



AEROSPACE MATERIAL SPECIFICATIONS

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc.

485 Lexington Ave., New York, N. Y. 10017

AMS 6462C

Superseding AMS 6462B

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STEEL WIRE, WELDING 0.95Cr - 0.20V (0-28 - 0.33C) (SAE 6130)

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. APPLICATION: Primarily for use as filler metal for inert gas arc welding of low alloy steels where the joint is capable of being heat treated to 150,000 psi tensile strength.
3. COMPOSITION:

	min	max
Carbon	0.28	0.33
Manganese	0.70	0.90
Silicon	0.20	0.35
Phosphorus	--	0.025
Sulfur	--	0.025
Chromium	0.80	1.10
Vanadium	0.15	0.25
Nickel	--	0.25
Molybdenum	--	0.06
Copper	--	0.35

- 3.1 Check Analysis: Composition variations shall meet the requirements of the latest issue of AMS 2259, paragraph titled "Low Alloy Steels".

4. CONDITION:

- 4.1 Unless otherwise specified, wire shall be cold drawn, bright finish, as-drawn temper. Wire shall be furnished on disposable spools for machine welding and in cut lengths for manual welding operations, as ordered.
- 4.2 Drawing compounds, oxides, and dirt shall be removed.
- 4.3 When specified, wire shall be copper flash coated and shall exhibit a thin, continuous, adherent copper coating.

5. TECHNICAL REQUIREMENTS:

- 5.1 Welding: Melted wire shall flow smoothly and evenly during welding and be capable of producing acceptable welds.
- 5.2 Spooled Wire: Shall conform to the following unless otherwise agreed upon by purchaser and vendor.
 - 5.2.1 Cast: Wire shall have imparted to it a curvature such that a specimen sufficient in length to form one loop, when cut from the spool and laid on a flat surface, shall form a circle not less than 15 in. and not greater than 30 in. in diameter.
 - 5.2.2 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.

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