

FLUX CORED WIRES FOR STAINLESS STEEL

DESCRIPTION & APPLICATIONS :

- SFC-409Ti is a metal-cored wire with addition of fewer ionization element to increase arc stability.
- Advantage of higher welding efficiency on thin plate; lower possibility of burn-through, higher deposition rate, better weldability and less sparkle than solid wire.
- It is suitable for AISI 409 the ferritic stainless steel and the similar alloy steels, especially for the automotive exhaust systems and mufflers.

NOTE ON USAGE :

- Use mixed gas with 80%Ar+20%CO₂, and the flow with 15~20 l/min.

WELDING POSITION :



CHEMICAL COMPOSITION (GAS SHIELD: 80%AR+20%CO₂)

C	Mn	Si	P	S	Cr	Ti
0.045	0.56	0.72	0.011	0.009	11.5	0.82

MECHANICAL PROPERTY (GAS SHIELD: 80%AR+20%CO₂)

TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %
475(48)	24

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters	Diameter (mm)	1.2
		F, H
Voltage (Volt)		28-32
Current (Amp)		200-240