



Unibraze C276

CLASSIFICATIONS: AWS A5.14/ASME SFA 5.14 Class ERNiCrMo-4 UNS N10276

DESCRIPTION: Unibraze C276 is used for GTAW, GMAW and SAW welding of alloy C276 and other Ni-Cr-Mo alloys, as well as dissimilar materials of nickel base alloys, steels and stainless steels. The high Mo content offers strong resistance to stress corrosion cracking, pitting and crevice corrosion.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Co	V	W	Others
.02 max	14.5- 16.5	Bal	15.0- 17.0	1.0 max	.08 max	.04 max	.03 max	4.0- 7.0	.50 max	2.5 max	.35 max	3.0- 4.5	.50 max

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	105,000 psi (720 MPa)
Yield Strength	81,000 psi (560 MPa)
Elongation	40%

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	
	.062" (1.6mm)	29-33	200/250	
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	
SAW	3/32" (2.4mm)	28-30	275-350	Suitable Flux
	1/8" (3.2mm)	29-32	350-450	
	5/32" (4.0mm)	30-33	400-550	

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.