

Applications

SF-430Nb is a metal cored wire for horizontal, fillet and flat position welding of 409 and 430 type stainless steel as found in ferrite stainless steel 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 100%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: Ar+2%O₂)

C	Si	Mn	P	S	Cr	Nb	Ti
0.03	0.40	0.17	0.010	0.010	16.5	0.50	0.40

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: Ar+2%O₂)

TS MPa(lbs/in ²)	EL (%)
520 (75,400)	24

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	Spool(kg)	12.5	15	20
(in)	.045	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

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