EXECUTIVE 439Ti-MC

STAINLES STEEL

METAL CORED WIRE TECHNICAL DATA SHEET

DESCRIPTION

Executive 439Ti-MC is specifically engineered for welding exhaust system components of similar composition, offering improved oxidation resistance at elevated operating temperatures. Its metal-cored construction delivers superior welding performance compared to Executive 439Ti-MC solid MIG wire. Furthermore, the higher titanium content enhances arc stability for better overall weld quality.

APPLICATIONS & FEATURES

Executive 439Ti-MC is designed for joining automotive exhaust system components, including catalytic converters. It is highly effective for welding aluminized ferritic stainless-steel parts, providing reliable performance in these demanding applications. It is also suited for welding parts with poor fit up and produces a spray type metal transfer with minimal spatter.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cr	Ti
0.02	0.26	0.59	0.026	0.003	18.18	0.67

Tensile Strength: 76,300 PSI **Elongation:** 15%
Tensile Strength: 63,800 PSI

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Wire Feed Speed in/min (m/min)	Shielding Gas*	Position
.045"	20	200	280 (7.1)	98% Ar / 2% O_2	Flat & Horizontal
	21	220	350 (8.9)		
	23	250	400 (10.2)		
	25	275	475 (12.1)		
.062"	24-32	220-330		98% Ar / 2% O_2	Flat & Horizontal

STANDARD PACKAGING

Spools	33-lb plastic spools		1,980-lb pallet
Drums	.045"	440-lb ea	8,800-lb pallet

CLASSIFICATION

AWS A5.22 / ASME SFA-5.22 Class EC439