

OK Autrod 430LNbTi

A ferritic stainless solid wire with low carbon content and excellent welding properties, 18 % Cr and stabilized with Nb and Ti, for welding similar and matching steels. OK Autrod 430LNbTi is developed and designed for the Automotive industry and used for production of exhaust systems. The wire should be used when there is a need for very good resistance to corrosion and thermal fatigue.

Classifications Wire Electrode	EN ISO 14343-A : G Z 18 L Nb Ti Werkstoffnummer : 1.4509 mod
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Alloy Type	18 % Cr – Nb and Ti stabilized
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Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ti
0.01	0.5	0.5	0.2	18.5	0.06	0.10	0.20

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (.040 in.)	100-260 A	18-28 V	-	-
1.2 mm (.045 in.)	180-280 A	20-28 V	4.9-8.5 m/min (193-335 in./min)	2.6-4.5 kg/h (5.7-9.9 lb/h)