



KISWEL K-409TiT

Classifications:

EN ISO 17633-B: TS409-M M13 0
AWS A5.22 : E409T0-G

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Ni	Mo	Cr	Ti
<0.10	<1.00	<0.80	<0.60	<0.50	10.50 – 13.50	<1.50

Description:

- K-409TiT is a Metal Cored Wire for automotive exhaust manufacturers
- The said wire excels in pulsed GMAW mode and additional applications which include heat exchangers, recuperators and power plant reheater tubes etc.
- It would produce a moderately soft arc and low spatter generation and also provide excellent bead appearance and porosity resistance.
- Slag quantity is almost the same as a solid wire and deposition rate is up to 20% higher than solid wire's one.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 380	Min. 450	min. 15

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.20 mm	Ar + 2% O ₂	180	340	24	33



ENAR WELD BRAZE PVT. LTD, Enar Chambers, A-112, DDA INDUSTRIAL SHEDS, OKHLA INDUSTRIAL AREA,
PHASE - II, NEW DELHI – 110020 ☎ : 011-26383911 /12 /13 Fax : 011-26383913 e-mail : info@enarweld.com

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