DURAMAX®
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Product
Data Sheet

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 (%)

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.10 max	15.0 - 18.0	0.60 max	0.75 max	1.0 max	0.90 max	0.04 max	0.03 max	0.75 max

Deposited Chemical Composition (%) (Typical)

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
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

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930