K-409TIT

FLUX CORED ARC WELDING
CONSUMABLE FOR
FERRITIC STAINLESS STEEL

KISWEL

Rev.0

K-409TIT

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■ Description & Application

- **K-409TiT is developed to meet the needs of the automotive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode and additional applications include heat exchangers and recuperators, power plant reheater tube etc.**
- **Wire is a metal type of flux cored wire for high speed welding on the plate as possible.**
- **It would produce a moderately soft arc and low spatter generation and also provide excellent bead appearance and porosity resistance.**
- **Slag quantity is almost the same as a solid wire and deposition rate is up to 20% higher than solid wire's one.**

■ Classification

- **AWS A5.22 : E409T0-G**
- **EN ISO 17633 : B : TS 409-M- M13 0**

■ Classification

	C	Cr	Mn	Si	P	S	Ti
AWS A5.22	0.10	10.5-13.5	0.80	1.0	0.04	0.03	10*C-1.5
EN ISO 17633	0.08	10.5-13.5	0.8	0.8	0.03	0.03	10*C-1.5
K-409TiT	0.02	11.3	0.45	0.42	0.009	0.007	0.86

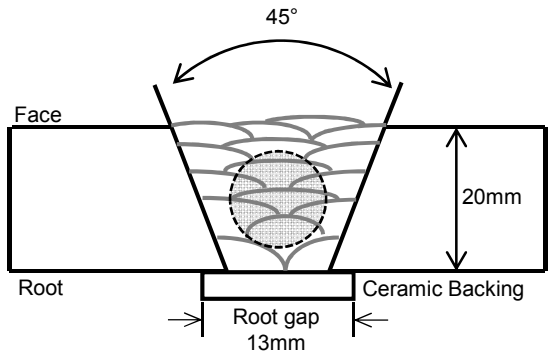
■ Shielding Gas

- **Ar + 2%O_2 (15~25ℓ/min)**

■ Welding Position



All Weld Metal Test Specimen



Base metal	SM490(Buttering)
Diameter	1.2mm
Current / Voltage	200A / 24V
Stick out	20mm
Travel Speed	32 CPM
Welding Position	PA / 1G

Typical Mechanical Properties of Weld Metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Shielding Gas	PWHT
K-409TiT	**460**	**520**	**25**	**Ar + 2%O_2**	**AW**

Typical Operating Procedures

Dia (mm)	Shielding Gas	Current (amps)	Voltage (volts)
1.2	**Ar + 2%O_2**	**150**	**17**
		200	**23**
		240	**27**

■ Bead appearance

Mode	Current (A)	Voltage (V)	Travel SP (cpm)	Base Metal	Stick out (mm)	Shielding Gas
Pulse	160	18	35	STS430	15	Ar + 2%O_2



■ Deposition rate

Brand name	Current (A)	Voltage (V)	Travel Speed (cpm)	Welding Time (min)	Deposition Rate (g/min)
K-409TiT	200	23	35	1	94
ZO-26 (Solid wire)					78

Deposition rate of K-409TiT is up to 20% higher than solid wire's one.

Packaging





Size and Weight

Dia. (mm)	1.2
Weight (kg)	15, 20
Pail pack(kg)	100, 200

■ Handling and Storage

- **Once Flux cored wire picked up moisture, it cannot be dried at high temperature, unlike covered electrode.**
- **If a wire was left in a wire feeder in a high-temperature high- humidity atmosphere in summer season, a wet environment in rainy season or a dew fall environment at night in winter was unpacked, the wire should be kept in an area of low humidity.**

  ※ Temp. below 30℃ relative humidity below 60%

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The Management System of KISWEL LTD, 704, Gongdan-ro, Seongsan-gu, Changwon-si, Gyeongnam 51544, Republic of Korea, 70, Saebyeok-ro 63beon-gil, Sasang-gu, Busan 47018, Republic of Korea has been approved by Lloyd's Register Quality Assurance to : IATF 16949:2016, ISO 14001:2015, applicable to : Manufacture of solid welding wires & rods, flux cored wires, submerged arc welding wires & fluxes, stainless steel welding wires & rods and covered electrodes.
More information : www.kiswel.com

