

AI-0460

Specifications

AWS/ASME 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-0460 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-0460 exhibits excellent welding characteristics for out of position welding in both DC and AC mode.

Typical Weldmetal Analysis

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

Mechanical Properties of Weldmetal

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

Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-70
3.2	DC /AC	70-110
4.0	DC /AC	110-140

MIG wire: AI-1799CI or AI-1765

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up

Disclaimer

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