



## Unibraze 718

**CLASSIFICATIONS:** AWS A5.14/ASME SFA 5.14 Class ERNiFeCr-2 UNS N07718

**DESCRIPTION:** Unibraze 718 is used for GTAW welding of 718, 706, and X-750 alloys. The weld metal is age hardenable and has mechanical properties comparable to the base metal.

### TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Nb + Ta	Al	Ti	Others
.08 max	17.0-21.0	50.0-55.0	2.8-5.5	.35 max	.35 max	.015 max	.015 max	Bal	.30 max	4.75-5.50	.20-.80	.65 - 1.15	.50 max

### TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	125,000 psi (860 MPa)
Yield Strength	91,000 psi (630 MPa)
Elongation	27%

### TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	Shielding Gas
TIG	.035" (.9mm)	12-15	60-90	100% Ar
	.045" (1.14mm)	13-16	80-110	
	1/16" (1.6mm)	14-18	90-130	
	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.