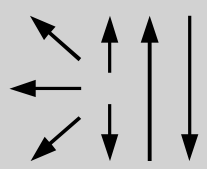


Classifications						
EN ISO 17633-A			AWS A5.22:			
T Z17 Nb L M M12 1			EC439Nb			
T Z17 Nb L M M13 1						
Characteristics and typical fields of application						
<p>Metal cored wire for catalyzers, silencers, exhaust mufflers and inlet manifolds with same-type or similar-type materials. The wire is resistant to scaling up to 900 °C. The easy handling and high deposition rate of BÖHLER CAT 430L Cb-MC result in high productivity with excellent welding performance, very low spatter formation, low weld oxidation with good wetting behaviour and even. Focus application: robot welding of exhaust systems for the car industry, especially for thin sheet one-layer joints with a high travel speed.</p>						
Base materials						
1.4511 X3CrNb17, 1.4016 X6Cr17 AISI 430						
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Cr	Nb	Ti
wt.-%	0.02	0.5	0.7	18.5	0.65	0.12
Mechanical properties of all-weld metal						
Condition	Brinell-hardness					
	HBW					
u	180					
u	untreated, as welded – shielding gas Ar + 2.5% CO ₂					
Operating data						
	Polarity: DC (+)	Shielding gases: Argon + 0.5 – 5% CO ₂ Argon + 0.5 – 3% O ₂	ø (mm) 1.2	Amps A 60 – 280	Voltage V 13 – 30	