



## Select 409Ti

### Description:

**Select 409Ti** is a composite metal cored electrode for gas-shielded arc welding of ferritic stainless steels. This electrode is formulated to produce improved bead wetting, which provides wider penetration of the bead. The results include faster travel speeds, improved bead geometry, and superb ability to bridge gaps and joints with poor fit up. The optimum shielding gas is 98% argon/2% oxygen, however, other argon blends can be used as individual applications allow. Gas flow rates of 40-55 cfh should be utilized, and dew points must be at least -40°F.

### Classification:

- EC409 per AWS A5.22 (also per AWS A5.9:2006)

### Characteristics:

**Select 409Ti** is a premium, composite metal cored electrode intended to weld ferritic stainless steels of similar composition. This new formulation provides increased travel speeds, enhanced bead geometry, and extremely low spatter. A real breakthrough in this electrode is the ability to bridge gaps and joints with poor fit up. This product outperforms all other electrodes in these areas, even on very thin material. The **Select 409Ti** is a major "problem solver" for difficult-to-weld joints, parts that require a reduction in reject rates, and areas which need reduced cycle times. Modern equipment and manufacturing techniques provide the highest levels of quality, consistency, and performance in the industry.

### Typical Applications:

**Select 409Ti** is the ideal product for welding automotive exhaust systems, especially manifolds, mufflers, converters, and other components. It excels in the welding of tubing to these other components, particularly where there are gaps or generally poor fit up.

### Typical Composition:

Wt. %	<u>C</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Si</u>	<u>Cr</u>	<u>Ti</u>
	.03	.65	.010	.010	.60	11.2	.65

### Suggested Parameters:

<u>Diam. (in.)</u>	<u>Amperage</u>	<u>Optimum</u>		<u>Amperage</u>	<u>Range</u>		<u>ESO</u>
		<u>WFS</u>	<u>Voltage</u>		<u>WFS</u>	<u>Voltage</u>	
.045"	250	410	25-26	190-330	240-600	22-28	½-1"
.052"	300	350	24-25	220-460	220-620	23-30	½-1"
1/16"	350	300	26	240-520	160-500	22-31	¾-1¼"

Rev 1 (04/06/2017)

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field.