

Select 439Ti

Description:

Select 439Ti is a bare stainless steel wire electrode for gas-metal arc welding. This electrode is intended for joining ~18 wt% chromium ferritic stainless steel sheet and thin gauge material where titanium is preferred for sensitization prevention over niobium (columbium).

Classification:

- ER439 per AWS A5.9

Applications:

Select 439Ti is designed to weld heat resistant, corrosion resistant, ferritic stainless steels used in exhaust system components. Typical applications include manifolds, converters, mufflers and tubular components of automotive exhaust systems made of 430 grade materials.

Typical Deposit Composition (wt%):

<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>Cr</u>	<u>Ti</u>
0.01	0.67	0.69	17.6	0.45

Suggested Parameters:

<u>Diameter</u>	<u>Optimum (CV)</u>		<u>Current (A)</u>	<u>Range</u>	<u>WFS (IPM)</u>
	<u>Current (A)</u>	<u>Voltage (V)</u>		<u>Voltage (V)</u>	
.035"	115-145	17-20	55-160	15-24	155-670
.040"	130-160	18-21	60-240	15-25	155-660
.045"	160-190	20-22	80-260	15-26	155-650
1/16"	190-220	22-24	100-300	15-28	155-630