



Select HT 409Ti

Description:

Select HT 409Ti is a premium composite metal cored electrode for gas-shielded arc welding of ferritic stainless steels. This electrode is formulated to produce enhanced bead wetting, which allows for faster travel speeds, improved bead geometry, and has a superior ability to bridge gaps and joints when compared to standard 409Ti consumables. Shielding gas is 98% argon/2% oxygen, however, other argon blends can be used as individual applications allow. Gas flow rates of 40-55 cfh should be utilized, and dew points must be at least -40°F.

Classification:

- EC409 per AWS A5.22

Characteristics:

Select HT 409Ti is a premium, composite metal cored electrode intended to weld ferritic stainless steels of similar composition. This formulation provides enhanced weldability when compared to 409Ti consumables. **Select HT 409Ti** with all its utility, is simply the best 409Ti ferritic wire on the market. Modern equipment and manufacturing techniques provide the highest levels of quality, consistency, and performance in the industry.

Typical Applications:

Select HT 409Ti is the ideal product for welding automotive exhaust systems, especially manifolds, mufflers, converters, and other components. It excels in the welding of tubing to these other components, particularly where there are gaps or generally poor fit up.

Typical Composition:

Wt. %	<u>C</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Si</u>	<u>Cr</u>	<u>Ti</u>
	.03	.7	.010	.010	.60	11.0	1.0

Suggested Parameters:

<u>Diam. (in.)</u>	<u>Amperage</u>	<u>Optimum</u>		<u>Amperage</u>	<u>Range</u>		<u>ESO</u>
		<u>WFS</u>	<u>Voltage</u>		<u>WFS</u>	<u>Voltage</u>	
.045"	250	410	25-26	190-330	240-600	22-28	½-1"
.052"	300	350	24-25	220-460	220-620	23-30	½-1"
1/16"	350	300	26	240-520	160-500	22-31	¾-1¼"

Rev 0 (04/07/2017)

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field.