

Classifications					
EN ISO 14343-A	AWS A5.9			Mat. No.	
G Z 18 Nb L	ER430(mod.)			≈1.4511	
Characteristics and typical fields of application					
Stainless. Scaling resistant up to 900 °C (1652 °F). For joining and surfacing of similar and matching steels. Exhaust systems.					
Base materials					
1.4016 – X6Cr17 AISI 430 1.4511 – AISI 430; X3CrNb17					
Typical analysis of solid wire (wt.-%)					
	C	Si	Mn	Cr	Nb
wt-%	≤ 0.02	0.5	0.5	18.0	≥ 12xC
Structure: Ferrite					
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 (1383 – 1472 °F);	