

SF-430

TYPE : Metal-Cored

AWS A5.9 / ASME SFA5.9 EC430
JIS Z3323 TS430-MAO

Applications

SF-430 is a metal cored wire for horizontal, fillet and flat position welding of 409 and 430 type stainless steels as found in ferrite stainless steels automotive mufflers.

Characteristics on Usage

This wire gives excellent bead appearance and provides the operator with a soft stable arc and very low spatter levels thus giving enhanced cosmetic appearance.

Notes on Usage

- ① Use with Ar or Ar + 2~5%O₂ gas.

Welding Position



1G 2F
(PA) (PB)

Current

DC +

Shielding Gas

Ar/Ar+2~5%O₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% Ar)

C	Si	Mn	P	S	Cr	Ti
0.03	0.30	0.50	0.005	0.010	16.5	0.45

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% Ar)

TS MPa(lbs/in ²)	EL (%)	Heat Treatment
500 (72,600)	40	770° C(1418°F)×4hr FC to 600° C(1112°F) AC to RT

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	Spool(kg)	12.5	15
(in)	.045	(lbs)	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)
F & HF	150~250