

Product Data Sheet

SUPERMIG 430

SS MIG WELDING WIRE
Stainless and Heat resistant steels

Classification:

AWS A 5.9 : ER 430
EN 14343-A: G 17

Description: SUPERMIG 430 is a ER430/G17 type solid MAG welding wire supplied precision layer wound. Suitable for use with Ar-CO₂ mix shielding gases. SUPERMIG 430 is used for many surfacing applications. The composition of SUPERMIG 430 is balanced by optimizing the chromium content to give adequate corrosion resistance and yet retain sufficient ductility. Welding with SUPERMIG 430 usually required pre heating and post weld heat treatment .

Precision layer winding technologies ensure smooth, virtually trouble-free feeding.

Materials to be welded

AISI 430; X20CrNi17-2, G-X 40 CrSi17, G-X 22 CrNi7, X10CrAl18

Typical Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.10 Max	0.60 Max	0.50 Max	15.50-17.00	0.60 Max	0.75 Max	0.75 max.	0.03 max.	0.03 max.

Typical All Weld Mechanical Properties

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO – V (J) 20° C
≥400	≥450	≥15%	≥27

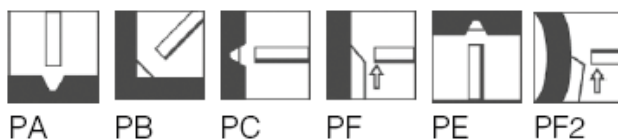
The chemistry and all weld mechanical properties will vary with the type of shielding gas used. Recommended shielding gas as per EN ISO 14175 : M12, M13.

Welding Directions :- MIG welding can be performed as short, spray or pulsed arc. Short arc is preferably used for thin gauges, both for horizontal and positional welding. Spray arc increases the deposition rate. Welding with pulsed arc gives excellent possibilities for a good result in varying plate thicknesses in all positions. The highest flexibility using pulsed arc is achieved with 1.20 mm

Current Conditions:- DC (+)

Storage: - Keep dry and avoid condensation.

Welding position:-





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Recommended Welding Data:-

Diameter (mm)		0.8	1.0	1.2
Operating range				
Ar+1~2%CO ₂	Amp	40~120	80~160	100~210
	Volt	15~20	16~22	17~22
Ar+1~2%O ₂	Amp	160~210	180~280	200~300
	Volt	24~28	24~30	24~30

Packing Data:

Size (mm)	0.80	0.90	1.00	1.10	1.20	1.60
Weight (kg)	12.50/15.00	12.50/15.00	12.50/15.00	12.50/15.00	12.50/15.00	12.50/15.00
