K-439T(TE)

FLUX CORED ARC WELDING
CONSUMABLE FOR
FERRITIC STAINLESS STEEL

KISWEL

Rev.0

K-439T(TE)

Description & Application

- **K-439T is designed for MAG welding of stainless steels of the 18%Cr-Ti types and suitable for automotive exhaust fabrications such as front pipe, bellows, flange etc. (AISI 430, 430Ti, 431)**
- **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.**
- **K-439T uses Ar + 2%O_2 shielding gas.**
- **K-439TE uses 100%Ar shielding gas.**

Classification

- **Not required**

Typical Chemical Composition of Weld Metal(%)

	C	Si	Mn	Cr	Mo	Ti
K-439T	0.03	0.45	0.43	16.05	0.02	0.50
K-439TE	0.03	0.42	0.50	15.70	0.02	0.35

Shielding Gas

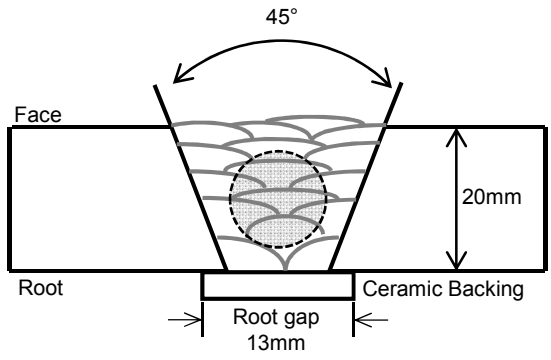
- **Ar + 2%O_2 (15~25ℓ/min)**
- **100%Ar (15~25ℓ/min)**

Welding position



K-439T(TE)

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-439T	**390**	**495**	**24**	**Ar + 2%O_2**	**AW**
K-439TE	**400**	**500**	**24**	**100%Ar**	**AW**

Typical Operating Procedures

Dia (mm)	Shielding Gas	Current (amps)	Voltage (volts)
1.2	**Ar + 2%O_2 100%Ar**	**150**	**20**
		200	**22**
		240	**25**

■ Application

Brand name	Dia. (mm)	Current (A)	Voltage (V)	Stick out (mm)	Shielding Gas
K-439T	1.2	170~260	21~25	15~20	Ar + 2%O_2





Brand name	Dia. (mm)	Current (A)	Voltage (V)	Stick out (mm)	Shielding Gas
K-439TE	1.2	170~260	21~25	15~20	100%Ar




■ 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

