

ROYALFIL GS - 409TI

AWS A /SFA 5.22 EC 409

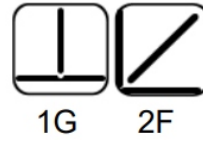
Applications

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

Characteristics on Usage

Royalfil GS 409TI is a ferritic type gas shielded metal type flux cored wire with argon or argon oxygen 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



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) Shielding
Gas Flow : 15-20 Lit / Min

FLUX CORED WIRE : STAINLESS STEEL

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%
0.080 Max	0.80 Max.	0.80 Max	0.030 Max	0.040 Max	10.50-13.50
NI%	Mo%	Ti%	Cu%		
0.60 Max	0.50 Max	10xc Min-1.50 Max	0.75 Max		

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION. (L = 4d) %
450-520 Min	15-22 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	200-280	28-34
1.60	250-320	28-34

Packing

15 kgs. Vacuum packed plastic spool