

SF-409Ti

Type : Metal-Cored

Conformances

AWS A5.9/ ASME SFA5.9 EC409

JIS Z3323 TS409-MA0

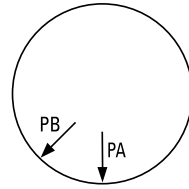
Applications

- Stainless steels 409 Type
- Automotive mufflers

Features

- Good corrosion resistance
- Low spatter
- Non-slag type

Welding Position



Current

DC +

Shielding Gas

Ar + 2% O₂

Diameter / Packaging

| Diameter mm (in) | Spool | | | Pac | | |
|---------------------|-------------|------------------|--------------|----------------|----------------|----------------|
| | 5kg (11lbs) | 12.5kg (27.6lbs) | 15kg (33lbs) | 250kg (551lbs) | 300kg (661lbs) | 350kg (771lbs) |
| 0.9 (0.035) | | √ | √ | √ | √ | √ |
| 1.0 (0.040) | | √ | √ | √ | √ | √ |
| 1.2 (0.045) | | √ | √ | √ | √ | √ |
| 1.4 (0.052) | | √ | √ | √ | √ | √ |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Cr | Ti |
|------|------|------|-------|-------|------|-----|
| 0.03 | 0.50 | 0.55 | 0.012 | 0.010 | 12.5 | 0.8 |

Typical Mechanical Properties of All-Weld Metal

| TS MPa(lbs/in ²) | EL (%) |
|---------------------------------|-----------|
| 500 (72,600) | 20 |

Typical Welding Parameters

| Diameter, Polarity Shielding Gas | CTWD mm (in) | Wire Feed Speed m/min (in/min) | Amp. (A) | Volt. (V) | Deposition Rate kg/hr (lb/hr) |
|-------------------------------------|-----------------|-----------------------------------|-------------|--------------|----------------------------------|
| 1.2mm (0.045 in) DC+ | | | | | |
| Ar + 2% O ₂ | 20 (0.78) | 5.5 (216) | 180 | 23~25 | 2.9 (6.3) |
| | | 6.6 (260) | 210 | 25~27 | 3.5 (7.6) |
| | | 8.1 (320) | 250 | 26~28 | 4.4 (9.5) |