

# Select 430NbL

Stainless Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

## FEATURES

- Dual stabilized with columbium (Cb), also known as niobium (Nb), and titanium (Ti) for improved sensitization resistance.
- Dual stabilization improves weld metal mechanical properties over Ti or Nb only stabilized weldments.
- Specially formulated to promote a fine-grained ferritic microstructure.
- Superior arc stability over entry level Nb stabilized wires.
- Metal cored construction inherently provides better welding performance compared to solid wires.
- Designed to weld exhaust system components of similar composition, ~18 wt% chromium (Cr), with increased oxidation resistance at high operating temperatures.

## CONFORMANCES

AWS A5.22

ECG

ASME SFA 5.22

ECG

## DIAMETERS (in [mm])

0.045 (1.2), 0.052 (1.3), 1/16 (1.6)

## POSITIONS



## SHIELDING GAS

Ar + 5-20% CO<sub>2</sub>

Flow Rate: 40 - 50 CFH

## POLARITY

Direct Current Electrode Positive (DCEP)

## TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Cr	Cu	Mn	Mo	Nb	Ni	P	S	Si	Ti
90%Ar / 10%CO <sub>2</sub>	0.03	17.4	0.03	0.26	<0.01	0.71	0.02	0.010	0.017	0.70	0.15



Revision: 1/17/2025

Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. 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.

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## RECOMMENDED WELDING PARAMETERS \*\*

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	90% Ar/10% CO2	Flat & Horizontal	280 (7.1)	200	21	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	350 (8.9)	220	22	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	400 (10.2)	250	24	5/8 (16)
		Flat & Horizontal	475 (12.1)	275	26	5/8 (16)
0.052 (1.3 mm)	90% Ar/10% CO2	Flat & Horizontal	225 (5.7)	215	21	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	350 (8.9)	280	24	3/4 (19)
		Flat & Horizontal	425 (10.8)	300	26	3/4 (19)
1/16 (1.6 mm)	90% Ar/10% CO2	Flat & Horizontal	225 (5.7)	260	22	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	265 (6.7)	285	23	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	300 (7.6)	310	24	3/4 - 1 (19 - 25)
		Flat & Horizontal	350 (8.9)	335	26	3/4 - 1 (19 - 25)

\* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

\*\*The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

## PACKAGING [lbs (kgs)]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

\*Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.

## STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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