Select 430LCb-Mod

Description:

Select 430LCb-Mod is a metal cored electrode designed for the welding of ferritic stainless materials. Normally used for single pass fillet weld application, this product has an extremely stable arc that reduces burn-through. **Select 430LCb-Mod** higher chrome content combined with stabilization from Niobium and Titanium provides similar heat and corrosion resistance to the base metals which are welded.

Classification:

- AWS A5.22, ECG

Characteristics:

- Faster travel speeds due to a highly stable arc.
- Less burn through on thin materials.
- Less spatter means greater productivity with less cleanup.
- Handles poor fit up and gaps, easier to weld than solid wire.
- Easy transition to spray transfer.
- Operates over a wider parameter range, including modified waveforms.
- Capable of welding over aluminized coatings.

Applications:

Select 430L-Cb is designed to weld heat resistant, corrosion resistant, ferritic stainless steels used in exhaust system components. Typical applications include manifolds, converters, mufflers and tubular components of automotive exhaust systems made of 430 grade materials.

Typical Deposit Composition:

Wt%	C	Nb	Cr	Cu	Mn	Ni	P	S	Si	Ti
	.02	.36	16.50	.03	.45	.02	.007	.010	.58	0.5

Suggested Parameters:

	Optimum			Range			
Diam. (in.)	Amperage	WFS	Voltage	Amperage	WFS	Voltage	ESO
.045”	250	410	25-26	190-330	240-600	22-28	½-1”
.052”	300	350	24-25	220-460	220-620	23-30	½-1”
1/16”	350	300	26	240-520	160-500	22-31	¾-1¼”

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