CSF-409Ti

For 13%Cr-0.6%Ti Muffler Welding

AWS	A5.22	E409T0-G
JIS	Z3323	TS409-MA0

Applications

CSF-409Ti is suitable for welding of low carbon 13%Cr-0.6%Ti stainless steel.

Characteristics

(1) CSF-409Ti is flux cored wire and designed for Fillet & H-F welding with 98%Ar+2%O_2 gas Shielding.
(2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
(3) Is containing Ferrite of a reasonable quantity and crack-resistance, integranular corrosion resistance, mechanical properties of weld metal is superior.
(4) Shield gas is 98%Ar+2%O_2 gas.

Notes on usage

(1) The optimum flow of 98%Ar+2%O_2 Shielding gas is 20~25 ℓ/min.
(2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
(3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 98%Ar+2%O_2)

C	Mn	Si	P	S	Cr	Ti
0.03	0.58	0.62	0.018	0.012	11.25	0.95

Typical mechanical properties of weld metal

(Shielding Gas : 98%Ar+2%O_2)

YP N/mm²(MPa)	TS N/mm²(MPa)	EL %
402	502	25

Size & recommended current range (DC +)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm/min)
1.2(0.045)	150-260	20-33	20-80
1.4(0.052)	180-260	20-33	20-80