DESCRIPTION:
SFC-409Ti is a flux cored wire for welding automotive exhaust systems and mufflers. While welded with mix gas (80%Ar+20%CO2) as a shielding gas, its welding performance can be obtained less spatter and few slag. In addition, it can have an excellent deposition rate and corrosion resistance.

APPLICATIONS:
SFC-409Ti is designed for flat and horizontal fillet welding of AISI 409 ferrite stainless steel.

NOTE ON USAGE:
1. Use DC (+) polarity.
2. Weld with mix gas shielding gas and suitable gas flow is 20~25 l/min.

WELDING POSITION:

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):
(Shielding Gas: 80%Ar + 20%CO2)
Weld Metal Analysis:
Carbon (C) 0.045
Manganese (Mn) 0.560
Silicon (Si) 0.720
Phosphorus (P) 0.011
Sulphur (S) 0.009
Chromium (Cr) 11.5
Titanium (Ti) 0.82

TYPICAL MECHANICAL PROPERTIES OF WELD METAL:(Shielding Gas: 80%Ar + 20%CO2)
TS N/mm² 475
EL% 24

APPROVALS:
-

SUGGESTED WELDING PARAMETERS (DC <+>)

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2mm</th>
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</thead>
<tbody>
<tr>
<td>Welding Position</td>
<td>F, HF</td>
<td></td>
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<tr>
<td>Voltage (Volt)</td>
<td>28 ~ 32</td>
<td></td>
</tr>
<tr>
<td>Current (Amp)</td>
<td>200 ~ 240</td>
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</tbody>
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