

## OK Autrod 430Ti

A ferritic, stainless, solid wire with a content of 18% Cr and stabilised with 0.5% Ti for welding similar and matching steels. The alloy is also used for cladding on unalloyed and low-alloyed steels.

OK Autrod 430Ti is also widely used in the automotive industry for the welding of manifolds, catalytic converters and exhaust pipes.

|                                       |  |
|---------------------------------------|--|
| <b>Classifications Wire Electrode</b> | EN ISO 14343-A : G Z 17 Ti<br>Werkstoffnummer : 1.4502 |
| <b>Approvals</b>                      | CE EN 13479  |

Approvals are based on factory location. Please contact ESAB for more information.

|                   |                    |
|-------------------|--------------------|
| <b>Alloy Type</b> | 18 % Cr - 0.5 % Ti |
|-------------------|--------------------|

### Typical Tensile Properties

| Yield Strength     | Tensile Strength | Elongation |
|--------------------|------------------|------------|
| 390 MPa (56.5 ksi) | 600 MPa (87 ksi) | 24 %       |
| 380 MPa (55 ksi)   | 580 MPa (84 ksi) | 28 %       |

### Typical Wire Composition %

| C    | Mn  | Si  | Ni  | Cr   | Mo   | Cu   | Ti    |
|------|-----|-----|-----|------|------|------|-------|
| 0.07 | 0.5 | 0.9 | 0.3 | 17.6 | 0.05 | 0.10 | 0.400 |

### Deposition Data

| Diameter             | Current   | Voltage | Wire Feed Speed                      | Deposition Rate                |
|----------------------|-----------|---------|--------------------------------------|--------------------------------|
| 0.9 mm<br>(.035 in.) | -         | -       | -                                    | -                              |
| 1.0 mm<br>(.040 in.) | 80-190 A  | 16-24 V | 2.9-8.4 m/min<br>(114-331 in./min)   | 1.1-3.1 kg/h<br>(2.4-6.8 lb/h) |
| 1.2 mm<br>(.045 in.) | 180-280 A | 20-28 V | 4.9-8.5 m/min<br>(193-335 in./min)   | 2.6-4.5 kg/h<br>(5.7-9.9 lb/h) |
| 1.6 mm<br>(1/16 in.) | 230-350 A | 24-28 V | 3.2-5.5 m/min<br>(126-216.5 in./min) | 3-5.2 kg/h<br>(6.6-11.5 lb/h)  |