K-409TiT

AWS EC409

FOR STAINLESS STEEL

Typical applications

K-409TiT 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 Wire is a metal type of flux cored wire for high speed welding on the plate as possible.
② It would produce a moderately soft arc and low spatter generation.
③ Slag quantity is almost the same as a solid wire and deposition rate is up to 20% higher than solid wire's one.
④ K-409TiT provides excellent bead appearance and porosity resistance.
⑤ The shielding gas should be used 98%Ar+2%O_2 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	0.05	0.50	0.45	12.1	0.7

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm²{kgf/mm²}	El (%)
Ar+2%O_2	560 {57}	20

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin(mm)
1.0	140~240	10~20
1.2	180~260	15~20

Welding positions


Approved by

ABS