

OK Autrod 430Ti

A ferritic, stainless, solid wire with a content of 18% Cr and stabilised with 0.5% Ti for welding similar and matching steels. The alloy is also used for cladding on unalloyed and low-alloyed steels. OK Autrod 430Ti is also widely used in the automotive industry for the welding of manifolds, catalytic converters and exhaust pipes.

Classifications Wire Electrode:	EN ISO 14343-A:G Z 17 Ti, Werkstoffnummer :1.4502
Approvals:	CE EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type:	18 % Cr - 0.5 % Ti
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Stress relieved 0.5 hr 780 °C	380 MPa	580 MPa	28 %
Stress relieved 0.5 hr 780 °C	390 MPa	600 MPa	24 %

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ti
0.07	0.5	0.9	0.3	17.6	0.05	0.10	0.400

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	80-190 A	16-24 V	2,9-8,4 m/min	1,1-3,1 kg/h
1.2 mm	180-280 A	20-28 V	4,9-8,5 m/min	2,6-4,5 kg/h
1.6 mm	230-350 A	24-28 V	3,2-5,5 m/min	3-5,2 kg/h