

# 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% CO<sub>2</sub>. This gas also gives highest resistance to weld metal porosity and carbon content typically not exceeding 0.12%.

**SHIELDING GAS :** Ar + 1 - 3% O<sub>2</sub> or 3 - 20% CO<sub>2</sub>

## 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