

Classifications

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

Characteristics and typical fields of application

Special GTAW rod for welding of exhaust systems. stabilized (Nb + Ti) with minimum affection to grain growth. Resists scaling up to +900°C.

Base materials

1.4509 X5CrTiNb 18, 1.4016 X6Cr17, 1.4511 X3CrNb17, AISI 430, AISI 441

Typical analysis


	C	Si	Mn	Cr	Nb	Ti
wt.-%	0.02	0.5	0.5	18	> 12xC	0.4

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

Condition	Hardness
u	150
a	130

u - untreated, as welded – shielding gas Ar + 0.5 – 5% CO₂
a - annealed, 760°C / 2h – shielding gas Ar + 0.5 – 5% CO₂

Operating data

	Polarity	DC-	Dimension mm
	Shielding gas (EN ISO 14175)	I1	1.6 × 1000
	Rod marking	+ 430LcbTi / WZ18NbTiL	2.4 × 1000

Approvals

DB (43.132.57), CE