

Typical applications

K-409TiC is developed to meet the needs of the auto-motive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode.

Characteristics on Usage

- ① It would produce a moderately soft arc and high welding speed
- ② K-409TiC provides low spatter, excellent bead appearance and porosity resistance.
- ③ Higher Ti component improves resistance to porosity, good wetting behaviour when compared to the K-409Ti wire
- ④ High deposition efficiency and high speed welding on the thin plate are possible.
- ⑤ The shielding gas should be used 98%Ar+2%O₂ for welding.
- ⑥ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ti
Ar+2%O ₂	0.03	0.55	0.60	11.4	1.0

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	EI (%)
Ar+2%O ₂	550 {56}	20

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extension(mm)
1.0	140~220	10~20
1.2	160~240	15~20

Welding positions



Approved by