K-430T AWS EC430

FOR STAINLESS STEEL

Typical applications

K-430T is designed for MAG welding of ferrite stainless alloys of the 17%Cr-Ti types. It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc. (AISI 430, dissimilar steels) (AISI 409, 430Ti, 431, ASTM A176I)

Characteristics on Usage

① Wire is a metal type of flux cored wire for high speed welding on the plate as possible.
② It would produce a moderately soft arc and low spatter generation.
③ K-430T provide higher corrosion resistance, heat resistance due to high alloy designs.
④ It is also suitable for surfacing of sealing faces of gas, water and steam valves.
⑤ The shielding gas should be used 98%Ar+2%O_2 for welding.
⑥ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	Cr	Ti
Ar+2%O_2	0.02	0.61	0.49	16.2	1.00

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm²{kgf/mm²}	T · S N/mm²{kgf/mm²}	El (%)	PWHT
Ar+2%O_2	475 {48}	535 {54}	25	-

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.4
Amp.	F	120~240A	140~260A
	H	120~240A	140~280A

Welding positions


Approved by

JIS