

K-439TE

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

Classifications

Not required

Description

- K-439TE is designed for MAG welding of stainless steels of the 18%Cr-Ti types and suitable for automotive exhaust fabrications such as front pipe, bellows, flange etc. (AISI 430, 430Ti, 431)
- 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 low spatter generation.
- Slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one.
- K-439TE has the high tensile strength at the high temperature atmosphere.

Welding positions



Polarity & shielding gas

- Mix: 100%Ar,
Ar+2% O₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cr	Ti
Ar	0.03	0.42	0.53	0.01	0.01	17.0	0.60

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
Example	400	500	24	Ar

※ 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 (PA/1G)	180 ~ 260	(15 ~ 20mm)
(Amp.) (PC/2G)	(22 ~ 25)	

Package

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