



MIG F17/0

Classification

AWS A5.9 : ER430

ISO 14343-A : G 17

Description & Applications

Solid wire for GMAW of ferritic stainless steels with 17% Chromium content like grade 430. Used for assembly or hardfacing. Good resistance against oxidation up to 900°C in sulfurous gases used for chemneys. Resistant to atmosphere corrosion, water corrosion and light acids with service temperature up to +450°C.

Main applications: Harfacing of piping systems, surfacing of fittings and valves.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co
Min				16.0				-			-
Max	0.05	0.5	0.6	17.0	0.5	0.5	0.5	-	0.03	0.02	-
Type	0.05	0.40	0.50	16.5	0.30	0.10	0.08	0.01	0.02	0.01	0.05

All Weld Metal Mechanical Properties*

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	300	450	20	-
Max				-
Type	340	480	22	-

* After PWHT at 760°C/2h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: M12 (Ar+0.5-5%CO ₂) M13 (Ar+0.5-3%O ₂) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	