

COR™STAIN 430 FC

DESCRIPTION

COR™STAIN 430 FC is a typical AISI 430 stainless steel alloy in a flux-cored tubular wire with excellent operating characteristics.

APPLICATIONS

Typical uses include: welding base metals of a similar composition, and overlays on mild and low alloy steels for mild corrosion and abrasion resistance.

PROCEDURE

Preheat according to base material.

WELDING PARAMETERS

Type	Size	Volts	Amps	Shielding Gas	Stickout
FC-G	.045"	23-27	140-200	CO ₂	0.5"
FC-G	1/16"	24-28	200-300	CO ₂	0.5"
FC-O	1/16"	25-28	180-250	none	1.5"
FC-O	3/32"	27-31	300-400	none	1.5"
FC-S	3/32"	27-31	300-400	*	1.0"

* Submerged arc wires are available in 1/16"-5/32"; Suggested fluxes: Lincoln ST-100, 880M, or 880.

MECHANICAL PROPERTIES

Hardness: 200-230 BHN
 Tensile: 60,000 psi minimum
 Elongation: 20% minimum

CLASSIFICATION

AWS A5.22, Class E430TX-X