

MIGWELD 430 LNb

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION: EN ISO 14343-A : G 18 LNb AWS A-5.9 : ER 430 LNb W.Nr. : 1.4511	APPROVALS:	APPLICATION: Constructions & Engineering
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- Stabilized stainless steel (nickel free) welding wire for ferritic steels.
- Used where good resistance to corrosion is required, especially related to car exhaust fumes and thermal fatigue.

Application

The wire is developed and designed for the automotive industry and is used, for example, in the production of exhaust systems and catalytic converters.

Kitchen haberdashery

Fasteners

Food processing

Devices

Haberdashery inside buildings

Base material

AISI/ASTM	EN 10088-1/2	W.Nr.
430	X3CrNb17	1.4511
	X6CrNb17	1.4511
430	X6Cr17	1.4016
430	X8Cr17	1.4016
409	X2CrTi12	1.4512
439	X3CrTi17	1.4510
436	X6CrMoNb17-1	1.4526
441	X2CrTiNb18	1.4509

Typical chemical composition %

C	Si	Mn	Cr	Ni	Nb
0,01	0,80	0,50	17,60	0,20	0,43

Typical mechanical properties

Yield strength Re [N/mm²]	220
Tensile strength Rm [N/mm²]	410
Elongation A5 [%]	15
Hardness	145 HB / 133 HB (PWHT 760°C/2h) /
Wire/rod type	solid
Welding positions	

Shielding gases acc. to EN ISO 14175	I1 - Ar / M12 - Ar + 0.5 - 5% CO2 / M13 - Ar + 0.5 - 3% O2 /
Remarks	When making welds on a base material containing titanium as a stabilizer, we will use the positive aspects of two elements. Titanium will minimize grain growth and cause TiN to precipitate in the liquid weld metal, minimizing the risk of embrittlement. Niobium binds C and N residues reducing the risk of grain corrosion in the weld metal.

Welding parameters and packing

∅	Welding current [A]	Voltage [V]
0,8	55-160	12-24
1,0	80-240	15-28
1,2	100-300	15-29

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl