



## MIGINOX MC 409

TITANIUM STABILISED 409 TYPE GAS SHIELDED METAL CORED WIRE

**CLASSIFICATION :** AWS A/SFA 5.22 EN ISO 17633-A

EC409

T 13 Ti M M13/M21 3

### KEY FEATURES :

- Gas shielded metal cored wire
- Typical 12Cr, Ti stabilized SS alloy
- Smooth operating characteristics
- Radiographic weld quality
- Ti addition form carbides to improve corrosion resistance, increase strength at high temperature and promote the ferritic microstructure

### WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
98Ar/2O <sub>2</sub> or 80Ar/20CO <sub>2</sub>	15-25	10-20

### TYPICAL APPLICATIONS :

- For joining of matching base materials of 409 type
- Automotive industries for automotive exhaust system components

### STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Cr	Ni
Specification	0.08 max	0.8 max	0.8 max	10.5-13.5	0.6 max
	Mo	Ti	S	P	
Specification	0.50 max	10xC-1.5	0.03 max	0.03 max	

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	450 min	15 min

### PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	24 – 32	150 - 280	12.5/15
1.6	25 – 33	180 - 310	12.5/15

