

## SA 430

**CATEGORY** SAW Arc Submerged

**TYPE** Solid wire for submerged arc welding with 17% Cr.

**APPLICATIONS** Cladding seats, valves, wheels, shafts etc.

**PROPERTIES** Submerged arc welding wire to be used with **FL 8111** or **FL 880** flux with excellent welding properties. Stainless deposit with low carbon content. Low heat input is recommended to avoid pronounced grain coarsening. Absence of stabilisation means that this steel is distinctly vulnerable to sensitisation phenomenon during welding, even though martensite hogs a great amount of carbon and nitrogen.

**CLASSIFICATION**

AWS	A 5.9: ER 430
EN ISO	14343-A: 17
DIN: W.Nr.	1.4016

**SUITABLE FOR** Cladding AISI 410, 410NiMo, 410NiMoNbV.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**FILLER METAL ANALYSIS % (TYPICAL VALUES)**

C	Mn	Si	Cr	Ni	Mo	N	S	P
0.021	0.46	0.40	17	0.40	0.03	0.0299	0.0026	0.023

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW							

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
2,0	27-31	280-380	K-415	25	
2,4	29-33	300-400	K-415	25	
3,2	29-33	350-500	K-415	25	
4,0	30-36	400-600	K-415	25	

**REDRYING TEMPERATURE** not required