

## 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.

### Dane techniczne

|              |                        |
|--------------|------------------------|
| Klasyfikacje | SFA/AWS A5.9 : ER409Nb |
|--------------|------------------------|

|              |                                         |
|--------------|-----------------------------------------|
| Rodzaj stopu | Ferritic stainless (12 % Cr - 0.4 % Nb) |
| Gaz osonowy  | M11, M12, M21 (EN ISO 14175)            |

### Skład drutu %

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

### Dane wydajności stopiwa

| rednica | A         | V       | Prdko podawania drutu | Wydajno stopiwa |
|---------|-----------|---------|-----------------------|-----------------|
| 1.0 mm  | 80-190 A  | 16-24 V | 2.9-8.4 m/min         | 1.1-3.1 kg/h    |
| 1.2 mm  | 180-280 A | 20-28 V | 4.9-8.5 m/min         | 2.6-4.5 kg/h    |

### Parametry spawania

| rednica drutu |
|---------------|
| 0.9 mm        |