

409Nb Tig

CATEGORY	GMAW-GTAW Solid wires	
TYPE	A ferritic stainless steel welding wire	
APPLICATIONS	Used to weld Type 409 and 409Ti base materials	
CLASSIFICATION	AWS	A 5.9: ER 409Nb
	EN ISO	14343-B: SS 409 Nb
	DIN: W.Nr.	~1.4009

SUITABLE FOR 409 and 409Ti materials

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	Ni	Nb	Mo	P	Cu	S
0.08	0.8	1.0	10.5-13.5	0.6	0.075	0.50	0.04	0.04	0.03

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW							

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters		Packing
D (mm)	Current (A) (DC-)	single
2.0 x 1000	70-110	5

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175: Argon