

SC-439Ti Cored

TYPE : Metal-Cored

Applications

SC-439Ti Cored is a metal cored wire designed for flat and horizontal fillet welding of AISI 439 ferrite stainless steels.

Characteristics on Usage

This wire has specifically formulated for use in the welding of automotive exhaust systems and mufflers. It benefits from being spatter free and without slag formation when used in conjunction with argon or argon oxygen mixed shielding gas. It also has an excellent deposition rate and corrosion resistance.

High speed welding can be carried out with this product on thin plate material without burning through. SC-439Ti Cored can used in the welding of similar chemical composition alloys.

Notes on Usage

① Use with Ar or Ar + 2~5%O₂ gas.

Welding Position



1G 2F
(PA) (PB)

Current

DC +

Shielding Gas

Ar/Ar+2~5%O₂

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

C	Si	Mn	P	S	Cr	Ti
0.03	0.30	0.60	0.005	0.010	18.5	0.75

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

TS MPa(lbs/in ²)	EL (%)	Heat Treatment
500 (72,600)	40	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) F & HF	1.2 (.045) 150~250
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