

CSF-439

For 17%Cr-Ti Muffler Welding

Applications

CSF-439 is suitable for welding of low carbon 18%Cr-0.75%Ti stainless steel.

Characteristics

- (1) CSF-439 is flux cored wire and designed for Fillet & H-F welding with 98%Ar+2%O₂ 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, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 98%Ar+2%O₂ gas.

Notes on usage

- (1) The optimum flow of 98%Ar+2%O₂ 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%O₂)

C	Mn	Si	P	S	Cr	Ti
0.03	0.47	0.32	0.015	0.009	17.5	0.31

Typical mechanical properties of weld metal (Shielding Gas : 98%Ar+2%O₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %
487	505	22

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