



# Unibrazed Z702

## Specifications

AWS A5.24 /ASME SFA 5.24 Class ERZr-2      UNS R60702

## Description

Unibrazed Z702 is a “commercially pure” zirconium used to weld pressure vessels, heat exchangers, tanks, pipe, mixers pumps and other corrosion resistant applications. Zirconium is a reactive metal and is sensitive to embrittlement by oxygen, nitrogen and hydrogen at temperatures above 1100°F (590°C). The zirconium metal should be free of heavy oxide and should be chemically cleaned prior to welding, as contamination will also cause embrittlement.

## Chemical Analysis (as welded)

Zr + Hf	Hf	Fe +Cr	O	H	N	C
99.01 Min.	4.5	.20	.16	.005	.025	.05

*Single values are maximum except as noted*

## Mechanical Properties (as welded)

Tensile Strength	55,000 psi min
Yield Strength	30,000 psi min
Elongation	16% min

## Typical Welding Parameters (GTAW)

Diameter	Amps	Volts	Argon (cfh)
1/16”	80-150	12-15	20
3/32”	130-200	12-15	20
1/8”	180-225	12-15	25