

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[®] 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 %

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 %



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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 %

Please note that not all of the UNIBRAZE Nickel Flux Cored Wires are listed in this catalog. If you can not find what you are looking for, please contact us toll free at 1-800-364-6900 or directly at 1-713-869-6000.

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



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