

SF-409Ti

TYPE : Metal-Cored

AWS A5.9/ASME SFA5.9 EC409
JIS Z3323 TS409-MAO

Applications

SF-409Ti is a metal type flux cored wire designed for the horizontal fillet welding of AISI 409 ferrite stainless steels.

Characteristics on Usage

This wire has been specifically formulated for use in the welding of automotive exhaust systems and mufflers.

It benefits from being spatter free and without slag formation when used with argon or argon oxygen mixed shielding gas. It also has an excellent deposition rate and corrosion resistance. High speed welding can be carried out with this product on thin plate material without burning through.

SF-409Ti can be used in the welding of similar chemical composition alloys.

Notes on Usage

① Use with Ar or Ar + 2-5%O₂ gas.

Welding Position



1G (PA) 2F (PB)

Current

DC +

Shielding Gas

Ar/Ar+2-5%O₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% Ar)

C	Si	Mn	P	S	Cr	Ti
0.03	0.50	0.55	0.012	0.010	12.5	0.7

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% Ar)

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

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	Spool(kg)	12.5	15
(in)	.045	(lbs)	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)
F&HF	150~250