MIG F17/0

Old reference: MIG 430

Classification

ISO 14343-A : G 17
AWS A5.9 : ER430

Material N° : 1.4016

Description & Applications

Solid wire for joining of stainless steels with 17% Chromium content. Good oxidation resistant up to 900°C also in sulphurous gases, used for chimneys as well as for sea water applications,….
Surfacing of fittings and valves.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.05	0.4	0.5	16.5	0.3	0.1	0.08	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
300	450	15

After PWHT 760°C/2h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8 1.0 1.2 1.6	100-150 120-200 140-220 180-260	22-27 24-28 24-28 24-30	Ar + 2%CO_2 Ar + 1%O_2 18-20 l/min

Ind.10

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