

NOTICE OF
ADOPTION

ADOPTION NOTICE
 15 August 1990 for
 AMS 6460D
1 January 1990
 SUPERSEDING
 AMS 6460C
 10 August 1984

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Title of Document: Wire, Steel Welding
 0.75Si - 0.62Cr - 0.20Mo - 0.10Zr (0.10 - 0.17C)

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AEROSPACE MATERIAL SPECIFICATION

AMS 6460D

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Superseding AMS 6460C

Submitted for recognition as an American National Standard

WIRE, STEEL WELDING
0.75Si - 0.62Cr - 0.20Mo - 0.10Zr (0.10 - 0.17C)

UNS K11365

1. SCOPE:

- 1.1 Form: This specification covers a low-alloy steel in the form of welding wire.
- 1.2 Application: Primarily for use as filler metal for gas-tungsten-arc and gas-metal-arc welding of low-alloy steels requiring a joint capable of being heat treated to strength levels consistent with the metals joined.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2259 - Chemical Check Analysis Limits, Wrought Low-Alloy and Carbon Steels

AMS 2350 - Standards and Test Methods

AMS 2370 - Quality Assurance Sampling of Carbon and Low-Alloy Steels, Wrought Products Except Forgings and Forging Stock

AMS 2813 - Packaging of Welding Wire, Standard Method

AMS 2815 - Identification, Welding Wire, Line Code System

AMS 2816 - Identification, Welding Wire, Color Code System

2.1.2 Aerospace Recommended Practices:

ARP1876 - Weldability Test for Weld Filler Metal Wire

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2.2 ASTM Publications: Available from ASTM, 1916 Race Street, Philadelphia, PA 19103.

ASTM E 350 - Chemical Analysis of Carbon Steel, Low-Alloy Steel, Silicon Electrical Steel, Ingot Iron, and Wrought Iron

3. TECHNICAL REQUIREMENTS:

3.1 Composition: Shall conform to the following percentages by weight, determined by wet chemical methods in accordance with ASTM E 350, by spectrochemical methods, or by other analytical methods acceptable to purchaser:

	min	max
Carbon	0.10	0.17
Manganese	0.50	0.80
Silicon	0.60	0.90
Phosphorus	--	0.040
Sulfur	--	0.040
Chromium	0.50	0.75
Molybdenum	0.15	0.25
Zirconium	0.05	0.15
Nickel	--	0.25
Copper	--	0.35

3.1.1 Check Analysis: Composition variations shall meet the applicable requirements of AMS 2259.

3.2 Condition: Cold drawn, bright finish, in a temper which will provide proper feeding of the wire in machine welding equipment.

3.2.1 Wire shall be furnished on disposable spools for machine welding and in cut lengths for manual welding, as ordered.

3.2.2 Surface texture of spooled wire shall be as agreed upon by purchaser and vendor.

3.2.3 Drawing compounds, oxides, dirt, and oil shall be removed by cleaning processes which will neither result in pitting nor cause gas absorption by the wire or deposition of substances harmful to welding operations.

3.2.4 When specified, wire shall be copper-flash coated and shall exhibit a thin, continuous, adherent copper coating.

3.3 Properties: Wire shall conform to the following requirements:

3.3.1 Weldability: Melted wire shall flow smoothly and evenly during welding and shall produce acceptable welds, determined by a procedure agreed upon by purchaser and vendor. The referee method of ARP1876 may be used to resolve weldability disputes.

3.3.2 Spooled Wire: Shall conform to 3.3.2.1 and 3.3.2.2.

3.3.2.1 Cast: Wire, wound on standard 12-inch (305-mm) diameter spools, shall have imparted to it a curvature such that a specimen sufficient in length, 4 to 8 feet (1219 to 2438 mm), to form one loop, when cut from the spool and laid on a flat surface, shall form a circle 15 - 30 inches (381 - 762 mm) in diameter.

3.3.2.2 Helix: The specimen on which cast was determined, when laid on a flat surface and measured between adjacent turns, shall show a vertical separation not greater than 1 inch (25 mm).

3.4 Quality: Wire, as received by purchaser, shall be uniform in quality and condition, sound, and free from foreign materials and from imperfections detrimental to welding operations, operation of welding equipment, or properties of the deposited weld metal.

3.5 Sizes and Tolerances: Wire shall be supplied in the sizes and to the tolerances shown in 3.5.1 and 3.5.2.

3.5.1 Diameter:

TABLE I

Form	Nominal Diameter Inch	Tolerance, Inch	
		plus	minus
Cut Lengths	0.030, 0.045, 0.062, 0.078	0.002	0.002
Cut Lengths	0.094, 0.125, 0.156, 0.188	0.003	0.003
Spools	0.007, 0.010, 0.015, 0.020	0.0005	0.0005
Spools	0.030, 0.035, 0.045	0.001	0.002
Spools	0.062, 0.078, 0.094	0.002	0.002

TABLE I (SI)

Form	Nominal Diameter Millimetres	Tolerance, Millimetre	
		plus	minus
Cut Lengths	0.76, 1.14, 1.57, 1.98	0.05	0.05
Cut Lengths	2.39, 3.18, 3.96, 4.78	0.08	0.08
Spools	0.18, 0.25, 0.38, 0.51	0.013	0.013
Spools	0.76, 0.89, 1.14	0.03	0.05
Spools	1.57, 1.98, 2.39	0.05	0.05