

Classifications

EN ISO 14343-A

AWS A5.9

G ZCr 18 NbTi L

ER430(mod)

Characteristics and typical fields of application

Special GMAW solid wire for joint welding and surfacing of exhaust systems. For analogous or similar materials. Double stabilized (Nb + Ti) with minimum affection to grain growth. Resists scaling up to +900°C. Outstanding feeding characteristics. Very good welding and flow characteristics.

Base materials

1.4509 X5CrTiNb 18, 1.4016 X6Cr17, 1.4511 X3CrNb17
AISI 430, AISI 441

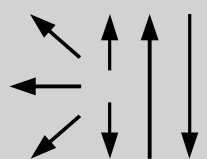
Typical analysis of solid wire (wt.-%)

	C	Si	Mn	Cr	Nb	Ti
wt.-%	0.02	0.5	0.5	18.0	> 12xC	0.40

Mechanical properties of all-weld metal

Condition	Brinell-hardness
	HBW
u	150
a	130
u	untreated, as welded – shielding gas Ar + 0.5 – 5% CO ₂
a	annealed, 760°C / 2h – shielding gas Ar + 0.5 – 5% CO ₂

Operating data

	Polarity:	Shielding gases:	ø (mm)
	DC (+)	Argon + 0.5 – 5% CO ₂	1.0
		Argon + 0.5 – 3% O ₂	1.2