

Arcaloy MC439Ti

Arcaloy MC439Ti is an 16-17% Cr alloy metal cored electrode stabilized with Titanium (Ti). The high level of chromium provides additional oxidation and corrosion resistance when welding stainless steel catalytic converters, manifolds, mufflers, and exhaust systems. It is also suited for welding parts with poor fit up. Arcaloy MC439Ti produces a spray - type metal transfer with minimal spatter.

Specifications

Classifications	SFA/AWS A5.22 : EC439
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Welding Current	DC+
Alloy Type	MC439Ti
Shielding Gas	M13 (EN ISO 14175)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Ti
0.02	0.76	0.27	0.01	0.01	17.90	0.68

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Electrical Stickout
1.2 mm (.045 in.)	200 A	20 V	533 cm/min (210 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	215 A	21 V	584 cm/min (230 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	234 A	22 V	635 cm/min (250 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	290 A	24 V	762 cm/min (300 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	323 A	24 V	889 cm/min (350 in./min)	12.7 mm (0.5 in.)

Recommended Welding Parameters

Current	Wire Diameter	Voltage	Wire Feed Speed
200-323 A	1.2 mm (0.045 in.)	20-24 V	5.23-8.89 mm/min (206-350 in./min)