

Arcaloy MC409Ti

Arcaloy MC409Ti is a 12% Cr alloy metal cored electrode stabilized with Titanium (Ti) for arc stability and to improve corrosion resistance, increase strength at high temperatures, and promote the ferritic microstructure. Arcaloy MC409Ti produces a smooth spray-type metal transfer with very minimal spatter. It is particularly suited for welding parts with poor fit up. It was designed for welding stainless steel catalytic converters, manifolds, mufflers, and exhaust systems.

Luokittelut	AWS A5.22 : EC409
Toimiala tai segmentti	Autoteollisuus

Hitsiaineen Koostumus

C	Mn	Si	S	P	Cr	Ti
0.02	0.72	0.27	0.01	0.01	11.90	1.00

Hitsausarvot

Halkaisija	A	Jännite	Langansyöttönopeus
1.2 mm	200 A	20 V	533 cm/min
1.2 mm	215 A	21 V	584 cm/min
1.2 mm	234 A	22 V	635 cm/min
1.2 mm	290 A	24 V	762 cm/min
1.2 mm	323 A	24 V	889 cm/min