

## 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.

### Specifications

|                        |                                         |
|------------------------|-----------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.9 : ER409Nb                  |
| <b>Alloy Type</b>      | Ferritic stainless (12 % Cr - 0.4 % Nb) |
| <b>Shielding Gas</b>   | M11, M12, M21 (EN ISO 14175)            |

### 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<br>( 0.040 in. ) | 80-190 A  | 16-24 V | 2.9-8.4 m/min<br>( 114-331 in./min ) | 1.1-3.1 kg/h<br>( 2.4-6.8 lbs/h ) |
| 1.2 mm<br>( 0.047 in. ) | 180-280 A | 20-28 V | 4.9-8.5 m/min<br>( 193-335 in./min ) | 2.6-4.5 kg/h<br>( 5.7-9.9 lbs/h ) |