

Classifications

EN ISO 3581-A:2012	: E 17 R 12	KS D 7014	: E430-16
EN ISO 3581-B:2012	: ES430-16	JIS Z 3221	: ES430-16
AWS A5.4-06	: E430-16		

Description

- Covering is lime titania type for welding of 17%Cr stainless steel or AISI 403, 405
- Preheat at 200~300°C and postheat treat at 700~800°C.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

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

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.07	0.42	0.75	0.028	0.009	0.20	17.43	0.20	0.30

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	EI. (%)	Remarks
AWS A5.4		min. 450	min. 20	
EN ISO 3581-A	min. 300	min. 450	min. 15	
Example	380	530	27	PWHT
* PWHT : 780°Cx2Hr.				

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp.	F	55~75	80~100	110~140	140~170
(A)	V · OH	45~60	70~90	90~130	-

Approvals

CE