

SM-430LNb



❖ Specification

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.

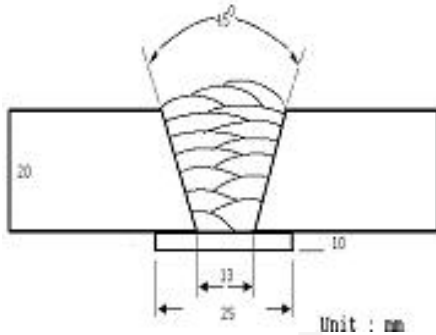
❖ Packing

Dia.	0.9mm (0.035in)	1.2mm (0.045in)
Spool	12.5kg (28lbs)	



Mechanical Properties & Chemical Composition of All Weld Metal

❖ **Welding Conditions**



[Joint Preparation & Layer Details]

- Diameter(mm)** : 1.2mm
- Shielding Gas** : 100%Ar + 2%O₂
- Flow Rate(ℓ /min.)** : 20~25
- Amp./ Volt.** : 220/27
- Stick-Out(mm)** : 20
- Pre-Heat(℃)** : 150
- Interpass Temp.(℃)** : 150 ± 15
- Polarity** : DC(+)

❖ **Chemical Analysis of All weld metal(wt%)**

Consumable	C	Si	Mn	P	S	Cr	Ni	Nb
SM-430LNb	0.019	0.40	0.33	0.028	0.002	18.00	0.13	0.47

❖ **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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