

430 LNb

GRUPPE GMAW-GTAW massiv Draht

BESCHREIBUNG Stabilized stainless steel welding wire for ferritic steels

ANWENDUNG 430LNb is developed and designed for the Automotive industry and used for production of exhaust systems and catalytic converters.. The wire should be used when there is a need for good resistance to corrosion and thermal fatigue.

EIGENSCHAFTEN Good corrosion and temperature resistance and excellent weldability. Due to the risk of grain growth in the melted zone, welding wire with a diameter larger then 1,2 mm is to be avoided

NORMBEZEICHNUNGEN

AWS	A 5.9: ER 430 LNb
EN ISO	14343-A: G Z17 L Nb
DIN: W.Nr.	1.4511
DIN	8556:

GEEIGNET FÜR 1.4511, X3CrNb17, 1.4512, 1.4510, 1.4526, 1.4509, 1.4016, X6Cr17, AISI, 430, 409, 439, 436, 441

ZULASSUNGEN CE approved

SCHWEISS POSITIONEN:



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo	Nb
<0.030	0.4	0.4	18.0	<0.5	<0.5	0.5

REINES SCHWEISSGUT ERGEBNISSE

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	900-1200	1050-1450	2,5-4				145
PWHT 760°C/2hr							133

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

RÜCKTROCKNUNG not required

GAS ACCORDING EN M12 (2-8% Co2)

14175