K-436T

FLUX CORED ARC WELDING
CONSUMABLE FOR
FERRITIC STAINLESS STEEL

KISWEL

Rev.0

K-436T

KISWEL

■ Description & Application

- **K-436T is designed for MAG welding of stainless steels of the 17%Cr-1%Mo-Ti types and suitable for automotive exhaust fabricators such as front pipe, bellows, flange, 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 the Mo component in weld metal improves good crack resistance and heat resistance.**

■ Classification

- **Not required**

■ Typical Chemical Composition of Weld Metal(%)

	C	Si	Mn	Cr	Mo	Ti
K-436T	0.03	0.43	0.50	17.50	0.80	0.50

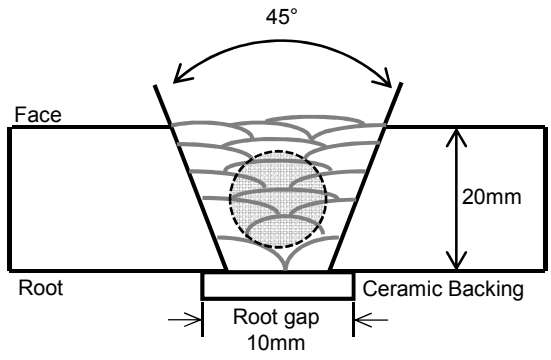
■ Shielding Gas

- **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

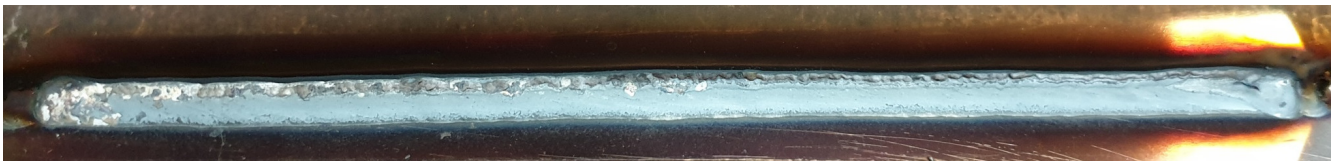
	Y.S (MPa)	T.S (MPa)	El. (%)	Shielding Gas	PWHT
K-436T	**385**	**490**	**32**	**Ar + 2%O_2**	**AW**

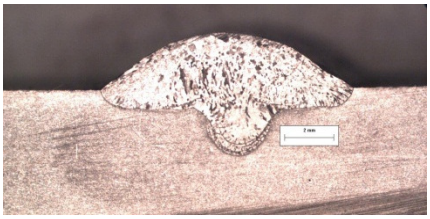
Typical Operating Procedures

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
Inverter	200	23	35	STS430	15	Ar + 2%O_2

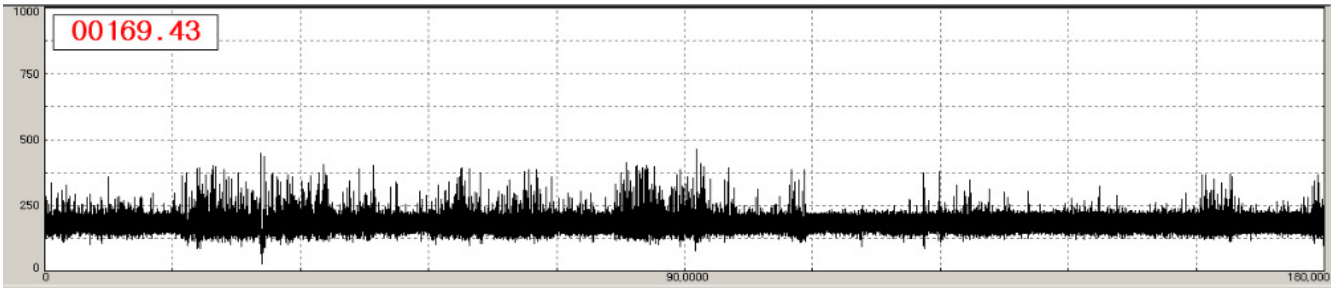




Depth (mm)	Width (mm)	Reincorcement (mm)
2.70	10.30	2.19

■ Feedability

5m, 2turn torch



Current (A)	Current deviation	Voltage (V)	Voltage deviation	Feed resistance
186.22	25.90	24.30	2.11	3.90

K-436T has stable feedability

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%

KISWEL

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

