

Standards

AWS A5.9 : ER 409 Nb

**Chemical Composition of
Welding Wire % (Typical)**

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

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (L ₀ =5d ₀) (%)
min. 355	min. 450	min. 20

Features and Applications

- 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

Welding Positions

Current Type

MIG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100364	1.20	0.047"	15	D 300