Unibraze 825

CLASSIFICATIONS: AWS A5.14/ASME SFA 5.14 Class ERNiFeCr-1 UNS N08065

DESCRIPTION: Unibraze 825 is used for welding of Ni-Fe-Cr-Mo-Cu alloy (ASTM B423 UNS N08825) It is highly corrosion resistant in sulfuric and phosphoric acids.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Al	Ti
.01	21.5	38.4	2.7	.5	.15	.002	.001	33.6	2.0	.08	.70

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	88,500 psi (610 MPa)
Yield Strength	61,000 psi (420 MPa)
Elongation	34%

TYPICAL WELDING PARAMETERS:

	Diameter	Volts	Amps	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	

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