Unibraze 321

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER321 UNS S32180

DESCRIPTION: Unibraze 321 is a 19.5% Chromium 9.5% Nickel with added Titanium that is used to weld Cr-Ni stainless steels of similar chemical composition. The addition of titanium increases the resistance to intergranular corrosion.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Ti
.08	18.5-20.5	9.0-10.5	.75	1.0-2.5	.30-.65	.03	.03	.75	9xC-1.0

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Gas Flow	Diameter	Voltage	Amperage
MIG	98/99% Ar +2/1% O 97%Ar + 3% CO_2	30 to 50 CFH	.035" (.9mm) .045" (1.14mm) .062" (1.6mm)	26-29 28-32 29-33	160 /210 180/250 200/280
TIG	100% Ar		1/16" (1.6mm) 3/32" (2.4mm) 1/8" (3.2mm)	14-18 15-20 15-20	90/130 120/175 150/220