DURAMAX STAINLESS ELECTRODE DM430-16

Classification: **E430-16** **AWS A5.4 / ASME SFA 5.4**

Description, Characteristics & Applications:

DURAMAX E430-16 electrode for welding of 17% Cr stainless steel such as SUS430.
DM430-16 is a lime-titania type electrode for all-position welding.
It shows good corrosion resistibility and good oxidation resistibility to Nitric acid.
-- Keep the arc as short as possible.
-- Weaving width should be within two and a half times electrode's diameter.
-- When the electrodes have absorbed moisture, dry them at 150~200℃ for 30~60 minutes before use

Typical Chemical Composition (%)

AWS Spec.	C	Cr	Ni	Mo	Mn	Si	P	S	Cu	
A5.4	0.10 max	15.0-18.0	0.6 max	0.75 max	1.0 max	0.90 max	0.04 max	0.03 max	0.75 max	
Typical	0.05	17.27	0.24	0.022	0.82	0.005	0.015	0.005	0.034	

Typical Mechanical Properties as Welded

Tensile Strength (n/mm²)	Yield Strength (n/mm²)	Elongation (%)	Hardness	Preheat / Interpass	PWHT
520 Min	300 Min	20% Min	-------	150 ~ 205°C	700 ~ 820°C

Note: 770°C x2hr, Air cooling after slowly cooled down to 590°C

Typical Welding Parameters DCEP or AC

Diameter	3/32"	1/8"	5/32"	3/16"	7/32"
Amps	65 - 90	90 - 120	120 - 150	160 - 200	200 - 260

POLARITY: DCEP or AC
DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.
AC: medium weld penetration (can have more spatter)
WELDING POSITIONS: All Positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METAL