

GM 430L



IDENTIFICATION :ER430L

CLASSIFICATION :AWS/SFA 5.9: ER430L , BS 2901: Pt2 430S94,
DIN 8556: SG X 8CrTi 18(1.4502)

CHARACTERISTICS :

GM 430L is a solid wire with 17% Cr for martensitic & martensitic-ferritic stainless steel. GM 430L gives a martensitic ferritic deposit which has good scaling resistance and corrosion resistance in sulphur bearing gases.

WELD METAL ANALYSIS (RANGE) %:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.10 max	0.60 max	0.50 max	0.03 max	0.03 max	15.5-17.0	0.60 max	0.50 max	0.75 max

MECHANICAL PROPERTIES (RANGE) :

AFTER PWHT:

Heat to (760-790°C) hold for 2 Hrs, furnace cool at a rate not exceeding 55°C /1 Hr to 595°C and air cool.

Ultimate Tensile Strength(MPa)	0.2% Proof Stress(MPa)	Elongation (L=4d)
500-640	360-490	20-27

Additional Information:

For MIG welding, the most economic shielding gas is Ar + 20% CO₂. This gas also gives highest resistance to weld metal porosity and carbon content typically not exceeding 0.12%.

Shielding Gas: Ar + 1-3% O₂ or 3-20% CO₂.

PACKING DATA :

SIZE (mm)	PACKING (KG) SPOOL
0.8	12.5-15.0
1.2	12.5-15.0
1.6	12.5-15.0