# K-439T

FOR STAINLESS STEEL

## Typical applications

K-439T is designed for MAG welding of stainless steels of the 18%Cr-1%Ti types.It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange, etc.(AISI 430, 430Ti, 431)

## 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 solid wire and deposition rate is up to 20% higher than solid wire's one.
④ K-439T has the high tensile strength at the high temperature atmosphere.
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%$O_2$ | 0.03 | 0.33 | 0.64 | 17.8 | 0.3 |

## Typical mechanical properties of all-weld-metal

| Shielding Gas | Y · P N/mm²{kgf/mm²} | T · S N/mm²{kgf/mm²} | El (%) |
|---|---|---|---|
| Ar+2%$O^2$ | 482 {49} | 501 {51} | 22 |

## Sizes available and recommended currents (DC wire⊕)

| Dia. (mm) | | 1.0 | 1.2 |
|---|---|---|---|
| Amp. | Amp. | 100~240 | 160~260 |
| | Volt. | 20~28 | 23~30 |
| | Electrode extension(mm) | 10~20 | 15~25 |

## Welding positions


## Approved by