

OK Autrod 430LNb

GMAW

G Z 17 L Nb

Description

A ferritic, stainless, solid wire with a low carbon content, 18% Cr and stabilised with Nb, for welding similar and matching steels. OK Autrod 430 LNb has been developed and designed for the automotive industry and is used in the production of exhaust systems. The wire should be used when very good resistance to corrosion and thermal fatigue is required.

Welding current

DC(+)

Classifications

EN 12072 G Z 17 L Nb
Werkstoffnummer ~1.4511

Typical chemical composition, aw (%)

C	Si	Mn	Cr
<0.03	0.5	0.5	18.2

Typical mech. properties all weld metal

Yield stress, MPa 275
Tensile strength, MPa 420
Elongation, % 26

Charpy V

Test temps, °C Impact values, J

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.9	3.5-18.0	65-220	15-28	1.1-5.4
1.0	4.0-16.0	80-240	15-28	1.5-6.0
1.2	3.0-14.0	100-300	15-19	1.6-7.5