

❖ Product Description

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| I. Ferritic stainless steel welding rod | III. Good uniform weld beads and minimization in spatter under optimum conditions |
| II. The niobium increases the corrosion resistance and promotes a ferritic micro-structure | IV. Radiographic weld quality |

❖ Range of Application

- I. Automotive exhaust
- II. Can be used to weld type 409 & 409Ti base material

❖ Classification

- AWS/SFA 5.9 ER409 Nb

❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
ER409 Nb	Min	-	-	-	-	-	10.5	-	-	-	10xCmin
	Max	0.08	0.8	1.0	0.03	0.04	13.5	0.6	0.50	0.75	0.75

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

- (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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