

Classifications

EN ISO 17633-B:2008 : TS430Nb-MA0 JIS Z 3323 : TS430Nb-MA0

Description

- K-430LNbE is designed for MAG welding of stainless steels of the 17%Cr-Nb steels and is suitable for automotive exhaust fabrications such as front pipe, bellows, flange etc (AISI 430, 430Ti, 431)
- It is a metal type of flux cored wire for high speed welding on the plate as possible.
- It would produce a moderately soft arc, low spatter generation and slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one.
- It has the high tensile strength at the high temperature atmosphere.
- It has a deeper penetration depth than K-430LNb.

Welding positions



Polarity & shielding gas

- Mix: 100% Ar (15~25l/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cr	Nb(Cb)
Mix	0.02	0.42	0.27	0.002	0.005	15.97	0.53

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
JIS Z 3323		min. 450	min. 13	
Example	400	510	25	100%Ar

[※] After machining, but before testing, the specimen was aged at a temperature 100°C for up to 48 hours then allowed to cool to room temperature.

Notes on usage and welding condition

	Dia.(mm)	1.2	Stick-out
Current (Amp.)	PA/1G PC/2G	180 ~ 260 (22 ~ 25)	(15 ~ 20mm)

Package

	Dia. (mm)	1.2	1.32
Spool (kg)		12.5, 15	
Pailpack (kg)		100 ~ 200	