ROYALFIL GS 409TI

AWS A/SFA 5.22 EC 409

Applications :

Often used for base metals of similar composition. Also used for welding of automotive exhaust system componentes & mufflers.

Characteristics on Usage :

Royalfil GS 409TI is a ferritic type gas shielded metal type flux cored wire with argon or argon oxygon mixed shielding gas. Weld metal composition is 12 % Cr.with Ti.added as stabilizer which promotes a ferritic microstructure & improves corrosion resistance. High welding speed can be achieved on thin material with excellent deposition rate.

Welding Positions

1G 2F

Recommended stick out

20-25 mm

Shielding Gas

98% Ar +2 % O2 Shielding Gas Flow: 15-20 Lit/min

Chemical Composition Of Weld Metal :

Element	C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	Ti%	Cu%
Typical Values	0.045	0.55	0.40	0.009	0.020	12.00	0.50	0.010	0.60	0.040
Spec. Reqd.	0.080 Max	0.80 Max	0.80 Max	0.030 Max	0.030 Max	10.5 – 13.50	0.60 max	0.50 Max	10xcmin - 1.50max	0.75 Max

Mechanical Properties Of Weld Metal :

Property	UTS (N/mm²)	Elongation (L=4d) %	
Typical Values	520	22	
Spec. Reqd.	450 min	15min	

WELDING PARAMETERS: (DC + VE)

Size of Wire Dia (MM)	FLAT & HORIZONTAL A	V
1.20	200-280	28-34
1.60	250-320	28-34

Packing:

15 Kg Vaccum packed plastic spool.