



Select 430NbL

Description:

Select 430NbL is a metal cored electrode designed for the welding of ferritic stainless steel materials used in automotive exhaust systems. It is designed to be used with Ar-CO₂ gas mixtures containing from 5 to 20% CO₂.

Classification:

- AWS A5.22 ECG

Characteristics:

- Specially formulated to produce tough, fine grained weld metal
- Faster travel speeds, less burn through, less spatter means greater productivity.
- Handles poor fit up and gaps, easier to weld with than solid wire

Applications:

Select 430NbL is designed to weld heat and 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 (Ar-10% CO₂):

<u>Shielding Gas</u>	<u>C</u>	<u>Cr</u>	<u>Nb(Cb)</u>	<u>Ti</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>
90Ar/10CO ₂	.03	17.8	0.6	0.1	0.3	0.6	.007	.010

Suggested Parameters:

<u>Diam. (in.)</u>	<u>Amperage</u>	<u>Optimum</u>		<u>Amperage</u>	<u>Range</u>		<u>ESO</u>
		<u>WFS</u>	<u>Voltage</u>		<u>WFS</u>	<u>Voltage</u>	
.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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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.