

UNIBRAZE® 1100 Electrode

Description:

UNIBRAZE 1100 is the ultimate electrode for welding all types of steels, without any danger of cracking or breakage. Special "FERRITE BALANCED" Chemistry also allows UNIBRAZE 1100 to serve as a "STUD PULL" electrode. Due to exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for the aluminum and copper alloys. Also recommended for repairing worn parts and as an underlay for hardfacing.

Specifications	
Type:	Coated Electrode (DCEP) or AC
Welding Position:	Flat, Horizontal, Vertical up, Overhead
Typical Deposit Characteristics:	
Tensile strength	132,300 psi
Yield strength	94,000 psi
Elongation	36%
Hardness	320 HB

UNIBRAZE® Techniwear 40

Description:

UNIBRAZE Techniwear 40 is a medium hardness build-up wire with excellent compressive strength. It is recommended for applications where weld deposits must provide good metal-to-metal wear resistance, but still be machinable "as welded". Use on carbon and low alloy steels.

Specifications	
Wire Type:	Metal-cored, Gas-shielded Deposits are slag-free
Gas:	Ar/CO2 mix or 98/2 Ar/Ox
Typical Deposit Characteristics:	
Hardness:	31 - 38 Rc
Deposit Thickness	Unlimited
Deposits can be flame cut	
Machinable with carbide tools	

UNIBRAZE® Techniwear 50

Description:

UNIBRAZE Techniwear 50 is a chromium carbide hardfacing alloy that produces a controlled microstructure of specially sized carbides in a very tough matrix. For applications involving high impact combined with abrasion. Weld metal is tougher than conventional chromium carbide alloys with fewer stress relieving check-cracks.

Specifications	
Wire Type:	Metal-cored, open-arc or gas-shielded. Deposits are slag-free
Typical Deposit Characteristics:	
Hardness:	45 - 50 Rc
Deposit Thickness	3-5 layers
Deposits can not be flame cut	
Deposits are non-machinable	

UNIBRAZE® Techniwear 56

Description:

UNIBRAZE Techniwear 56 is a general purpose self-hardening overlay with a good combination of resistance to abrasion and impact. Unibraze Techniwear 56 is very tough with excellent resistance to chipping and spalling. Deposits will retain their hardness and maintain a good cutting edge up to 1100 F (595 C).

Specifications	
Wire Type:	Metal-cored, Gas-shielded Deposits are slag-free
Gas:	Ar/CO2 mix or 98/2 Ar/Ox
Weld Deposit Properties:	
Hardness:	55-59 Rc
Deposit Thickness	2-3 layers
Good Hot-hardness: up to 1100° F	
Deposits are non-machinable	



THE SOURCE FOR ALL YOUR WELDING PRODUCTS

UNIBRAZE® Techniwear 61

Description:

UNIBRAZE Techniwear 61 is a premium chromium carbide alloy that has a high volume fraction of carbides dispersed in a hard matrix. UNIBRAZE Techniwear is used for applications involving high abrasion and mild or moderate impact. The deposit polishes in service and is heat resistant to 1000°F (531°C). Use on carbon and low alloy steels.

Specifications

Wire Type: Metal-cored, open-arc or gas-shielded. Deposits are slag-free

Weld Deposit Properties:

Hardness: 58-62 Rc

Deposit Thickness 1-2 layers

Deposits cannot be flame cut

Deposits are non-machinable

UNIBRAZE also carries the full line of Stoddy® and McKay® Hardfacing and M&R electrodes and wires.

Please visit the UNIBRAZE web site at www.unibraze.com for the full line of wires available.

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Data contained in this catalog are typical of the products described, but are not suitable for specifications.

M&R HARD FACING



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