



# CEWELD 430 LNbTi

TYPE	Double stabilized ferritic filler metal for welding critical applications in exhaust manufacturing.																
APPLICATIONS	CEWELD® 430 LNbTi was developed for the automotive industry and is used in the manufacture of exhaust systems and catalytic converters. This wire should be used when good resistance to corrosion and thermal fatigue is required. Suitable for use with stabilized ferritic stainless steels, austenitic stainless steels, and in both homogeneous and heterogeneous sheet configurations (sheets of different grades welded together).																
PROPERTIES	Stabilization with niobium and titanium gives CEWELD® 430 LNbTi the advantages of these two ferritic microstructure stabilizers: Titanium minimizes grain growth in the weld zones (WM) by precipitating titanium nitride (TiN) in the still-molten metal in these zones, thus preventing the risk of embrittlement that can sometimes occur with very thick welds ( $> 3$ mm of the sheet being welded). Niobium retains the remaining carbon and nitrogen by transferring 85 to 95% of the carbon in the welding arc under all standard welding conditions, thereby preventing the risk of intergranular corrosion in the weld metal.																
CLASSIFICATION	AWS A 5.9: ~ 439 LNB EN ISO 14343-A: G 18 L Nb Ti F-nr 6 FM 5 W.Nr. 1.4509																
SUITABLE FOR	<b>1.4509, AISI 441, UNS-Nummer: S43940</b> 1.4000, 1.4002, 1.4016, 1.4057, 1.4740, 1.4742, 1.4057, 1.4059, 1.4741, 1.4509, 1.4510, 1.4511, 1.4512, 1.4520, 1.4712, 1.4713, 1.4724, X7Cr14, X12Cr13, X17CrNi16-2, X6Cr13, X6CrAl13, X6Cr17, X17CrNi16-2, X2CrTiNb18, X3CrTi17, X3CrNb17, X2CrTi12, X2CrTi17, X10CrSi6, X10CrAlSi7, X10CrAlSi13, X10CrAlSi18 UNS S40300, S40500, S40900, S41000, S42900, S43000, S43035, S43036, S43100, S44200 AISI 403, 405, 409, 410, 429, 430, 430Cb, 430Ti, 439, 431, 442																
APPROVALS	CE																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><thead><tr><th>C</th><th>Si</th><th>Mn</th><th>Cr</th><th>Ni</th><th>Mo</th><th>Nb</th><th>Ti</th></tr></thead><tbody><tr><td>0.02</td><td>0.5</td><td>0.6</td><td>18</td><td>0.15</td><td>0.2</td><td>0.7</td><td>0.4</td></tr></tbody></table>	C	Si	Mn	Cr	Ni	Mo	Nb	Ti	0.02	0.5	0.6	18	0.15	0.2	0.7	0.4
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ALL WELD MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th><math>R_{P0,2}</math> MPa</th><th>Rm MPa</th><th>A5 (%)</th><th>Hardness Rockwell C</th></tr></thead><tbody><tr><td>As Welded /</td><td>310</td><td>450</td><td>25</td><td>Avg. 140</td></tr></tbody></table>	Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Rockwell C	As Welded /	310	450	25	Avg. 140						
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As Welded /	310	450	25	Avg. 140													
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175	M12																



# CEWELD 430 LNbTi

430 LNBTI 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663412157

430 LNBTI 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663412164