



Unibraze #60

ERNiCr-C

Specifications

AWS A5.21 /ASME SFA 5.21 Class ERNiCr-C

Description

Unibraze # 60 is an all position Nickel, chrome, silicon, boron continuous cast hardfacing rod that forms complex borides and carbides in a nickel matrix. Unibraze #60 has excellent abrasion resistance, good corrosion pitting and galling resistance, and fair impact resistance. Unibraze #60 can be used in a range of applications including shaft sleeves, bushings, valves, pump parts, dies, oil extraction screws, centrifuges, etc. It is not machinable but may be ground. Deposits maintain hardness up to 1200°F. Weld deposits are smooth and can be applied to low and medium carbon steels, cast iron and stainless steels. Argon shielding gas and DCEN current is recommended.

Typical Chemical Analysis

C	Si	B	Cr	Ni	Fe	Hardness
.65	4.0	3.1	14.0	Bal	4.0	54-62 HRC

Composition and properties depend upon dilutions. Single layer deposit properties depend upon base material and/or build up material.