

# SC-439Ti Cored

Type : Metal-Cored

## Conformances

AWS A5.22/ ASME SFA5.22 EC439

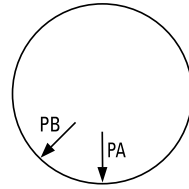
## Applications

- Stainless steels 409, 430, 436, 439 Type
- Automotive mufflers

## Features

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

## Welding Position



## Current

DC +

## Shielding Gas

Ar + 2% O<sub>2</sub>

## Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
1.2 (0.045)		✓	✓	✓	✓	✓

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ti
0.03	0.3	0.6	0.005	0.010	18.5	0.60

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)	Heat treatment
500 (72,600)	40	770°C x 2hr FC to 600°C AC to RT

## 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 <sub>2</sub>	20 (0.78)	5.5 (216)	180	23~25	2.8 (6.2)
		6.6 (260)	210	25~27	3.3 (7.3)
		8.1 (320)	250	26~28	4.3 (9.4)