

Supershield 430-0

FERRITIC STS TYPE OPEN ARC WIRE

HYUNDAI WELDING CO., LTD.



Supershield 430-O

❖ Specification

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❖ Description & Applications

Supershield 430-O is an open arc type wire. Used for buffer layer of Hardfacing. Good weldability(Non-Gas) and PWHT(Post-Weld Heat Treatment) is not required.

(Steel Mill Rolls, Casting Rolls, etc.)

❖ Welding Process

Open Arc Type

❖ Current Type

DC+

❖ Packing

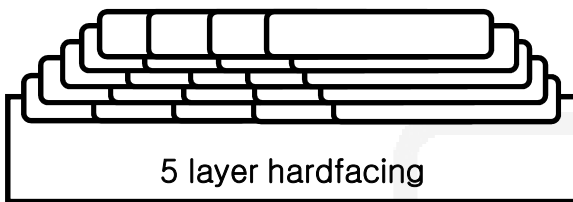
Supershield 430-O	Dia.	2.4mm(3/32in) 2.8mm(7/64in)
	Coil	25kg(55lbs)
	Pailpack	150kg(330lbs), 250kg(551lbs)



Supershield 430-O

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	: 2.4mm(3/32in)
Welding Type	: Open Arc
Amp./ Volt.	: 380 / 28
Stick-Out	: 25~30mm(0.98~1.18in)
Pre-Heat	: 150~250°C (302~482°F)
Interpass Temp.	: 200~300°C (392~572°F)
Total layers	: ≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr
Supershield 430-O	0.04	0.87	1.11	18.5

❖ Hardness test of All weld metal(HRc)

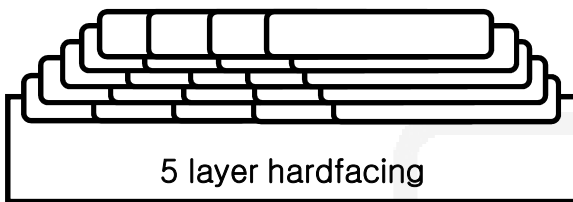
Consumable	Hardness(HRc)					Avg.
Supershield 430-O	6	6	8	9	10	8

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



Diameter	: 2.8mm(7/64in)
Welding Type	: Open Arc
Amp./ Volt.	: 380 / 29
Stick-Out	: 25~30mm(0.98~1.18in)
Pre-Heat	: 150~250°C (302~482°F)
Interpass Temp.	: 200~300°C (392~572°F)
Total layers	: ≥4 layer

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	Cr
Supershield 430-O	0.05	0.81	1.04	18.8

❖ Hardness test of All weld metal(HRc)

Consumable	Hardness(HRc)					Avg.
Supershield 430-O	6	7	7	9	10	7.5



Test Results

❖ BEAD APPEARANCE

Consumable	Supershield 430-O (2.4mm, 3/32in)
Amp.(A)	360~380
Volt.(V)	27~28
Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)



Consumable	Supershield 430-O (2.8mm, 7/64in)
Amp.(A)	370~390
Volt.(V)	27~29
Speed	40~60cm/min(15.7~23.6in/min)
Welding Position	Flat(1G)



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