Select FP 409Ti-C

Stainless Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Increased titanium (Ti) content, compared to solid wire of similar classification, promotes an improved resistance to sensitization and enhanced arc stability.
- Can successfully weld aluminized ferritic stainless steel components.
- “FP” technology promotes joining thin (~0.8mm) automotive components.
- Metal cored construction inherently provides better welding performance compared to solid wires.
- Designed to weld exhaust system components of similar composition, ~12 wt% chromium (Cr).

CONFORMANCES

AWS A5.22	EC409
ASME SFA 5.22	EC409

DIAMETERS [in (mm)]

0.045 (1.2)

POSITIONS

SHIELDING GAS

Ar + 0.5-5% CO2, Ar + 0.5-3% O2
Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Cr	Cu	Mn	Mo	Ni	P	S	Si	Ti
Argon	0.01	11.92	0.02	0.46	<0.01	0.02	0.015	0.018	0.62	0.40

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	98% Ar/2% O2	Flat & Horizontal	280 (7.1)	200	20	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	350 (8.9)	220	21	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	400 (10.2)	250	23	5/8 (16)
		Flat & Horizontal	475 (12.1)	275	25	5/8 (16)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*
***The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with “all-position” capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn’t limited to the listing.*

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APPROVALS

Agency	Approval	Shielding Gas	Diameter(s) in (mm)
Chrysler MS-90024/04	W403	N/A	0.035 (0.9) - 1/8 (3.2)

PACKAGING [lbs [kgs]]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.

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