



## Unibraze 44

(AWS A5.15/ASME SFA 5.15 ERNiFeMn-CI)

### DESCRIPTION:

Unibraze 44 is an all position wire recommended for GMAW and GTAW welding of ductile, gray and malleable cast irons. The addition of Manganese in Unibraze 44 increases the welds resistant to cracking. Pre and post weld heat treatment is not required but can be helpful for heavy fully restrained joints. The welds are moderately hard and require carbide tipped tools for machining.

### TYPICAL CHEMISTRY:

C	Ni	Mn	Fe	Others
.3	44.0	11.0	45.0	1.0

### TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	100,000 psi (690 MPa)
Elongation	35%

### TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	Shielding Gas
MIG	.035" (.9mm)	26-29	150/190	75% Ar/25 He
	.045" (1.14mm)	28-32	180/220	
TIG	1/16" (1.6mm)	14-18	90-130	100% Ar
	3/32" (2.4mm)	15-20	120-175	
	1/8" (3.2mm)	15-20	150-220	

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.