

K-436T

Ferritic Stainless welding wire (Muffler, 18%Cr-Nb(Cb))

Classifications

Not required

Description

- K-436T is designed for MAG welding of stainless steels of the 17%Cr-1%Mo-Ti types and suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc (JIS 436L/436J1L)
- Wire is a metal type of flux cored wire for high speed welding on the plate as possible.
- It would produce a moderately soft arc and high low spatter generation, and the Mo component in weld metal improves good crack resistance and heat resistance.
- It is also suitable for surfacing of sealing faces of gas, water and steam valves.

Welding positions



Polarity & shielding gas

- Mix: Ar+2% O₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Mo	Ti
Mix	0.03	0.35	0.63	17.50	1.10	0.50

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
Example	385	490	23	Mix

^① After machining, but before testing, the specimen was aged at a temperature 100°C 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 PC/2G	180 ~ 260 (22 ~ 25)	(15 ~ 20mm)

Package

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