BÖHLER CAT 430L CbTi-IG

Solid wire, high-alloyed, ferritic stainless, stabilized

Classifications

EN ISO 14343-A	AWS A5.9
G Z 18 Nb Ti L	ER430 (mod.)

Characteristics and typical fields of application

Solid wire of G Z 18 NbTi L / ER430 (mod.) for exhaust manifolds, catalytic converters, silencers and diesel particle filters of matching or similar materials. Double stabilized (Nb + Ti) to reduce tendency to grain growth. Resistant to scaling up to 900ºC. Outstanding feeding characteristics and very good welding and flow characteristics.

Base materials

1.4509 X5CrTiNb 18, 1.4016 X6Cr17, 1.4511 X3CrNb17
UNS S43940, S43000
AISI 430, 441

Typical analysis

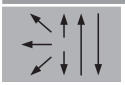
	C	Si	Mn	Cr	Nb	Ti
wt.-%	0.02	0.5	0.5	18	≥ 12xC	0.40

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
	HB
u	150
s	130

u untreated, as-welded – shielding gas Ar + 2% CO_2
s heat treated, annealed – shielding gas Ar + 2% CO_2, 760°C for 2 h

Operating data



Polarity	DC+
Shielding gas (EN ISO 14175)	M12 M13

Dimension mm
1.0
1.2

Preheating as required by the base metal. Thicker matching ferritic steels can be preheated to 200 – 300ºC. Post weld heat treated at 700 – 750ºC.
Shielding gas: Ar + 2 – 3% CO_2 or Ar + 1 – 2% O_2

Approvals

DB (43.132.57), CE