



# Unibraze X

(ERNiCrMo-2)

Unibraze X is a nickel-chromium-iron filler metal used for MIG, TIG, and Plasma arc welding of Hastelloy® X to itself, to carbon steels, low alloy steels, and stainless steels. Weld metal deposited by Unibraze X has high temperature strength and resists weld metal fatigue at up to 2200°F. It is commonly used in the aerospace industry and to combat stress corrosion cracking in petro-chemical applications.

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## Typical Chemical Composition(%)

*Conforms to the AWS specification*

Ni	Balance	C	.10 max.
Cr	20.5 – 23.0	Mo	8.0 – 10.0
W	0.2 – 1.0	P	0.04 max.
Si	1.0 max.	Co	0.5 – 2.5
Mn	1.0 max.	Fe	17.0 – 20.0
S	0.03 max.	C	0.05 – 0.15
Cu	0.50 max.	Others	0.50 max.

## Typical Mechanical Properties (As Welded)

*Conforms to the AWS specification*

Tensile Strength	109,500 psi, min.
Yield Strength	55,900 psi min.
Elongation, % in 2 in.	45% min.

## Specifications

AWS A5.14 Class ERNiCrMo-2

ASME SFA 5.14 Class ERNiCrMo-2

AMS 5798

## Available Sizes

mm	.9	1.14	1.6	2.4	3.2
in	.035	.045	.062	.093	.125
			1/16	3/32	1/8