Revicor®430

Solid wire for welding of stainless and heat resistant steels

Classification

AWS A5.9	:ER 430
EN 12072	:G Z 17Ti

General Description

Wire G Z 17 Ti/Er 430 for deposit welding of surfaces of gas, water and steam valves, fittings and gadgetry from carbon and low alloyed steels. Working temperature up to 500°C
Good wire feeding and welding properties. Heat resistant up to 900°C. Wire is applicable for joint welding of ferritic stainless steels with 13-18% Cr, when it is necessary to get similar colour both welded metal and metal of base material. Preheating of surface up to 250-450°C is necessary for joint welding. Annealing 650-750°C approves deposit metal durability.

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	S+P	Nb	Mo	Ni
0.03	1.0	0.7	18.0	0.045	0.6	0.5	0.5

Mechanical properties, all weld metal

		Process	Shielding gas	Condition	0.2% Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Elongation (%)	Impact (ISO), J +20 °C
Required	EN12072	GTAW	I1	AW	min 300	min 500	min 20	min 130
Typical values after welding		GTAW	I1	AW	400	550	25	260

Materials to be welded

EN	ASTM
X6CrTi17	431
X20CrNi17 2	430Ti

Packaging, available sizes and identification

Process	Unit:	Sizes, mm 2.0	2.4
GTAW	5 kg tube	X	X
GMAW	15 kg spool B300	X	X
	300 kg metal coil	X	X

Identification	Imprint: Revicor®430	Tip colour:	**Revicor®430 : rev.EN 20**