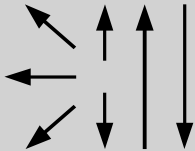


Classifications					
EN ISO 14343-A			AWS A5.9:		
G Z18 Ti L			ER439		
Characteristics and typical fields of application					
GMAW solid wire for catalytic converters as well as exhaust silencers, mufflers, manifolds, and manifold elbows of analogous or similar materials. Resists scaling up to 900 °C. Outstanding feeding characteristics. Very good welding and flow characteristics					
Base materials					
1.4510, X3CrTi17, 1.4016 X6Cr17, 1.4502, X8CrTi18 AISI 439					
Typical analysis of solid wire (wt.-%)					
	C	Si	Mn	Cr	Ti
wt.-%	0.03	0.8	0.8	18.0	> 12xC
Mechanical properties of all-weld metal					
Condition	Brinell-hardness				
	HBW				
u	150				
a	130				
u	untreated, as welded – shielding gas Ar + 8 – 10% CO ₂				
a	annealed, 800°C/1h – shielding gas Ar + 8 – 10% CO ₂				
Operating data					
	Polarity: DC (+)	Shielding gases: Argon + 5 – 10% CO ₂ Argon + 1 – 3% O ₂		ø (mm) 1.0	