CWR-430 Welding Wire and Rod

CWR-430 is a ferritic stainless steel filler metal offering good ductility in heat-treated condition. It is generally used to weld similar alloys but can also be used for overlays and thermal spraying. Pre-heating and post weld heat treatment is required to obtain optimum mechanical properties and corrosion resistance.

CONFORMANCES

AWS A5.9/A5.9M	:	ER 430
ASME SFA-A5.9	:	ER 430
ISO 14343-B	:	SS 430

AWS CHEMICAL COMPOSITION *(TYPICAL)*

%C	%Cr	%Ni	%Mo	%Mn
0.10 max	15.5 – 17.0	0.60 max	0.75 max	0.60 max

%Si	%P	%S	%Cu	Total Others
0.50 max	0.03 max	0.03 max	0.75 max	0.50 max

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	59,000 psi
Tensile Strength	:	77,500 psi
Elongation	:	25 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16”	1.6 mm	14 – 17	90 – 130	100% Ar
	3/32”	2.4 mm	15 – 20	125 – 175	100% Ar
MIG (GMAW)	.035”	0.9 mm	29 – 33	160 – 180	98%Ar – 2%O_2
	.045”	1.1 mm	29 – 33	180 – 220	98%Ar – 2%O_2
Sub Arc (SAW)	.093”	2.4 mm	28 – 33	250 – 450	
	.125”	3.2 mm	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED
BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.