



Unibraze 385-16

AWS A5.4/ASME SFA 5.4 Class E385-16 (904L) UNS WW88904

Unibraze 385-16 is used for welding of materials of similar chemical composition (UNS N08904). It is used in the fabrication of equipment and vessels for handling and storage of sulfuric and phosphoric acid. The weld metal is fully austenitic and as such, the low melting constituents such as carbon, silicon and phosphorus should be kept low. Welding must be done with low heat input, using a stringer bead technique

AWS CHEMISTRY

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
.03 max	19.5- 21.5	24.0- 26.0	4.2- 5.2	1.0- 2.5	.75 max	.03 max	.02 max	1.2- 2.0

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	88,000 psi (610 MPa)
Yield Strength	65,500 psi (450 MPa)
Elongation	32%

TYPICAL WELDING PARAMETERS:

Dia.	Volts	Amps Flat	Amps Vertical/Overhead
3/32"	24-28	70-85	65-75
1/8"	26-30	85-110	80-90
5/32"	28-32	110-140	100-120
3/16"	28-32	12-160	110-130

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.