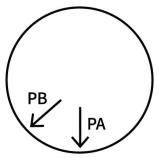
SF-436

Classification

AWS AWS A5.22 / ASME SFA-5.22
ECG

Welding Positions



Features

- Good corrosion resistance
- Low spatter
- Non-slag type

Polarity

DC+

Application Areas

- Stainless steels 409, 430 and 436 Type
- Automotive mufflers

Shielding Gas

100% Ar
Ar + 2% O2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cr	Mo	Ti
Ar + 2% O2	0.03	0.60	0.40	0.010	0.010	16.8	0.78	0.5

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)
Ar + 2% O2	500 (73)	35

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)
1.2 (0.045)	180~250