

CLASSIFICATIONS

AWS A5.9 : ER 409 Nb

DESCRIPTION

- It used for the welding of ferritic stainless steel 409Gb and 409Ti which are commonly used for exhaust parts in automotive industry
- High resistant to thermal fatigue
- With help of Nb addition, Chromium carbide formation is prevented
- Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mixed gases are used as shielding gas

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.07 | Si: 1.0 | Mn: 0.8 | Cr: 12.0 | Ni: 0.6 | Mo: 0.5

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (L _o =5d _o) (%)
min. 355	min. 450	min. 20

WELDING POSITIONS



CURRENT CONDITION

MIG D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100067	1.20	0.047"	15	D 300