



FCW 430LP Flux Cored Wire

Classification

AWS A5.22 : E430 T1-1/4
ISO 17633-A : T 17 P RM3

EN 14700 : T Fe7

Characteristics

Rutile flux cored wire to weld in all positions with shielding gas protection used for cladding and for joining of 430 stainless steels. Nice bead appearance, self releasing slag, good penetration and high productivity.

Applications

To Surface valve seats, To weld Ferritic stainless steels used in the presence of Sulphurous gas.

Base Materials

UNS	Alloy	EN 10088	Material N°
S 43036	430 Ti	X 3CrTi177	1.4510
S 43100	431		
S 43000	430	X6Cr17	1.4016

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ti	P	S	Fe
0.03	0.90	1.00	17.50	0.25	0.015	0.005	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _e (MPa)	% Elg A ₅	Hardness (HB) AW
PWHT	530	370	22	200

PWHT : After heat treatment at 760°C/4hrs

Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	ISO 14175
FCAW = +	1.2	120 - 250	23 - 30	15 - 20	M21 (Ar+10-20 %Co ₂) or CO ₂ 18 - 20 l/min

Preheating : 200°C ; Interpass temperature : 200 - 300°C

Welding Positions : 1G/PA ; 2G/PC ; 3G/PF ; 2F/PB

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