

# SF-436

TYPE : Metal-Cored

## Applications

SF-436 is a metal cored wire for horizontal, fillet and flat position welding of 409,430 and 436 type stainless steels as found in ferrite stainless steels automotive mufflers.

## Characteristics on Usage

This wire gives excellent bead appearance and provides the operator with a soft stable arc and very

low spatter levels thus giving enhanced cosmetic appearance.

## Notes on Usage

- ① Use with Ar or Ar + 2~5% O<sub>2</sub> gas.

## Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

## Current

DC +

## Shielding Gas

Ar/Ar+2~5%O<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% Ar)

C	Si	Mn	P	S	Cr	Mo	Ti
0.03	0.60	0.40	0.008	0.010	17.5	1.0	0.40

## Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% Ar)

TS MPa(lbs/in <sup>2</sup> )	EL (%)	Heat Treatment
500 (72,600)	35	770° C × 4hr FC to 600° C AC to RT

## Approval

## I Packing(Including Ball Pac)

Dia. (mm)	1.2	Spool(kg)	12.5	15
(in)	.045	(lbs)	28	33

## Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)
F&HF	150~250