

# GMM MIG 430L

## Classification:

Class: AWS : A5.9- ER430

**Material Conforms to:** AWS A5.9

**Weld Process Used:** MIG (GMAW)

### Description:

ER430 is a ferritic stainless steel which offers good ductility in heat treated condition. In addition to the applications of welding similar alloys, it is also used for overlays and thermal spraying.

### Chemical Composition of wire:

Standard Requirement								
C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03 max	0.60 max	0.50 max	15.5-17.0	0.60 max	0.75 max	0.75 max	0.03 max	0.03 max
Average Typical composition								
0.026	0.34	0.37	15.84	0.40	0.05	0.11	0.010	0.027

### Mechanical Properties:

Tensile Strength (Min)	Yield Strength (Min)	Elongation (Min)
480 MPa	400 MPa	22%

### Available sizes:

- 0.80 mm, 0.90 mm, 1.00 mm, 1.20 mm, 1.60 mm

### Welding position:

- All position

**Polarity:**

- DCEP (DC+)

**Recommended Welding Parameters:**

<u>GMAW "MIG Process"</u>			<u>Reversed Polarity</u>			
	<u>Wire Diameter</u>	<u>Wire Feed</u>	<u>Amps</u>	<u>Volts</u>	<u>Shielding Gas</u>	<u>Gas CFH</u>
<b><u>Short Arc Welding</u></b>	0.80	13-26	40-120	16-20	98% Argon+2% O2	25
	0.90/1.00	13-26	60-140	16-22	98% Argon+2% O2	25
<b><u>Spray Arc Welding</u></b>	0.90/1.00	20-39	140-220	24-29	98% Argon+2% O2	38
	1.20	16-30	160-260	25-30	98% Argon+2% O2	38
	1.60	10-16	230-350	27-31	98% Argon+2% O2	38

**Packing Details:**

- 1 Kg/2lbs – SD100
- 5 Kg/10lbs – SD200
- 15Kg/25lbs/33lbs - SD300/BS300
- 100 Kg – Drum Pack
- 250 Kg – Drum Pack

**Note:** Other shielding Gases may be used for MIG welding. Shielding gases are chosen taking Quality, Cost, and Operability into consideration.