KM-409Nb

Shielding Gas: Ar+1~2%O_2
Ar+1~2%CO_2

Classification

AWS A5.9/A5.9M ER409Nb

Applications and Features

(1) Weld metal is ferrite structure with 12%Cr-Nb.

(2) Additional Nb content in weld metal promotes the formation of ferrite and improves the corrosion resistance and strength at high temperature.

(3) It is suitable for welding car exhaust and muffler systems, such as AISI 409 stainless steel.

Welding Instruction

(1) Use Ar blend with 1~2%O_2 for high current, spray transfer welding .

(2) Use Ar blend with 1~2%CO_2 for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Nb
0.021	0.45	0.44	0.011	0.008	11.61	0.41

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2% O_2)

Tensile Strength MPa	Yield Strength MPa	Elongation %
490	370	25

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm) 0.9
Ar+1~2%CO_2	Amp	60~140
	Volt	15~21
Ar+1~2%O_2	Amp	170~260
	Volt	24~30

Diam.	15 kg Spool
0.9mm	KM4090915

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