

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GFW430Cb

Applicable Specification
JIS Z 3323 TS430Nb-FM0

● Applications and Characteristics

TASETO GFW430Cb is used for root pass on SUS405 or SUS410 clad steel and welding root pass on 13%Cr steel before build up welding.

● Notes on Usage

- * Please refer "Guideline for Welding Stainless Steel with GFW Wires".
- * Keep the preheat and interpass temperature at 150°C to 250 °C and apply 760°C to 790 °C heat treat after welding.
- * Use Ar+20%CO₂ as shielding gas.
- * Excess dilution cause hardening in weld metal with martensite formation. So, it is preferable to limit the welding current in less than 200A at 1.2mm diameter and 250A at 1.6mm diameter.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb+Ta
Typical	0.047	0.59	0.17	0.023	0.003	0.08	17.07	0.02	0.02	1.14

● Mechanical Properties of All Weld Metal

	Heat Treatment	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	780°C×2h AC	356	661	22.0

● Sizes Available and Shielding Gas

Size (mm)	Shielding Gas
1.2	Ar+20%CO ₂ , 20L/min
1.6	Ar+20%CO ₂ , 20L/min