



AMPCO-TRODE® 46

Nickel-Aluminium-Bronze

Classifications

AWS A5.7 Class ER CuNiAl

ABS Certified: ER CuNiAl

ASME SFA 5.7 Class ER CuNiAl

*MIL-E-23765/3A Type MIL-CuNiAl

*Note: A weld test is required on each Heat/lot of material to conform to MIL-E23765/3A

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	3.0-5.0	4.0-5.50	0.60-3.50	0.10 max	0.50 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	407	718	23	22	196

Sizes available

Diameter	(mm)	0.9	1.2	1.6
Spool size	(kg)	0.68 & 13.6	0.68 & 13.6	13.6

Recommended welding parameters

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