

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
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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	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