

SF-409Ti

METAL CORED ARC WELDING CONSUMABLE
FOR WELDING OF 409 TYPE STAINLESS STEEL



❖ Specification

AWS A5.9

EC 409

❖ Applications

Metal type flux cored wire designed for the horizontal fillet welding of AISI 409 ferrite stainless steels.

❖ Characteristics on Usage

This wire has been specifically formulated for use in the welding of automotive exhaust systems and mufflers. It benefits from being spatter free and without slag formation when used with argon or argon oxygen mixed shielding gas. It also has an excellent deposition rate and corrosion resistance. High speed welding can be carried out with this product on thin plate material without burning through. SF-409Ti can be used in the welding of similar chemical composition alloys.

❖ Note on Usage

Use with Ar or Ar + 2~5%O₂ gas.

❖ Packing

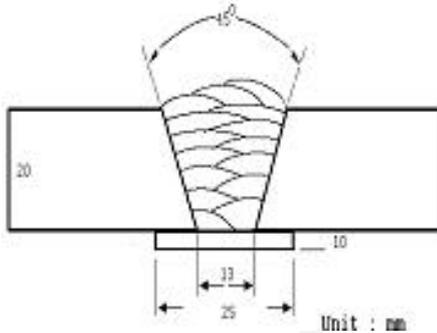
Dia.	1.2mm(0.045in)	
Spool *including ball pac	12.5kg(27.6lbs)	15kg(33lbs)



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



[Joint Preparation & Layer Details]

Diameter(mm)	: 1.2mm(0.045in)
Shielding Gas	: 100%Ar
Flow Rate(ℓ /min.)	: 20~22
Amp./ Volt.	: 220/26
Stick-Out	: 20mm (0.79in)
Pre-Heat(°C)	: 150°C(302°F)
Interpass Temp.(°C)	: 150 ~ 260°C(302~500°F)
Polarity	: DC(+)

❖ Mechanical Properties of All weld metal

Consumable	Tensile Test	
	TS Mpa(ksi)	EL(%)
SF-409Ti	500(73)	20

❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	P	S	Cr	Ti
SF-409Ti	0.03	0.50	0.55	0.012	0.010	12.5	1.0

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.



Proper Welding Condition

❖ Proper Current Range

Consumable	Shielding Gas	Welding Position	Wire Dia.
			1.2mm (0.045in)
SF-409Ti	100%Ar or Ar + 2~5%O ₂ gas	F & HF	150~250Amp

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