

**Classifications**

Not required

**Description**

- K-439T is designed for MAG welding of stainless steels of the 18%Cr-Ti types and suitable for automotive exhaust fabrications such as front pipe, bellows, flange etc. (AISI 430, 430Ti, 431)
- Wire is a metal type of flux cored wire for high speed welding on the plate as possible.
- It would produce a moderately soft arc and low spatter generation.
- Slag quantity is almost the same as solid wire and deposition rate is up to 20% higher than solid wire's one.
- K-439T has the high tensile strength at the high temperature atmosphere.

**Welding positions****Polarity & shielding gas**

- Mix: Ar+2% O<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

**Typical chemical composition of all-weld metal (%)**

Shielding gas	C	Si	Mn	P	S	Cr	Ti
Mix	0.03	0.45	0.55	0.010	0.015	16.50	0.90

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
Example	390	495	24	Mix

<sup>\*)</sup> After machining, but before testing, the specimen was aged at a temperature 100°C for up to 48 hours then allowed to cool to room temperature.

**Notes on usage and welding condition**

	Dia.(mm)	1.2	Stick-out
Current (Amp.)	PA/1G PC/2G	180 ~ 260 (22 ~25)	(15 ~20mm)

**Package**

	Dia. (mm)	1.2	1.32
Spool (kg)		12.5, 15	
Pailpack (kg)		100 ~ 200	