

DESCRIPTION

Executive 430 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up.

By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 430 is a 16% Cr alloy. The composition is balanced by providing sufficient chromium to give adequate corrosion resistance while retaining ductility in the heat-treated condition.

APPLICATIONS & FEATURES

Executive 430 is used in environments with continued heat cycling such as exhaust and furnace manufacturing and maintenance.

Optimum mechanical properties and corrosion resistance are obtained only when the weldment is heat treated following the welding operation.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	
0.011	16.19	0.29	0.03	0.35	0.34	0.018	0.0006	0.04	0.0072	
Tensile Strength:		90,000 PSI min		Yield Strength:		65,300 PSI min		Elongation:		42%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short - Spray	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar
	.045"	22-23	180-210		
	.062"	23-24	200-220		
	.035"	23-25	190-260		
	.045"	25-28	250-330		
	.062"	28-31	310-350		
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.093"	29-32	300-350		Record IND 24 or Record IN
	.125"	29-32	400-550		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER430**

