

OK Autrod 430LNb

A continuous ferritic stainless solid wire with low carbon content, 18 % Cr and stabilized with Nb, for welding similar and matching steels. OK Autrod 430LNb is developed and designed for the Automotive industry and used for production of exhaust systems. The wire should be used when there is a need for good resistance to corrosion and thermal fatigue.

Specifications	
Classifications	EN ISO 14343-A : G 18 L Nb Werkstoffnummer : ~1.4511
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	18 % Cr - 0.5 % Nb
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	275 MPa (40 ksi)	420 MPa (61 ksi)	26 %

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.015	0.50	0.50	0.003	0.015	0.2	18.5	0.06	0.10	0.01

Typical Weld Metal Analysis %
Nb
0.45

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	0.48	0.39	0.006	0.017	0.21	18.2	0.02	0.05	0.02

Typical Wire Composition %
Nb
0.4

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm (0.030 in.)	50-140 A	16-22 V	3.4-11.0 m/min (134-433 in./min)	0.8-2.7 kg/h (1.8-6.0 lbs/h)
1.0 mm (0.040 in.)	80-190 A	16-24 V	2.9-8.4 m/min (114-331 in./min)	1.1-3.1 kg/h (2.4-6.8 lbs/h)
1.2 mm (0.047 in.)	180-280 A	20-28 V	4.9-8.5 m/min (193-335 in./min)	2.6-4.5 kg/h (5.7-9.9 lbs/h)

Recommended Welding Parameters
Wire Diameter
0.9 mm (0.035 in.)
1.14 mm (0.045 in.)