

Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 430

Classification: EN ISO 14343-A – S 17
SFA-5.9 – ER430

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-WIRE 430	0.04	0.35	0.5	0.1	0.1	16.5	0.015	0.015	0.2
S 17 acc. to ISO 14343-A	0.12	1.0	1.0	0.5	0.5	16.0–19.0	0.03	0.02	0.5
ER430 acc. to AWS A5.9	0.10	0.5	0.6	0.75	0.6	15.5–17.0	0.03	0.03	0.75

Application:

Wire electrode for submerged arc welding intended for welding ferritic and martensitic chromium steels with 15-17%Cr, AISI 430. Also suitable for surfacing gas, water and steam valves and fittings. Service temperatures up to +450 °C. Scaling resistant up to +950 °C.

Base Materials:

- Surfacing: all weldable backing materials, unalloyed and low-alloyed.
Joining: corrosion resistant Cr-steels as well as other similar-alloyed steels with C-contents up to 0.20 %.
1.4510 X3CrTi17
AISI 430 Ti; AISI 431
Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire electrode surface:

Smooth finish free from surface defects and foreign matter.