



UNIBRAZE 625T-1

Specification: AWS A5.34 /ASME SFA5.34 Class ENiCrMo3T1-1/ENiCrMo3T1-4

Description: Unibraze 625T-1 is an all position, gas-shielded, flux cored, nickel-based electrode, used to weld 625, 601, 802, and 9% Ni steels to themselves and to steel. Unibraze 625T-1 is also utilized for surfacing, and to clad steel with corrosion resistance is required. Applications include heat exchangers, marine and offshore, and for joining 9% Ni steels in LNG storage and to join steel to Ni based alloys.

Shielding Gases: 100% CO₂, 75/80% Ar/ CO₂ balance 30-40 cfh

Typical Deposit Chemistry (75% Ar/25% CO₂)

C	Mn	Si	Cr	Ni	Mo	Fe	Nb
.03	.15	.40	21.5	Bal	9.0	.60	3.8

Typical Mechanical Properties (75% Ar/25% CO₂)

Tensile Strength	117,000 psi
Yield Strength	68,,000 psi
Elongation	39%
CVN @ -320°F	70 ft. lbs.

Optimum Welding Parameters (75% Ar/25% CO₂)*

Diameter	Position	Amps	Volts	WPS
.045"	Flat	190	27	400
	Overhead	140	26	300
	Vertical up	140	26	300
1/16"	Flat	200	26	225
	Overhead	175	24	175
	Vertical Up	175	24	175

(1/2 - 5/8" contact tip to work distance)

**For CO₂ shielding gas increase voltage by 1/2 – 1 volt.*