

# **SC-439Ti Cored**

METAL CORED ARC WELDING CONSUMABLE  
FOR WELDING OF 409, 430, 436 AND 439 TYPE STAINLESS STEEL



## SC-439Ti Cored

### ❖ Specification

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### ❖ Applications

Metal cored wire designed for the horizontal fillet welding of AISI 439 ferrite stainless steels.

### ❖ Characteristics on Usage

This wire has specifically formulated for use in the welding of automotive exhaust systems and mufflers. It benefits from being spatter free and without slag formation when used in conjunction with argon or argon oxygen mixed shielding gas. It also has an excellent deposition rate and corrosion resistance.

### ❖ Note on Usage

Use with Ar or Ar + 2~5%O<sub>2</sub> gas.

### ❖ Packing

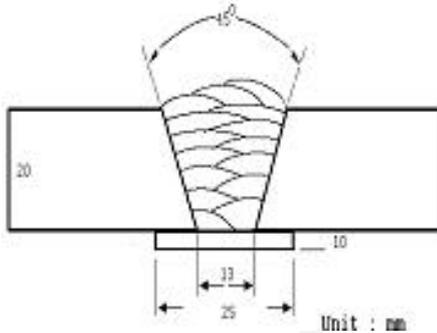
<b>Dia.</b>	1.2mm(0.045in)	
<b>Spool *including ball pac</b>	12.5kg(27.6lbs)	15kg(33lbs)



## Mechanical Properties & Chemical Composition of All Weld Metal

### ❖ Welding Conditions

Method by AWS Spec.



[ Joint Preparation & Layer Details ]

<b>Diameter(mm)</b>	: 1.2mm(0.045in)
<b>Shielding Gas</b>	: 100%Ar
<b>Flow Rate(ℓ /min.)</b>	: 20~22
<b>Amp./ Volt.</b>	: 220/26
<b>Stick-Out(mm)</b>	: 20mm (0.79in)
<b>Pre-Heat(℃)</b>	: 150℃(302℉)
<b>Interpass Temp.(℃)</b>	: 150 ~ 260℃(302~500℉)
<b>Polarity</b>	: DC(+)

### ❖ Mechanical Properties of All weld metal

Consumable	Tensile Test		Heat Treatment
SC-439Ti Cored	<b>TS</b> MPa(ksi)	<b>EL(%)</b>	770℃(1418℉) x 4Hr FC to 600℃(1112℉) AC to RT
	500(73)	40	

### ❖ Chemical Analysis of All weld metal(wt%)

Consumable	C	Si	Mn	P	S	Cr	Ti
SC-439Ti Cored	0.03	0.30	0.60	0.005	0.010	18.5	0.75

This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.



# Proper Welding Condition

## ❖ Proper Current Range

Consumable	Shielding Gas	Welding Position	Wire Dia.
			1.2mm (0.045in)
SC-439Ti Cored	100%Ar or Ar + 2~5%O <sub>2</sub> gas	F & HF	150~250Amp

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