



Unibraze 330

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER330 UNS N08331

DESCRIPTION: Unibraze 330 is used to weld cast and wrought material of similar chemical composition. The weld metal provides excellent heat and scale resistance up to 1800°F. However, high sulfur environments may adversely affect elevated temperature performance.

TYPICAL CHEMISTRY:

C-	Cr	Ni	Mo	Mn	Si	P	S	Cu	FN (WRC)
.18-.25	15.0-17.0	34.0-37.0	.75 max	1.0-2.5	.30-.65	.03 max	.03 max	.75 max	0

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	84,000 psi (580 MPa)
Yield Strength	56,500 psi (390 MPa)
Elongation	29%

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Gas Flow	Diameter	Voltage	Amperage
MIG	98/99% Ar +2/1% O 97%Ar + 3% CO ₂	30 to 50 CFH	.035" (.9mm)	26-29	160 /210
			.045" (1.14mm)	28-32	180/250
			.062" (1.6mm)	29-33	200/280
TIG	100% Ar		1/16" (1.6mm)	14-18	90/130
			3/32" (2.4mm)	15-20	120/175
			1/8" (3.2mm)	15-20	150/220
SUBARC	Suitable Flux		3/32" (2.4mm)	28-33	275/350
			1/8" (3.2mm)	29-32	350/450

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.