

## 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

<b>Classifications</b>	SFA/AWS A5.22 : EC409
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### 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 (.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	5.33-8.89 mm/min ( 210-350 in./min )