

# KMX-409Ti

**Classification**

AWS A5.22/A5.22M	EC409
JIS Z3323	TS409-MA1
EN ISO 17633-A	T 13Ti M M13 0
GB T17853	T 13Ti M M13 0

Shielding Gas : Ar+2%O<sub>2</sub>**Applications and Features**

- ( 1 ) Weld metal is 12%Cr -Ti.
- ( 2 ) Designed for joining components of automotive exhaust systems, such as catalytic converters
- ( 3 ) Ideal for welding ferritic stainless steel, such as AISI/ SUS 409.

**Welding position****Welding Instruction**

- ( 1 ) For other instructions, please refer to Appendix D.
- ( 2 ) For extra information, please refer to Appendix F.

**Typical Chemical Composition of Weld Metal (wt%)**

C	Si	Mn	P	S	Cr	Ti
0.03	0.59	0.30	0.012	0.005	11.86	0.90

**Typical Mechanical Properties of Weld Metal**

Tensile Strength	Yield Strength	Elongation
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%
489	410	15

**Size and Suggested Operating Range (DC+)**

Diameter (mm)	F/H-Fillet	
	Current (A)	Voltage (V)
1.0	100~180	16~24
1.2	120~250	18~26