

SM-430LNb



❖ Specification

JIS Z3321 YS430LNb

EN ISO 14343 A G 18LNb

❖ Applications

SM-430LNb is a MIG wire for horizontal, Fillet and flat position welding Of 429 and 444 type stainless steels.

❖ Characteristics on Usage

This wire gives excellent bead appearance and provides the operator With a soft stable arc and low spatter levels thus giving enhanced appearance.

❖ Note on Usage

Use 100% Ar or Ar + 2~5%O₂ gas.

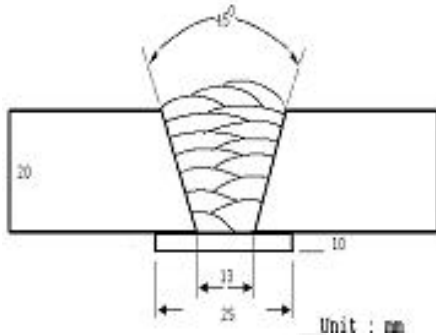
❖ Packing

Dia.(mm)	0.9	1.2
Spool (kg) *including ball pac	12.5	



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



[Joint Preparation & Layer Details]

Diameter(mm)	: 1.2mm
Shielding Gas	: 100%Ar + 2%O ₂
Flow Rate(ℓ /min.)	: 20~25
Amp./ Volt.	: 220/27
Stick-Out(mm)	: 20
Pre-Heat(°C)	: 150
Interpass Temp.(°C)	: 150 ± 15
Polarity	: DC(+)

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	P	S	Cr	Ni	Nb
SM-430LNb	0.014	0.37	0.34	0.020	0.004	18.14	0.28	0.45

❖ Proper Current Range

Consumable	Shielding Gas	Welding Position	Wire Dia. (mm)	
			0.9mm	1.2mm
SM-430LNb	100%Ar or Ar + 2~5%O ₂	F & HF	180~220 Amp 24~26 Vol	220~250 Amp 26~27 Vol

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