



## Unibraze 67

**CLASSIFICATIONS:** AWS A5.7/ASME SFA 5.7 Class ERCuNi      UNS C71581

**DESCRIPTION:** Unibraze 67 is used for TIG, MIG, and SAW welding of 70/30, 80/20 and 90/10 copper-nickel alloys. It is also used for surfacing of steel if a barrier layer of Unibraze 61 is applied first. Unibraze 67 has excellent resistance to corrosion in sea water, and is used for desalination and marine applications.

### TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Pb	Ti	Others
.15 max		29.0- 32.0		1.0 max	.25 max	.02 max	.01 max	.40- .75	Bal.	.02 max	.20- .50	.50 max

### TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	53,000 psi (360 MPa)
Yield Strength	21,000 psi (140 MPa)
Elongation	32%

### TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	Shielding Gas
MIG	.035" (.9mm)	26-29	150/190	75% Ar/25% He
	.045" (1.14mm)	28-32	180/220	
	.062" (1.6mm)	29-33	200/250	
TIG	.035" (.9mm)	12-15	60-90	100% Ar
	.045" (1.14mm)	13-16	80-110	
	1/16" (1.6mm)	14-18	90-130	
	3/32" (2.4mm)	15-20	120-175	
	1/8" (3.2mm)	15-20	150-220	
SAW	3/32" (2.4mm)	28-30	275-350	Suitable Flux
	1/8" (3.2mm)	29-32	350-450	
	5/32" (4.0mm)	30-33	400-550	

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.