

## Classifications

EN ISO 17633-A	AWS A5.22
T Z17 Nb Ti L M M12 1	EC430G
T Z17 Nb Ti L M M13 1	EC439Nb

## Characteristics and typical fields of application

Metal cored wire for joints in exhaust systems with same-type or similar-type materials. Double stabilised (Nb + Ti) formula and a low carbon content with a reduced tendency to the formation of coarse grains. Resistant to scaling up to +900 °C. The easy handling and high deposition rate of BÖHLER CAT 430L Cb Ti-MC result in high productivity with excellent welding performance, very low spatter formation, finely rippled weld pattern with good wetting behaviour and even, reliable fusion penetration. Focus application: robot welding of exhaust systems for the car industry, especially for thin sheet one-layer joints with a high travel speed.

## Base materials

1.4509 X5CrTiNb18, 1.4016 X6Cr17, 1.4511 X3CrNb17  
AISI 430, AISI 441

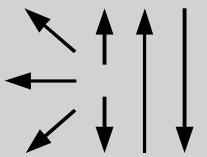
## Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Cr	Nb	Ti
wt-%	0.02	0.5	0.7	18.5	0.55	0.35

## Mechanical properties of all-weld metal

Condition	Brinell-hardness
	HBW
u	<b>180</b>
u	untreated, as welded – shielding gas Ar + 2.5% CO <sub>2</sub>

## Operating data

	<b>Polarity:</b> DC ( + )	<b>Shielding gases:</b> Argon + 0.5 – 5% CO <sub>2</sub> Argon + 0.5 – 3% O <sub>2</sub>	<b>ø (mm)</b> 1.2	<b>Amps A</b> 60 – 280	<b>Voltage V</b> 13 – 30
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