

# KMX-439Ti

## Classification

AWS A5.22/A5.22M	EC439
JIS Z3323	-
EN ISO 17633-B	TS 430-M M13 0
GB T17853	TS 430-M M13 0

Shielding Gas : Ar+2%O<sub>2</sub>

## Applications and Features

- ( 1 ) Weld metal is 18%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 409/430/436/440..

## 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	0.51	0.35	0.022	0.009	17.61	0.81

## Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%
526	440	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