

UNIBRAZE[®] 1100

Description:

UNIBRAZE 1100 is the ultimate electrode for welding all types of steels, without any danger of cracking or breakage. Special "FERRITE BALANCED" Chemistry also allows UNIBRAZE 1100 to serve as a "STUD PULL" electrode. Due to exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for the aluminum and copper alloys. Also recommended for repairing worn parts and as an underlay for hardfacing.

Specifications	
Type:	Coated Electrode (DCEP) or AC
Welding Position:	Flat, Horizontal, Vertical up, Overhead
Typical Deposit Characteristics:	
Tensile strength	132,300 psi
Yield strength	94,000 psi
Elongation	36%
Hardness	320 HB

UNIBRAZE[®] Cast SM

Description:

UNIBRAZE CastSM is a solid core welding electrode for the welding of most cast irons, including gray cast iron and spheroidal graphite cast iron parts. With a unique non-nickel series core rod, the weld zone of the reclaimed part is almost indistinguishable from the parent material after welding. UNIBRAZE CastSM has an extremely smooth welding arc, and excellent slag fluidity. Weldability, crack resistance, as well as workability and mechanical properties are all excellent.

Specifications	
Type:	Coated Electrode (DCEP) or AC
Welding Position:	Flat, Horizontal, Vertical up
Typical Deposit Characteristics:	
Tensile strength	84,000 psi
Elongation	27%
Hardness	180 HB

UNIBRAZE[®] Cast DM

Description:

UNIBRAZE CastDM is a solid core welding electrode for the welding of most cast irons, including gray cast iron and spheroidal graphite cast iron parts as well as dissimilar metals (carbon steel, stainless). With a unique non-nickel series core rod, the weld zone of the reclaimed part is almost indistinguishable from the parent material after welding. UNIBRAZE CastDM has an extremely smooth welding arc, and excellent slag fluidity. Weldability, crack resistance, as well as workability and mechanical properties are all excellent.

Specifications	
Type:	Coated Electrode (DCEP) or AC
Welding Position:	Flat, Horizontal, Vertical up
Typical Deposit Characteristics:	
Tensile strength	84,000 psi
Elongation	27%
Hardness	180 HB

UNIBRAZE also carries the full line of Stoodly[®] and McKay[®] Hardfacing and M&R electrodes.

Please visit the UNIBRAZE web site at www.unibraze.com for the full line of electrodes available.

UNIBRAZE[®] IS A REGISTERED TRADEMARK OF UNIBRAZE CORP.

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



UNIBRAZE® Techniwear 25

Description:

UNIBRAZE Techniwear 25 is a low alloy buildup wire with very good compressive strength and resistance to plastic deformation. It is an ideal base for subsequent overlay with a more wear resistant alloy. UNIBRAZE Techniwear 25 is also good when an easily machined "as welded" deposit is required. Use on carbon and low alloy steels.

Specifications	
Wire Type:	Metal-cored, Gas-shielded Deposits are slag-free
Gas:	Ar/CO2 mix or 98/2 Ar/Ox
Typical Deposit Characteristics:	
Hardness:	21 - 25 Rc
Deposit Thickness	Unlimited
Deposits can be flame cut	
Deposits are fully machinables	

UNIBRAZE® Techniwear 40

Description:

UNIBRAZE Techniwear 40 is a medium hardness build-up wire with excellent compressive strength. It is recommended for applications where weld deposits must provide good metal-to-metal wear resistance, but still be machinable "as welded". Use on carbon and low alloy steels.

Specifications	
Wire Type:	Metal-cored, Gas-shielded Deposits are slag-free
Gas:	Ar/CO2 mix or 98/2 Ar/Ox
Typical Deposit Characteristics:	
Hardness:	31 - 38 Rc
Deposit Thickness	Unlimited
Deposits can be flame cut	
Machinable with carbide tools	

UNIBRAZE® Techniwear 50

Description:

UNIBRAZE Techniwear 50 is a chromium carbide hardfacing alloy that produces a controlled microstructure of specially sized carbides in a very tough matrix. For applications involving high impact combined with abrasion. Weld metal is tougher than conventional chromium carbide alloys with fewer stress relieving check-cracks.

Specifications	
Wire Type:	Metal-cored, open-arc or gas-shielded. Deposits are slag-free
Typical Deposit Characteristics:	
Hardness:	45 - 50 Rc
Deposit Thickness	3-5 layers
Deposits can not be flame cut	
Deposits are non-machinable	

UNIBRAZE® Techniwear 56

Description:

UNIBRAZE Techniwear 56 is a general purpose self-hardening overlay with a good combination of resistance to abrasion and impact. Unibrazed Techniwear 56 is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100 F (595 C).

Specifications	
Wire Type:	Metal-cored, Gas-shielded Deposits are slag-free
Gas:	Ar/CO2 mix or 98/2 Ar/Ox
Weld Deposit Properties:	
Hardness:	55-59 Rc
Deposit Thickness	2-3 layers
Good Hot-hardness: up to 1100° F	
Deposits are non-machinable	

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UNIBRAZE® Techniwear 61

Description:

UNIBRAZE Techniwear 61 is a premium chromium carbide alloy that has a high volume fraction of carbides dispersed in a hard matrix. UNIBRAZE Techniwear is used for applications involving high abrasion and mild or moderate impact. The deposit polishes in service and is heat resistant to 1000°F (531°C). Use on carbon and low alloy steels.

Specifications	
Wire Type:	Metal-cored, open-arc or gas-shielded. Deposits are slag-free
Weld Deposit Properties:	
Hardness:	58-62 Rc
Deposit Thickness	1-2 layers
Deposits cannot be flame cut	
Deposits are non-machinable	

UNIBRAZE® Techniwear CF65

Description: "CHROME FREE "

UNIBRAZE Techniwear CF65 is an economical high hardness, chromium-free hardfacing overlay designed for applications involving general abrasion or abrasion combined with impact.

Specifications	
Wire Type:	Metal-cored, open-arc or gas-shielded. Deposits are slag-free
Typical Deposit Characteristics:	
Hardness:	60-65 Rc
Deposit Thickness	2 layers
Deposits are non-machinable	

UNIBRAZE also carries the full line of Stoodly® and McKay® Hardfacing and M&R wires. Please visit the UNIBRAZE web site at www.unibraise.com for the full line of wires available.

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