



UNIBRAZE C276T-1

Specification: AWS A5.34 /ASME SFA5.34 Class ENiCrMo4T1-1/ENiCrMo4T1-4

Description: Unibrazed C276T-1 is an all position, gas-shielded, flux cored, nickel-based electrode, used to weld Ni-Cr-Mo to itself and other nickel alloys. Unibrazed C276T-1 is also utilized for surfacing, and for joining nickel-based alloys to steel. Unibrazed C276T-1 has excellent corrosion resistance to crevice corrosion and pitting. It is used in pipelines, pressure vessels, chemical processing plants, offshore oil and gas facilities and marine environments.

Shielding Gases: 100% CO₂, 75/80% Ar/ CO₂ balance

Typical Deposit Chemistry *

C	Cr	Mn	W	Ni	Mo	Fe
.02	15.9	.40	4.1	Bal	16.1	6.0

Typical Mechanical Properties *

Tensile Strength	108,000 psi
Yield Strength	64,000 psi
Elongation	42%
CVN @ -320°F	31 ft-lbs.

* Properties shown are with 100% CO₂ shielding gas. 75% Ar/25% CO₂ results are very similar.

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

Diameter	Position	Amps	Volts	WPS
.045"	Flat	180	27	400
	Overhead	140	26	300
	Vertical up	140	26	300
1/16"	Flat	250	26	300
	Overhead	200	26	200
	Vertical Up	200	26	200

(Use 1/2" contact tip to work distance)

**For 100% CO₂ shielding gas increase voltage by 1 1/2 – 2 volts.