

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.

Dane techniczne

Klasyfikacje	SFA/AWS A5.22 : EC439
Przemys	Motoryzacja

Prd spawania	DC+
Rodzaj stopu	MC439Ti
Gaz osonowy	M13 (EN ISO 14175)

Typowy skad chemiczny stopiwa %

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

Dane wydajności stopiwa

rednica	A	V	Prdko podawania drutu	Wolny wylot elektrody
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

Parametry spawania

A	rednica drutu	V	Prdko podawania drutu
200-323 A	1.2 mm	20-24 V	5.23-8.89 mm/min