \* Stainless and acid-resistant steels
- \* Tool- and machine-part steels
- \* Cast iron
- \* Aluminium and aluminium alloys
- \* Copper and copper alloys
- \* Air-carbon-arc gouging
- \* Gouging with standard equipment

## Product information

### A product range selected for maritime use with the best welding properties

The Unitor welding electrodes range has been carefully selected to cover all normally occurring applications onboard. These high quality, high efficiency welding electrodes are designed for easy to weld even in difficult positions.

The versatility of Unitor welding electrodes enables each electrode to cover a wide range of applications that help vessel to reduce the number of electrode types needed on board and for welding standardization.

#### Features

- Class (DNV-GL, ABS, BV and LR) approved for Joining electrodes
- Low Moisture Absorption (LMA) properties for electrodes used in structural welding
- High quality and high deposition efficiency
- Recyclable high density polyethylene packaging for maritime conditions

#### Benefits

- "LMA Electrodes" reduces the electrodes moisture absorption rate especially for high humidity maritime environment to avoid hydrogen porosities or cold cracking in weld
- Easy to weld without high demands on the welder's skill ensuring high productivity
- The packaging protects electrodes from moisture pickup, contamination and physical damage
- The information label on packaging provides all relevant information including usage and application

## Specification

### Variants

Product name	Product number
<u>18/8-321N 1.6X300MM 213 PCS 1.7 KG</u>	699397 (supersedes 606433)
<u>18/8-321N 2.5X300MM 89 PCS 1.7 KG</u>	699405 (supersedes 606434)
<u>18/8-321N 3.2X300MM 54 PCS 1.7 KG</u>	699413 (supersedes 606435)
<u>23/14-322N 2.5X300MM 84 PCS 1.7 KG</u>	699421 (supersedes 606436)
<u>23/14-322N 3.2X350MM 50 PCS 2.0 KG</u>	699439 (supersedes 606437)
<u>23/14-322N 4.0X350MM 35 PCS 2.0 KG</u>	699447 (supersedes 606438)
<u>ACA-384 15X5X305MM 50 PCS 2.1 KG</u>	758458 (supersedes 699561)
<u>ACA-384 6.3X305MM 50 PCS 0.8 KG</u>	758474 (supersedes 699546)
<u>ACA-384 8.0X305MM 50 PCS 1.3 KG</u>	758466 (supersedes 699553)
<u>ALBRONZE-344 3.2X350MM 46PCS 1.3 KG</u>	606457 (supersedes 233668)

Product name	Product number
<u>ALUMIN-351N 3.2X350MM71 PCS 1.1 KG</u>	699538 (supersedes 233676)
<u>CH2-382 3.2 X 350MM36 PCS 1.4 KG</u>	606459 (supersedes 233684)
<u>DUFLEX-325N 2.5X300MM91 PCS 1.7 KG</u>	699454 (supersedes 606238)
<u>DUFLEX-325N 3.2X350MM55 PCS 2.0 KG</u>	699462 (supersedes 606239)
<u>GPO-302N 2.5X350MM295 PCS 5.2KG</u>	699165 (supersedes 535401)
<u>GPO-302N 3.2X350MM190 PCS 5.4 KG</u>	699173 (supersedes 535385)
<u>GPO-302N 4.0X350MM120 PCS 5.2 KG</u>	699181 (supersedes 535393)
<u>GFR-300H 3.2X450MM85 PCS 5.8 KG</u>	699231 (supersedes 606444)
<u>GFR-300H 4.0X450MM51 PCS 5.5 KG</u>	699249 (supersedes 606445)
<u>GFR-300H 5.0X450MM35 PCS 5.6 KG</u>	699256 (supersedes 606446)
<u>GFR-300H 6.0X450MM23 PCS 5.3KG</u>	699260 (supersedes 658179)
<u>IMPACT-329S 3.2 X 350MM39PCS 1.4KG</u>	606460 (supersedes 519728)
<u>LH-314N 2.5X350MM161 PCS 4.0 KG</u>	699264 (supersedes 605857)
<u>LH-314N 3.2X450MM96 PCS 5KG</u>	699272 (supersedes 303057)
<u>LH-314N 4.0X450MM78 PCS 5.6 KG</u>	699280 (supersedes 303065)
<u>LHH-314H 4.0X450MM54 PCS 5.5 KG</u>	699298
<u>LHH-314H 5.0X450MM36 PCS 5.5 KG</u>	699306
<u>LHL-319N 2.5X350MM78 PCS 1.8 KG</u>	683631 (supersedes 606447)
<u>LHL-319N 3.2X350MM48 PCS 1.8 KG</u>	683649 (supersedes 606448)
<u>LHR-320 N 2.5X350MM88 PCS 1.7 KG</u>	683656
<u>LHR-320N 3.2X350MM48 PCS 1.8 KG</u>	699389
<u>LHT-318N 2.5X350MM75 PCS 1.7 KG</u>	699330 (supersedes 606449)
<u>LHT-318N 3.2X350MM48 PCS 1.7 KG</u>	699348 (supersedes 606450)
<u>LHV-316N 3.2X350MM137 PCS 4.8 KG</u>	699314 (supersedes 592949)
<u>LHV-316N 4.0X350MM99 PCS 5.0 KG</u>	699322 (supersedes 592956)
<u>NICKEL-333N 2.5X300MM121PCS 2.0 KG</u>	699496 (supersedes 602946)
<u>NICKEL-333N 3.2X350 68 PCS 2.2 KG</u>	699504 (supersedes 606451)
<u>NIFE-334N 3.2X350MM68 PCS 2.2 KG</u>	699512 (supersedes 546523)
<u>NIFE-334N 4.0X350MM51 PCS 2.4 KG</u>	699520 (supersedes 546515)
<u>SPECIAL-303N 2.0X350MM115PCS 1.7KG</u>	699199 (supersedes 606442)
<u>SPECIAL-303N 2.5X350MM200PCS 4.1KG</u>	699207 (supersedes 606439)
<u>SPECIAL-303N 3.2X350MM120PCS 4.1KG</u>	699215 (supersedes 606440)
<u>SPECIAL-303N 4.0X450MM75 PCS 5.2KG</u>	699223 (supersedes 606441)
<u>TENSILE-328N 2.5X300MM79PCS 1.6 KG</u>	699470 (supersedes 606452)
<u>TENSILE-328N 3.2X350MM50PCS 2.0 KG</u>	699488 (supersedes 606453)
<u>TINBRO-341 3.2 X 350 MM42PCS 1.4KG</u>	606458 (supersedes 558445)
<u>WEARMAX-327 2.5 X 350MM49PCS 1.6KG</u>	606454 (supersedes 604274)
<u>WEARMAX-327 3.2 X 350MM68PCS 3.5KG</u>	606455 (supersedes 604280)
<u>WEARMAX-327 4.0 X 350MM42PCS 3.4KG</u>	606456 (supersedes 604298)

## Directions for use

The label on each box fully identifies the contents, and also gives basic information on application areas. Further, the Uitor Welding Handbook for maritime welders provides complete information on each electrode, with instructions for use and application examples.

## For stainless steel materials

Pickling gel, product number 661778 should be used

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