

430

CATEGORY GMAW-GTAW Solid wires

TYPE Solid stainless steel welding wire for ferritic stainless steels

APPLICATIONS 17% chromium solid wire for GMAW welding

CLASSIFICATION

AWS	A 5.9: ER 430
EN ISO	14343-A: G 17 14343-A: SS 430
DIN: W.Nr.	1.4015
DIN	8556: SG X 8 Cr 18

SUITABLE FOR 1.4511, X3CrNb17, 1.4512, 1.4510, 1.4526, 1.4509, 1.4016, X6Cr17, AISI, 430

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo	Nb
0.07	0.7	0.8	17.5			

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	300	450	15				

AW: as welded, PWHT: Post Weld Heat Treated.

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spooling type	kg / spool / drum	kg / pallet
0.8	12-24	55-160	B-300 / drum	15 / 250	1080 / 1000
1.0	15-28	80-240	B-300 / drum	15 / 250	1080 / 1000
1.2	15-29	100-300	B-300 / drum	15 / 250	1080 / 1000

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175: M11, M12, M13