



# HI-ALLOY 460MC

## METAL CORED WIRE FOR CAST IRON WELDING

**DESCRIPTION:** Hi-Alloy 460MC is a unique wire, with a powdered metal alloy core, that produces strong yet machinable weld deposits. This product will provide outstanding performance while joining or repairing all weldable grades of cast iron. A combination of high tensile strength and superior elongation allows for repair of nodular, malleable and grey cast irons. Continuous welding with this gas shielded alloy reduces porosity and the thermal stresses created by the frequent starts and stops encountered when welding with standard coated electrodes.

**TYPICAL APPLICATIONS:** Repair of cast iron dies, pumps, pump housings, cylinder heads, engine blocks, molds, gears, bearing seats, machine bases, and heavy equipment.

**PROCEDURES:** Clean the weld area and remove cracked, contaminated, or worn metal with Hi-Alloy Metal Mover or by grinding. On heavy sections preheat to 500° - 600° F. Peen deposit immediately with the ball end of a ball peen hammer to distribute stresses. Allow finished part to cool slowly in still air.

**AVAILABLE SIZES:** .045 diameter on 11# -8" spools or 33# -12" spools

**AMPERAGE RANGE:** 220 - 260

**VOLTAGE RANGE:** 27 - 30

**POLARITY:** DC Reverse

**SHIELDING GAS:** 98% Argon 2% Oxygen

**STICK OUT:** 1/2"

**TENSILE STRENGTH:** Up to 74,000 psi

**HARDNESS:** Up to Rockwell B 190

**ELONGATION:** Up To 12%