# Arcaloy MC409Ti

Arcaloy MC409Ti is a 12% Cr alloy metal cored electrode stabilized with Titanium (Ti) for arc stability and to improve corrosion resistance, increase strength at high temperatures, and promote the ferritic microstructure. Arcaloy MC409Ti produces a smooth spray-type metal transfer with very minimal spatter. It is particularly suited for welding parts with poor fit up. It was designed for welding stainless steel catalytic converters, manifolds, mufflers, and exhaust systems.

| Specifications | |
|---|---|
| **Classifications** | SFA/AWS A5.22 : EC409 |

| Typical Weld Metal Analysis % | | | | | | |
|---|---|---|---|---|---|---|
| **C** | **Mn** | **Si** | **S** | **P** | **Cr** | **Ti** |
| 0.02 | 0.72 | 0.27 | 0.01 | 0.01 | 11.90 | 1.00 |

| Deposition Data | | | | |
|---|---|---|---|---|
| **Diameter** | **Current** | **Voltage** | **Wire Feed Speed** | **Electrical Stickout** |
| 1.2 mm | 200 A | 20 V | 533 cm/min | 12.7 mm |
| 1.2 mm | 215 A | 21 V | 584 cm/min | 12.7 mm |
| 1.2 mm | 234 A | 22 V | 635 cm/min | 12.7 mm |
| 1.2 mm | 290 A | 24 V | 762 cm/min | 12.7 mm |
| 1.2 mm | 323 A | 24 V | 889 cm/min | 12.7 mm |

| Recommended Welding Parameters | | | |
|---|---|---|---|
| **Current** | **Wire Diameter** | **Voltage** | **Wire Feed Speed** |
| 200-323 A | 1.2 mm | 20-24 V | 5.33-8.89 mm/min |