

AI-0460

Specifications

AWS A 5.15: E Ni Fe-CI

DIN 8573: E-Ni Fe – 1 – BG-23

ISO R1071: E-Ni Fe- BG-23

Description and Applications

AI 460 is a nickel iron electrode with a copper flashed core wire designed for improved current transfer and subsequent lower amperages. It can be used for maintenance welding and repair of most types of cast iron particularly malleable, nodular and phosphorous (P >0.20%) irons.

AI 460 exhibits excellent welding characteristics for out of position welding in both DC and AC mode.

Typical Weldmetal Analysis

C	Ni	Fe	Mn	Si	Cu
1.2	52	Bal	0.8	1.2	6

Mechanical Properties of Weldmetal

Tensile Strength	435 MPa
Yield Strength (0.2%)	325MPa
Hardness	200HB
Elongation	8% (4d)

Welding

DC –ve,

AC60V

Positions: Horizontal, Fillet, vertical up, horizontal vertical, overhead, 45° incline, 45° decline

Weldability is excellent in all positions

Available Sizes & Forms

2.5, 3.2, 4.0mm electrodes

MIG wire: AI-1799CI or AI1765

Disclaimer

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