

Classifications						
EN ISO 14343-A	AWS A5.9			Mat. No.		
G Z 18 NbTi L	ER430(mod.)			≈1.4509		
Characteristics and typical fields of application						
<p>Ferritic stainless steel. Double stabilized (Nb + Ti) filler material with reduced susceptibility against grain growth.</p> <p>Scale resistant up to 900 °C (1652 °F).</p> <p>For joining and surfacing of similar and matching steels.</p> <p>Exhaust systems.</p>						
Base materials						
<p>AISI 441 – 1.4509 – X5CrTiNb 18</p> <p>AISI 430 – 1.4016 – X6Cr17</p> <p>1.4511 – X3CrNb17</p>						
Typical analysis of solid wire (wt.-%)						
	C	Si	Mn	Cr	Nb	Ti
wt-%	≤ 0.03	0.5	0.6	18.5	0.55	0.40
Structure: Ferrite (with soft martensite)						
Mechanical properties of all-weld metal						
Heattreatment	Hardness HB30					
aw	≈150					
760 °C / 2 h (1400 °F)	≈130					
Operating data						
Polarity: DC (+)	Shielding gas: (EN ISO 14175) M12, M13			ø (mm) 1.0 1.2	Spool: B300 B300	
Welding instruction						
Materials	Preheating			Postweld heat treatment		
Matching / similar steels	According to wall thickness 200 – 300 °C (392 – 572 °F)			According to wall thickness 750 – 800 °C (1292 – 1472 °F)		