

M-430LNb

For ferrite stainless steel (16%Cr-Nb STS)

Classifications

EN ISO 14343-A:2009 : G 18 L Nb
JIS Z 3321:2013 : YS430LNb

Description

- TIG welding of 16% Cr-Nb ferrite stainless steels (AISI 405, 410L, 429, 430, 444)
- It is used for front pipe and manifold of automobile exhaust systems

Welding positions



Polarity & shielding gas

- DCEP (DC+)
- Ar + 1-3% O₂ (15 – 25 l/min)
- Ar + 1-5% CO₂ (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr	Nb+Ta
0.02	0.4	0.39	0.25	18.01	0.5

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	High Temp T.S.	High Temp EL.
	(MPa)	(MPa)	(%)	(MPa, 850°C)	(%, 850°C)
EN ISO 14343	Min. 220	Min. 410	Min. 15		
Example	437	547	15	48	45