Unibraze 320LR-16

Specifications: AWS A5.4/ASME SFA 5.4 Class E320LR-16 UNS W88022

Description: **Unibraze 320LR-16** is a corrosion resistant austenitic SMAW stainless steel electrode similar in composition to 320. **Unibraze 320LR-16** *Low Residual* chemistry is designed to improve weldability and reduce the possibility of microfissuring. C, Si, P, and S are controlled to lower limits and Nb and Mn are kept to a narrower range. It used to join Alloy 20 to itself and to nickel based alloys, stainless steel, low alloy and carbon steels. Applications include heat exchangers, petrochemical and high temperature, long term service in power generation plants. Low heat input is advised during welding to prevent solidification cracking.

Typical Chemistry

C	Cr	Ni	Mo	Nb+Ta	Mn	Si	P	S	Cu	FN
.02	19.9	33.8	2.3	.10	1.7	.16	.016	.006	3.2	NA

Typical Mechanical Properties

Tensile Strength	85,000 psi (590 MPa)
Yield Strength	57,000 psi (390 MPa)
Elongation	34%

Typical Welding Parameters (AC/DC+)

Diameter	3/32”	1/8”	5/32”	3/16”
Amperage	40-80	75-110	95-150	130-200
Voltage	24-28	26-30	28-32	28-32

Packaging

Length	12”	14”	14”	14”
Weight	8 lbs.	10 lbs.	10 lbs.	10 lbs.