MODI 430

STAINLESS STEEL ELECTRODE

CLASSIFICATION : **AWS/A 5.4 : E 430-16**

CHARACTERISTICS : A stainless steel electrode containing 17% Cr for welding of AISI 430 and steels with similar composition. It shows good corrosion resistance and good oxidation resistance to nitric acid. Also suitable for surfacing to serve as straight chromium materials. it works equally well on AC as well as

APPLICATIONS :

* For the welding of AISI 430 steel and also AISI 410 steel where chromium contents are on the higher side.
* For steels requiring high resistance to chemical corrosion and oxidation resistance upto 850°C.

RECOMMENDATIONS : Re-dry the electrodes at 200°C for one hour. Keep the arc as short as possible. Thick materials should be preheated to 100°C to 120°C and stress relieving may be done at 760°C-790°C for two hours and furnace cooling at a rate not exceeding 55°C per hour to 595°C and air cool to ambient.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	S	P	Cu
0.10 max	1.0 max	0.90 max	15-18	0.60 max	0.75 max	0.03 max	0.04 max	0.75 max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :

Ultimate Tensile Strength N/mm^2	Elongation (%)
450 min	20 min

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	3.15x350	4.0x350	5.0x350
Amps	80-110	110-140	150-180

ISO 9001 REGISTERED
DNV
MGMT. SYS. RvA C 024
DNV Certificate B.V., The Netherlands

MODI ARC ELECTRODES CO.
Modinagar - 201 204 (U.P.)
Fax : 01232 - 242147
Phone : (01232) 325700, 325925, 243912
E-mail : modiarc@ndb.vsnl.net.in
Web Site : www.modielectrodes.com

MODI 430-15

STAINLESS STEEL ELECTRODE

CLASSIFICATION : **AWS/A 5.4 : E 430-15**

CHARACTERISTICS : A stainless steel electrode containing 17% Cr. Weld metal displays good resistance to corrosion and heat. The electrode is suitable for joining stainless steel of similar composition. It is also suitable for surfacing carbon steels, low alloy steel and chromium steels.

APPLICATIONS :

* For the welding of AISI 430 steels and also AISI 410 steels where chromium contents are on the higher side.
* For steels requiring high resistance to chemical corrosion and oxidation resistance upto 850°C.
* For surfacing of valves, impellers, turbine blades etc.

RECOMMENDATIONS : Re-dry the electrodes at 250°C for 1 hour. Keep the arc as short as possible. Thick materials should be preheated to 100°C to 120°C and stress relieving may be done at 760°C-790°C for 2 hours and furnace cooling at a rate not exceeding 55°C per hour to 595°C and air cool to ambient.

CHEMICAL ANALYSIS OF WELD-METAL(%) :

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.10 max	1.0 max	0.9 max	15-18	0.6 max	0.75 max	0.75 max	0.03 max	0.04 max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER AWS/A 5.4) :

Ultimate Tensile Strength N/mm^2	Elongation (%)
450 min.	20 min.

CURRENT CONDITIONS : USE DC (+) ONLY

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	60-80	80-110	110-140	150-180

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Web Site : www.modielectrodes.com