



UNIBRAZE 1400

Classification: AWS A5.6/ASME SFA 5.6 ECuSn-C UNS: C52100
DIN 1733 EL-CuSn8

Description: **Unibraz 1400** is an all position Phos-Bronze electrode used for joining copper-based alloys of similar composition and stainless steel and cast-iron dissimilar applications. The higher Sn content of the material results in increased hardness, tensile and yield strength compared to ECuSn-A. It provides good color match and will work harden. Weld deposits are ductile, strong and machinable. **Unibraz 1400** is corrosion resistant to salt water and chemicals. Applications include, overlay on pumps, shafts, impellers, and propeller blades, as well as build up on bearing journals and frictional wear surfaces on heavier sections, galvanized iron and ornamental iron. Remove all surface contamination from the weld area. Maintain a short arc gap and fill in craters prior to extinguishing the arc

Typical Weld Deposit Chemistry

Cu**	Zn*	Sn	Mn*	Fe	Si*	Ni*	P	Al	Pb	Others
Bal.	0.003	8.0	.01	.10	.05	.05	.10	.001	.01	≤.50

*Included in Others **includes Ag

Typical Mechanical Properties (All Weld Metal)

Tensile Strength	50,000 psi
Yield Strength	30,000 psi
Elongation	24%
Brinell Hardness	85-100

Typical Welding Parameters (AC-DCEN)

Diameter	Amps
3/32"	75-105
1/8"	100-135
5/32"	120-160

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.