

OK Autrod 430LNb

A continuous ferritic stainless solid wire with low carbon content, 18 % Cr and stabilized with Nb, for welding similar and matching steels. OK Autrod 430LNb 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 good resistance to corrosion and thermal fatigue.

Specifications

Classifications	EN ISO 14343-A : G 18 L Nb Werkstoffnummer : ~1.4511
Approvals	CE : EN 13479 UKCA : EN 13479

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

Alloy Type	18 % Cr - 0.5 % Nb
Shielding Gas	M12, M13 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	275 MPa	420 MPa	26 %

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb
0.01	0.5	0.5	0.2	18.5	0.06	0.10	0.45

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.015	0.50	0.50	0.003	0.015	0.2	18.5	0.06	0.10	0.01

Typical Weld Metal Analysis %

Nb
0.45

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
0.8 mm	50-140 A	16-22 V	3.4-11.0 m/min	0.8-2.7 kg/h
1.0 mm	80-190 A	16-24 V	2.9-8.4 m/min	1.1-3.1 kg/h
1.2 mm	180-280 A	20-28 V	4.9-8.5 m/min	2.6-4.5 kg/h

Welding Parameters

Wire Diameter
0.9 mm
1.14 mm