Unibraze 62
(Modified)

CLASSIFICATIONS: AWS A5.14/ASME SFA 5.14 Class ERNiCrFe-5 (Except Mn & Fe)

DESCRIPTION: Unibraze 62 is a modified nickel alloy wire used for GMAW and GTAW welding of alloy 600 in thicknesses up to 2 inches. Unibraze 62 has been modified to minimize stress cracking by reducing the iron (<6%) and increasing the manganese (>1.0%) content. The weld metal exhibits the same high temperature strength and oxidation resistance as the alloy 600 base metal.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mn	Co	Si	P	S	Fe	Cu	Nb+ Ta	Ti	Al
.011	17.0	72.6	2.9*	.01	.16	.003	.002	4.8**	.01	1.8	.40	.16

***NOTE**: AWS 5.14 ERNiCrFe-5 *Mn%= 1.0 Max **Fe% = 6.0-10.0*

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	80,000 psi
Yield Strength	40,000 psi
Elongation	30%

TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	Shielding Gas
MIG	.035" (.9mm) .045" (1.14mm) .062" (1.6mm)	26-29 28-32 29-33	150/190 180/220 200/250	75% Ar/25% He
TIG	.035" (.9mm) .045" (1.14mm) 1/16" (1.6mm) 3/32" (2.4mm) 1/8" (3.2mm)	12-15 13-16 14-18 15-20 15-20	60-90 80-110 90-130 120-175 150-220	100% Ar

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.

Unibraze Corporation 1050 Penner Crest Houston, TX 77055 1-800-364-6900 www.unibraze.com