

# PRIMALLOY™ T-409Ti

Stainless ▪ AWS EC409

## KEY FEATURES

- Minimal spatter and slag
- Great deposition rates
- High travel speed welding on thin material

## WELDING POSITIONS

All Positions

## CONFORMANCES

AWS A5.22/A5.22M: EC409

## TYPICAL APPLICATIONS

- Designed for joining components of automotive exhaust systems, such as catalytic converters
- Single pass welding

## SHIELDING GAS

98% Ar / 2% O<sub>2</sub>,  
40-45 CFH

## DIAMETERS / PACKAGING

Diameter mm (in)	33 lb (15 kg) Plastic Spool	500 lb (227 kg) Bulk Drum
0.045 (1.2)	ED034208	ED034209

## DEPOSIT COMPOSITION<sup>(1)</sup> – As Required per AWS A5.22/A5.22M

	%C	%Cr	%Ni	%Mo	%Mn
<b>Requirements</b> AWS EC409	0.08	10.5-13.5	0.6	0.5	0.8
<b>Typical Results<sup>(2)</sup></b> 98% Argon / 2% O <sub>2</sub>	0.03	11.1	0.02	0.03	0.5
	%Si	%P	%S	%Ti	
<b>Requirements</b> AWS EC409	0.8	0.03	0.03	10xC min 1.5 max	
<b>Typical Results<sup>(2)</sup></b> 98% Argon / 2% O <sub>2</sub>	0.6	0.007	0.008	1.0	

## TYPICAL OPERATING PROCEDURES

Diameter, Polarity, Shielding Gas	CTWD in (mm)	Wire Feed Speed in/min (m/min)	Voltage (Volts)	Approx. Current (Amps)
0.045 (1.2), DC+ 98% Argon / 2% CO <sub>2</sub>	5/8 (15.8)	200 (5.08)	22	200
		250 (6.35)	23	230
		300 (7.62)	25	260
		450 (11.43)	28	335

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

# PRIMALLOY™ T-439Ti

Stainless ▪ AWS EC439

## KEY FEATURES

- Minimal spatter and slag
- Great deposition rates
- High travel speed welding on thin material

## WELDING POSITIONS

All Positions

## CONFORMANCES

AWS A5.22/A5.22M: EC439

## TYPICAL APPLICATIONS

- Designed for joining components of automotive exhaust systems, such as catalytic converters
- Single pass welding

## SHIELDING GAS

98% Ar / 2% O<sub>2</sub>,  
40-45 CFH

## DIAMETERS / PACKAGING

Diameter mm (in)	33 lb (15 kg) Plastic Spool	500 lb (227 kg) Bulk Drum
0.045 (1.2)	ED034293	ED034294

## DEPOSIT COMPOSITION<sup>(1)</sup> – As Required per AWS A5.22/A5.22M

	%C	%Cr	%Ni	%Mo	%Mn
<b>Requirements</b> AWS EC439	0.04	17.0-19.0	0.6	0.5	0.8
<b>Typical Results<sup>(2)</sup></b> 98% Argon / 2% O <sub>2</sub>	0.03	17.5	0.02	0.02	0.47
	%Si	%P	%S	%Ti	
<b>Requirements</b> AWS EC439	0.8	0.03	0.03	10xC min 1.1 max	
<b>Typical Results<sup>(2)</sup></b> 98% Argon / 2% O <sub>2</sub>	0.4	0.01	0.01	0.4	

## TYPICAL OPERATING PROCEDURES

Diameter, Polarity, Shielding Gas	CTWD in (mm)	Wire Feed Speed in/min (m/min)	Voltage (Volts)	Approx. Current (Amps)
0.045 (1.2), DC+ 98% Argon / 2% CO <sub>2</sub>	5/8 (15.8)	200 (5.08)	22	200
		250 (6.35)	23	230
		300 (7.62)	25	260
		450 (11.43)	28	335

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

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