

Typical applications

K-436T is designed for MAG welding of stainless steels of the 17%Cr-1% Mo-Ti types. It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc. (AISI 430, 430Ti, 431, 436)

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 The Mo component in weld metal improves good crack resistance and heat resistance.
- ④ It is also suitable for surfacing of sealing faces of gas, water and steam valves.
- 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	Mo	Ti
Ar+2%O ₂	0.03	0.35	0.63	17.5	1.1	0.5

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P	T · S	EI
	N/mm ² {kgf/mm ² }	N/mm ² {kgf/mm ² }	(%)
Ar+2%O ₂	365 {37}	477 {49}	23

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
	Amp.	F	120~240
H		120~240	140~280

Welding positions



Approved by

ABS, BV, DNV, GL, KR, LR, NK