

# SW-409Ti



不 锈 钢 药 芯 焊 丝  
Flux Cored Wire For Stainless Steel

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## 执行标准 CLASSIFICATION

符合 AWS G/B 17853 TS409-M 13 0 A5.22EC409

## 产品特性 DESCRIPTION

这种 12Cr 合金 (wt%) 与 410 型材料不同, 因为它具有铁素体微观结构。钛的加入形成碳化物, 以提高耐腐蚀性, 增加高温强度, 促进铁素体微观结构, EC409 填充金属可用于连接匹配或不同的基体金属。

This 12Cr alloy (by weight percent) differs from Type 410 material in that it has a ferritic microstructure. The addition of titanium forms carbides, which improves corrosion resistance, enhances high-temperature strength, and promotes the ferritic microstructure. EC409 filler metal can be used to join matching or dissimilar base metals.

## 应用 APPLICATIONS

通常用于 AISI 409 铁素体不锈钢及相似成分的合金钢, 尤其是用汽车排气系统和汽车消音器焊接及单道焊。

It is typically used for AISI 409 ferritic stainless steel and alloy steels with similar compositions, especially in the welding of automotive exhaust systems and automotive mufflers, as well as for single-pass welding.

## 电源类型 CURRENT TYPE

焊枪接正电极 DC+

## 过程保护 PROCESS

二氧化碳气保焊 100%CO<sub>2</sub> Gas-shielded Welding

## 焊接位置 WELDING POSITIONS

平焊、角焊、仰焊、立向上焊、立向下焊 Flat, fillet, tilt, vertical up, vertical down

## 熔敷金属化学成分 CHEMICAL COMPOSITION OF WELDED METAL %

| 项目                | C     | Si   | Mn   | P      | S      | Cu    | Ni    | Cr        | Mo    | Ti       |
|-------------------|-------|------|------|--------|--------|-------|-------|-----------|-------|----------|
| GB/T Standard     | ≤0.08 | ≤0.8 | ≤0.8 | ≤0.030 | ≤0.030 | ≤0.75 | ≤0.60 | 10.5-13.5 | ≤0.75 | 10*C-1.5 |
| 例值 Typical values | 0.02  | 0.52 | 0.43 | 0.008  | 0.006  | 0.020 | 0.006 | 11.5      | 0.015 | 0.80     |

## 作业条件 OPERATING CONDITIONS

| 直径 Diameter [mm] |                       | φ1.0 | φ1.2    | φ1.6 |
|------------------|-----------------------|------|---------|------|
| 电流 Current [A]   | 平焊 Flat               | -    | 150-280 | -    |
|                  | 上立焊/仰焊 V-Up&Overhead  | -    | -       | -    |
|                  | 下立焊 Vertical Downward | -    | -       | -    |

## 包装 PACKAGING

5kg 12.5kg 盘装 Coil

也可以定制其他包装和规格 Other packaging and other diameters: please consult us