

OK Autrod 430LNbTi

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

Classifications Wire Electrode	EN ISO 14343-A : G 18 L Nb Ti Werkstoffnummer : ~1.4509
Approvals	CE EN 13479

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

Alloy Type	18 % Cr – Nb and Ti stabilized
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	0.5	0.5	0.005	0.020	0.2	18.5	0.06	0.10	0.017

Typical Wire Composition %

Nb	Ti
0.5	0.30

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (0.040 in.)	80-190 A	16-24 V	2.9-8.4 m/min (114-331 in./min)	1.1-3.1 kg/h (2.4-6.8 lb/h)
1.2 mm (0.047 in.)	180-280 A	20-28 V	4.9-8.5 m/min (193-335 in./min)	2.6-4.5 kg/h (5.7-9.9 lb/h)

Recommended Welding Parameters

Wire Diameter

0.9 mm
(0.035 in.)