

KM-430

Shielding Gas: Ar+1~2%O₂
Ar+1~2%CO₂

Classification

AWS A5.9/A5.9M ER430
AS/NZS ISO 1434S B SS430

Applications and Features

- (1) Weld metal is ferritic structure with 16%Cr.
- (2) Good heat and corrosion resistance.
- (3) It is suitable for welding exhaust and muffler systems, such as AISI 409 and 430 steel.

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding .
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr
0.041	0.78	1.60	0.010	0.010	16.25

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2%O₂ PWHT 780°Cx2Hr)

Tensile Strength MPa	Yield Strength MPa	Elongation %
620	450	42

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)	
		1.2	1.6
Ar+1~2%CO ₂	Amp	100~210	—
	Volt	17~22	—
Ar+1~2%O ₂	Amp	200~300	220~330
	Volt	24~30	24~32

Diam.	15 kg Spool
1.2mm	KM4301215
1.6mm	KM4301615

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