PRIMALLOY™ T-409Ti is a stainless steel metal core wire designed for welding of AISI 409 ferrite stainless steels. The titanium addition forms carbides to improve corrosion resistance and increase strength at high temperature. The wire is widely used in welding of cold end of automotive exhaust systems.

**APPLICATION**
- Designed for joining components of automotive exhaust systems, such as tail pipe, muffler and intermediate pipe.
- Single pass welding.

**CONFORMANCE**
AWS A5.9/A5.9M: EC409

**APPROVALS**
CWB: EC409

**WELDING POSITIONS**
1G, 1F, 2G, 2F

**ADVANTAGE LINCOLN**
- No spatter and no slag
- Excellent deposition rate
- Excellent corrosion resistance in high temperature
- High travel speed welding on thin material
- Manufactured under a quality system certified to ISO 9001-2008 requirements

**PACKAGING**
- All spools of wire are level layer wound on black plastic spools.
- The spools are then vacuum-packed in moisture proof, polyfoil bags.
- The spools of wire are boxed and securely stacked on wooden pallets with shrink-wrap plastic.
Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements. Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

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www.lincolnelectric.com.cn

PRIMALLOY™ T-409Ti

PACKAGING, SHIELDING GAS AND AVAILABLE DIAMETERS

<table>
<thead>
<tr>
<th>Diameter (mm)</th>
<th>Packaging Type</th>
<th>Shielding Gas</th>
<th>Pallet Weight (kg)</th>
<th>Product No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2</td>
<td>15kg, Plastic Spools</td>
<td>98% Ar / 2%O₂, 18L/min or 40-45 CFH</td>
<td>1080</td>
<td>COPT409E21</td>
</tr>
<tr>
<td>1.2</td>
<td>225kg, Bulk Drum</td>
<td>98%Ar / 2%O₂, 18L/min or 40-45 CFH</td>
<td>900</td>
<td>COPT409X27</td>
</tr>
</tbody>
</table>

MECHANICAL PROPERTIES

PRIMALLOY™ T-409Ti is designed for single pass welding. Mechanical properties depend upon dilution and heat input.

WELD DEPOSITE CHEMICAL COMPOSITIONS (Wt-%) -- TYPICAL

<table>
<thead>
<tr>
<th>Requirements</th>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>S</th>
<th>P</th>
<th>Ni</th>
<th>Cr</th>
<th>Mo</th>
<th>Ti</th>
</tr>
</thead>
<tbody>
<tr>
<td>AWS EC409 (%) Max.</td>
<td>0.08</td>
<td>0.80</td>
<td>0.80</td>
<td>0.03</td>
<td>0.03</td>
<td>0.60</td>
<td>10.5-13.5</td>
<td>0.50</td>
<td>10×C min. 1.5% max.</td>
</tr>
<tr>
<td>Typical Values(%) (98%Ar / 2%O₂)</td>
<td>0.025</td>
<td>0.46</td>
<td>0.60</td>
<td>0.008</td>
<td>0.007</td>
<td>0.02</td>
<td>11.1</td>
<td>0.027</td>
<td>1.02</td>
</tr>
</tbody>
</table>

TYPICAL OPERATING PROCEDURES

<table>
<thead>
<tr>
<th>Wire diameter / Polarity / ESO</th>
<th>Arc Voltage (volts)</th>
<th>Approx. Current (amps)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2mm / DC+ / 15mm</td>
<td>22-28</td>
<td>200-260</td>
</tr>
</tbody>
</table>