



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard: AWS A 5.9 YB/T5092	Chemical Composition %								
	C	Mn	Si	Cr	Ni	P	S	Mo	Cu
Grade ER430	≤0.10	≤ 0.6	≤ 0.5	15.5 – 17.0	≤ 0.60	≤0.03	≤0.03	≤0.75	≤0.75
Type	Spool (MIG)				Tube (TIG)				
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0				1.6、 2.0、 2.4、 3.2、 4.0、 5.0				
Package	S100/1kg S200/5kg S270,S300/15kg-20kg				5kg/box	10kg/box	length :1000MM		
Diameter (MM)	0.8	1.0	1.2	1.6	2.0	2.5	3.2		
Current (A)	70 ~ 150	100 ~ 200	140 ~ 220	50 ~ 100	100 ~ 200	200 ~ 300	300 ~ 400		
Application	ER430, also known as H10Cr17, is mainly composed of 17Cr. it is a ferrite stainless steel MIG wire, which can be welded in all position. The welding performance is excellent, the wire feeding is smooth, the arc is stable, and the shape is beautiful. There was little splash. It is suitable for welding 13Cr or 17Cr martensitic stainless steel,especially for nitric acid vessels, and is often used for welding of wear-resistant and corrosion-resistant components. Such as 10Cr17 (SUS430) material device, guardrail, golf head.								
Notice	1. Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface of the groove and its surroundings should be polished with metallic gloss. 2. In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O2 and shield gas flow rate 20-25 L/min for MIG welding. For TIG welding,suggest protect gas pure Ar and shield gas flow rate 8-15 L/min ,Arc length 1~3 mm; Length of the tungsten pole is about 3~5 mm; wind speed limit ≤ 1.0 m/s, argon protection at the back of welding area . 3. In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to. 4. The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding.								

