



## ENAR WELD BRAZE PVT. LTD

A-112, DDA INDUSTRIAL SHEDS,  
OKHLA INDUSTRIAL AREA, PHASE – II  
NEW DELHI – 110020

Telephone : 011-26383911/12/13  
Fax : 011-26383913  
E-Mail : info@enarweld.com

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### KISWEL K-409TiT

#### Classifications:

EN ISO 17633-B:2008 : TS409-MA0

AWS A5.9 : EC409

#### Typical Chemistry Composition of Weld Deposit:

Shielding Gas	C	Si	Mn	P	S	Cr	Ti
Ar+2%O <sub>2</sub>	<0.08	<0.80	<0.80	<0.03	<0.03	10.50 – 13.50	<1.50

#### Description:

- K-409TiT is developed to meet the needs of the automotive exhaust fabricators that desired a metal cored wire. It excels in the pulsed GMAW mode and additional applications include heat exchangers and recuperators, power plant reheater tubes etc.
- Wire is a metal type of flux cored wire for high speed welding on the plates as possible.
- 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)  
min. 460

Tensile Strength  
(Mpa)  
min. 450

Elongation  
(%)  
min. 15