

UNIBRAZE® 82-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCr3T1-1/-4

Description:

UNIBRAZE 82-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications. Some typical applications include joining Ni-Cr-Fe alloys, surfacing steel with Ni-Cr-Fe weld metal, or joining Inconel® 600, 601 and Incoloy® 800 to themselves or to stainless and carbon steels.

Typical Deposit Chemistry					
C	Mn	Fe	P	S	Si
0.10 max	2.5 - 3.5	3.0 max	0.03 max	0.015 max	0.50 max
Cu	Ni	Co	Cr	Nb(Cb) + Ta	
0.50 max	67 min		18.0- 22.0	2.0-3.0	
Mo	V	W	Other	Ti	
			0.50 max	0.75 max	

Typical Mechanical Properties

Tensile Strength	89,000 psi
Yield Strength	58,000 psi
Elongation % in 2"	26 %

UNIBRAZE® 182-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrFe3T1-1/-4

Description:

UNIBRAZE 182-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications such as joining Ni-Cr-Fe alloys, surfacing steel with Ni-Cr-Fe weld metal or joining Alloys 600, 601 or joining Inconel® 600, 601 and Incoloy® 800 to themselves or to stainless and carbon steels.

Typical Chemistry Analysis					
C	Mn	Fe	P	S	Si
0.10 max	5.0 - 9.5	10.0 max	0.03 max	0.015 max	1.0 max
Cu	Ni	Co	Cr	Nb(Cb) + Ta	
0.50 max	59 min		13.0- 17.0	1.0 - 2.5	
Mo	V	W	Other	Ti	
			0.50 max	1.0 max	

Typical Mechanical Properties

Tensile Strength	94,000 psi
Yield Strength	58,000 psi
Elongation % in 2"	35 %

UNIBRAZE® 622-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrMo10T1-1/-4

Description:

UNIBRAZE 622-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. The wire possesses excellent weldability and is used in welding Ni-Cr-Mo alloys. Typical specifications for the Ni-Cr-Mo base metals are ASTM B574, B575, B619, B622, and B626, all of which have UNS# N06022.

Typical Deposit Chemistry					
C	Mn	Fe	P	S	Si
0.02 max	1.0 max	2.0 - 6.0	0.03 max	0.015 max	0.2 max
Cu	Ni	Co	Cr	Mo	V
0.50 max	Rem	2.5 max	20.0 - 22.5	12.5 - 14.5	0.35 max
W	Other				
2.5 - 3.5	0.50 max				

Typical Mechanical Properties

Tensile Strength	115,000 psi
Yield Strength	82,000 psi
Elongation % in 2"	34 %

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Data contained in this catalog are typical of the products described, but are not suitable for specifications.



UNIBRAZE® 625-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrMo3T1-1/-4

Description:

UNIBRAZE 625-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Ar/CO₂ mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications. Some typical applications include joining Ni-Cr-Mo alloys, surfacing steel with Ni-Cr-Mo weld metal, joining steels to nickel based alloys, and joining 9% nickel steel for cryogenic applications.

Typical Chemistry Analysis						
C	Mn	Fe	P	S	Si	
0.10 max	0.50 max	5.0 max	0.02 max	0.015 max	0.50 max	
Cu	Ni	Co	Cr	Nb(Cb) + Ta		
0.50 max	58 min		20.0 - 23.0	3.15 - 4.15		
Mo	V	W	Other	Ti		
8.0 - 10.0			0.50 max	0.40 max		

Typical Mechanical Properties	
Tensile Strength	112,000 psi
Yield Strength	72,000 psi
Elongation % in 2"	38 %

UNIBRAZE® A-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrFe2T1-1/-4

Description:

UNIBRAZE A-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications such as joining Ni-Cr-Fe alloys, joining nickel steels, or joining Inconel® 600, 601 and Incoloy® 800 to themselves or to stainless and carbon steels.

Typical Chemistry Analysis						
C	Mn	Fe	P	S	Si	
0.10 Max	1.0 - 3.5	12.0 max	0.03 max	0.02 max	0.75 max	
Cu	Ni	Co	Cr	Nb(Cb) + Ta		
0.50 max	62 min		13.0 - 17.0	0.5 - 3.0		
Mo	V	W	Other			
0.5 - 2.5			0.50 max			

Typical Mechanical Properties	
Tensile Strength	89,000 psi
Yield Strength	51,000 psi
Elongation % in 2"	45 %

UNIBRAZE® C276-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrMo4T1-1/-4

Description:

UNIBRAZE C276-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. The wire possesses excellent weldability and is used in welding Low Carbon Ni-Cr-Mo alloys to other nickel base alloys. Typical specifications for the Ni-Cr-Mo base metals are ASTM B574, B575, B619, B622, and B626, all of which have UNS# N10276.

Typical Chemistry Analysis						
C	Mn	Fe	P	S	Si	
0.02 max	1.0 max	4.0 - 7.0	0.03 max	0.03 max	0.2 max	
Cu	Ni	Co	Cr	Mo	V	
0.50 max	Rem	2.5 max	14.5 - 16.5	15.0 - 17.0	.035 max	
W	Other					
3.0 - 4.5	0.05 max					

Typical Mechanical Properties	
Tensile Strength	110,000 psi
Yield Strength	75,000 psi
Elongation % in 2"	37 %

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