

OK Autrod 409Nb

A ferritic stabilized stainless solid welding wire of 12% Cr and 0,4% Nb type. OK Autrod 409Nb is used for welding of similar steels in applications such as catalytic converters and mufflers.

Classifications Wire Electrode:	SFA/AWS A5.9:ER409Nb
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
PWHT 850°C (1562°F) 2h	250 MPa (36 ksi)	450 MPa (65 ksi)	15 %

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb
0.03	0.5	0.7	0.3	11.3	0.10	0.02	0.5

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (.040 in.)	80-190 A	16-24 V	2.9-8.4 m/min (114-331 in./min)	1.1-3.1 kg/h (2.4-6.8 lb/h)
1.2 mm (3/64 in.)	180-280 A	20-28 V	4.9-8.5 m/min (193-335 in./min)	2.6-4.5 kg/h (5.7-9.9 lb/h)