

# SF-409Ti

Type : Metal-Cored

## Conformances

AWS A5.9/ ASME SFA5.9 EC409

JIS Z3323 TS409-MA0

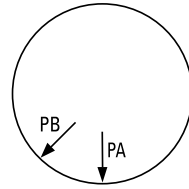
## Applications

- Stainless steels 409 Type
- Automotive mufflers

## Features

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

## Welding Position



## Current

DC +

## Shielding Gas

Ar + 2% 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)
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 <sup>2</sup> )	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)
<b>1.2mm (0.045 in) DC+</b>					
Ar + 2% O <sub>2</sub>	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)