



Unibraze P-20

Specifications: AISI P20 Werkstoff 1.2330
EN10204 3.1 (Chemical Analysis) 2.2 (Mechanical Properties)

Description: Unibraze P20 is a Chromium – Manganese – Molybdenum welding wire used for large and medium sized molds for plastic processing, mold frames for injection molding and die cast industries.

Welding Process:

Shielding Gas: TIG = 100% Argon

Polarity: TIG = DC-

Recommended preheat temperature: Preheat slowly and uniformly at ~572°F

Typical Chemical Composition

C	Si	Mn	P	S	Cu	Cr	Mo
.35	.50	.80	<.025	<.025	<.25	1.7	.45

Cu includes Cu coating

Typical Mechanical Properties

Rm	Rs	Al% 5d	Kv +20°C	Kv -40 °C	Hardness	Hardness
(N/mm ²)	(N/mm ²)		J	J	HB	HRC
						34-38

Mechanical properties may change by the heat of the material, shielding gas, parameters and other factors.