

❖ Product Description

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| I. 19Cr-9Ni-Nb type stabilized stainless steel wire | III. Resistance to cracking and embrittlement |
| II. Resistant to intergranular corrosion and scaling up to 850°C | IV. Smooth operating characteristics |
| | V. Radiographic weld quality |

❖ Range of Application

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| I. For welding Cr-Ni steels such as AISI 321, 321H, 347, 347H | IV. For boilers and gas turbines |
| II. For refineries, power plants, centrifugal pump impellers and shafts | V. Welding of stainless steel tanks, valves, pipes in food, chemical and petrochemical industry |
| III. Recommended for use at high temperature | |

❖ Classification

- AWS/SFA 5.9 ER409

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	Cr	Cu	Mo	P	Ni	Ti
ER409	Min	-	-	-	-	10.5	-	-	-	-	10xCmin
	Max	0.08	0.80	0.03	0.80	13.5	0.75	0.50	0.03	0.60	1.5

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charpy "v" Notch Impact @ -30°C
As Welded	450	350	20	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEN; 8-15lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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