

430 Ti

CATEGORY GMAW-GTAW Solid wires

TYPE Stabilized ferritic filler metal for welding critical applications in exhaust manufacturing.

APPLICATIONS Stabilised ferritic stainless steels, Austenitic stainless steels and in both homogeneous and heterogeneous sheet metal configurations (sheets of different grades welded together)

CLASSIFICATION

AWS	A 5.9: ER 430 Ti
EN ISO	EN 14700: S Fe7
DIN: W.Nr.	1.4502
DIN	8556: SG X 8 Cr Ti 18

SUITABLE FOR 1.4000, 1.4002, 1.4016, 1.4113, 1.4510, 1.4511, 1.4523 etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT % (TYPICAL)

C	Mn	Si	Cr	Ti	Mo	Nb	Ni	Cu	P	S
0.08	0.6	1.0	17.5	0.5						

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	360	620	10				

AW: as welded

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: M12, M13