

**Classifications**

AWS A5.22-15 : E430T0-G

**Description**

- K-430T is designed for MAG welding of ferrite stainless alloys of the 17%Cr-Ti types and suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc (AISI 409, 430Ti, ASTM A176I)
- Wire is a metal type of flux cored wire for high speed welding on the plate as possible and It would produce a moderately soft arc and high low spatter generation.
- K-430T provide higher corrosion resistance, heat resistance due to high alloy designs and also suitable for surfacing of sealing faces of gas, water and steam valves.

**Welding positions****Polarity & shielding gas**

- Mix: Ar+2% O<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

**Typical chemical composition of all-weld metal (%)**

Shielding gas	C	Si	Mn	P	S	Cr	Ti
Mix	0.02	0.61	0.49	0.010	0.007	16.80	1.00

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.22		min. 450	min. 20	
Example	475	535	25	Mix

<sup>※</sup> 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	