Flux Cored Welding Wire

K-409TiC

Ferritic Stainless welding wire (Muffler, 13%Cr-Ti)

Classifications

EN ISO 17633-B:2010 : TS 409-M M13 0 AWS A5.22-2012 : E409T0-G

Description

- K-409TiT is developed to meet the needs of the automotive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode and additional applications include heat exchangers and recuperators, power plant reheater tubes etc.
- It would produce a moderately soft arc and high welding speed.
- K-409TiC provides low spatter, excellent bead appearance and porosity resistance.
- Higher Ti component improves resistance to porosity, good wetting behaviour when compared to the K-409TiT wire.
- High deposition efficiency and high speed welding on the thin plate are possible.

Welding positions

Polarity & shielding gas

- Mix: Ar+2% O_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cr	Ti
Mix	0.02	0.44	0.62	0.011	0.005	11.50	1.00

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
EN ISO 17633-B		min. 450	min. 15	
Example	480	530	24	CO_2

☞ After machining, but before testing, the specimen was aged at a temperature 100℃ for up to 48 hours then allowed to cool to room temperature.

Notes on usage and welding condition

Dia.(mm)		1.2	Stick-out
Current (Amp.)	PA/1G	180 ~ 260	(15 ~20mm)
	PC/2G	(22 ~25)	

Package

Dia. (mm)	1.2	1.32
Spool (kg)	12.5, 15	
Pailpack (kg)	100 ~ 200	