K-409TiT

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.
- Wire is a metal type of flux cored wire for high speed welding on the plates as possible
- It would produce a moderately soft arc and low spatter generation and also provide excellent bead appearance and porosity resistance.
- Slag quantity is almost the same as a solid wire and deposition rate is up to 20% higher than solid wire's one.

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	0.50	0.45	0.011	0.005	12.10	0.80

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
EN ISO 17633-B		min. 450	min. 15	
Example	460	520	25	Mix

☞ 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	