

**Applications :**

Often used for base metals of similar composition. Also used for welding of automotive exhaust system components & mufflers.

**Characteristics on Usage :**

Royalfil GS 409TI is a ferritic type gas shielded metal type flux cored wire with argon or argon oxygen mixed shielding gas. Weld metal composition is 12 % Cr.with Ti.added as stabilizer which promotes a ferritic microstructure & improves corrosion resistance. High welding speed can be achieved on thin material with excellent deposition rate.

**Welding Positions**

**Recommended stick out**

**Shielding Gas**

20-25 mm

98% Ar +2 % O2 Shielding  
Gas Flow: 15-20 Lit/min



1G

2F

**Chemical Composition Of Weld Metal :**

Element	C%	Mn%	Si%	S%	P%	Cr%	Ni%	Mo%	Ti%	Cu%
Typical Values	0.045	0.55	0.40	0.009	0.020	12.00	0.50	0.01 0	0.60	0.040
Spec. Reqd.	0.080 Max	0.80 Max	0.80 Max	0.030 Max	0.030 Max	10.5 – 13.50	0.60 max	0.50 Max	10xcmin - 1.50max	0.75 Max

**Mechanical Properties Of Weld Metal :**

Property	UTS (N/mm <sup>2</sup> )	Elongation (L=4d) %
Typical Values	520	22
Spec. Reqd.	450 min	15min

**WELDING PARAMETERS: (DC + VE)**

Size of Wire Dia (MM)	FLAT & HORIZONTAL	
	A	V
1.20	200-280	28-34
1.60	250-320	28-34

**Packing:**

15 Kg Vaccum packed plastic spool.

