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 (.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)