



MIGINOX MC 409

AWS A/SFA 5.22 **EC409**

FCAW STAINLESS STEEL

CLASSIFICATION:

EN ISO 17633-A
T 13 Ti M M13/M21 2

KEY FEATURES:

- Gas shielded metal cored wire
- Typical 12Cr, Ti stabilized SS alloy
- Smooth operating characteristics
- Radiographic weld quality
- Uniform and fine ripples
- Excellent combination of high
- Ti addition form carbides to improve corrosion resistance, increase strength at high temperature and promote the ferritic microstructure

TYPICAL APPLICATIONS:

- For joining of matching base materials of 409 type
- Automotive industries for automotive exhaust system components



CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	Ti
0.08 max	0.8 max	0.8 max	10.5-13.5	0.6 max	0.50 max	10xC-1.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	450 min	15 min

PARAMETERS - PACKING DATA:

∅, mm	Kg/Spool	
1.2	12.5	 DCEP All Positions, Except Vertical Down:  STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box
1.6	12.5	

Shielding Gas	Gas Flow Rate, LPM
98Ar/2O ₂ or 80Ar/20CO ₂	15-25