

AMPCO-TRODE® 46

Nickel-Aluminium-Bronze

Classifications

AWS A5.6 Class E CuNiAl
ASME SFA 5.6 Class E CuNiAl

Description

- AMPCO-TRODE® 46 nickel-aluminium bronze was developed for the welding of cast and wrought nickel-aluminium bronze.
- AMPCO-TRODE® 46 is also recommended for weld repairing NiBral boat propellers.
- Typical applications include ship fittings, power plant valves, intake screens, welding AMPCO® 45, oil recovery pumps, propeller gear housings, marine propulsion systems, ship propellers, piping systems and welding AMPCO® 483.



Limiting chemical composition of all-weld metal (%)

Cu*	Al	Fe	Ni	Mn	Si	Others
Rem.	8.50-9.50	3.0-6.0	4.0-6.0	0.5-3.50	1.5 max	0.5 max

*Including silver

Mechanical properties (nominal all-weld metal values)

	Y.S. (MPa)	T.S. (MPa)	El. (% in 51mm)	Area Reduction %	BHN (3000 kg) (6.4 mm deposit)
Example	400	683	25	22	187

Sizes available

Diameter	(mm)	3.2	4.0
Length	(mm)	356	356

Recommended welding parameters

Refer to AMPCO® welding products brochure or website for recommended welding parameters.