

<h1>GMM TIG 430L</h1>	<p>Classification: Class: AWS : A5.9- ER430</p>
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Material Conforms to: AWS A5.9

Weld Process Used: TIG (GTAW)

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:

- Diameter- 1.20 mm, 1.60 mm, 2.00 mm, 2.40 mm, 3.20 mm, 4.00 mm
- Length- 1000 mm & 36" Inch

Welding position:

- All position

Polarity:

- DCEN (DC-)

Recommended Welding Parameters:

<u>GTAW "TIG Process"</u>			
<u>Wire Diameter</u>	<u>Amps DC</u>	<u>Volts</u>	<u>Shielding Gas</u>
1.20	80-110	13-16	Argon 100%
1.60	90-130	14-16	Argon 100%
2.40	120-175	15-20	Argon 100%
3.20	140-200	17-22	Argon 100%
4.00	160-230	18-25	Argon 100%

Packing Details:

- 1 Kg/2lbs – Tube
- 5 Kg/10lbs – Tube
- 20Kg/40lbs - Box (4 Tubes)

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