

GM 430L

IDENTIFICATION

GM 430L, ER 430L

CLASSIFICATION

AWS/SFA 5.9: ER430L, BS 2901: Pt2 430S94,
DIN 8556: SG X 8CrTi 18 (1.4502)

DESCRIPTION

GM 430L is a solid wire with 17% Cr for martensitic & martensitic-ferritic stainless steel. GM 430L gives a martensitic ferritic deposit which has good scaling resistance and corrosion resistance in sulphur bearing gases.

CHEMICAL ANALYSIS (RANGE) %

| C | Mn | Si | S | P | Cr | Ni | Mo | Cu |
|----------|----------|----------|----------|----------|-------------|----------|----------|----------|
| 0.10 max | 0.60 max | 0.50 max | 0.03 max | 0.03 max | 15.5 - 17.0 | 0.60 max | 0.50 max | 0.75 max |

MECHANICAL PROPERTIES (RANGE)

| UTS (MPa) | EL (%) (L=4D) |
|-----------|---------------|
| 500 - 640 | 20 - 27 |

AFTER PWHT

Heat to (760-790°C) hold for 2 Hrs, furnace cool at a rate not exceeding 55°C / 1 Hr to 595°C and air cool.

ADDITIONAL INFORMATION

For MIG welding, the most economic shielding gas is Ar + 20% CO₂. This gas also gives highest resistance to weld metal porosity and carbon content typically not exceeding 0.12%.

SHIELDING GAS : Ar + 1 - 3% O₂ or 3 - 20% CO₂

PACKING PARAMETERS

| Size (mm) | Weight / Spool (kg) |
|-----------|---------------------|
| 0.8 | 12.5 / 15.0 |
| 1.2 | 12.5 / 15.0 |
| 1.6 | 12.5 / 15.0 |