



## WB409NbT TIG WELDING WIRE

<b>Classification</b>	<b>AWS A5.9/A5.9M:</b> ER409Nb <b>ASME SFA-5.9:</b> ER409Nb									
<b>Product Description</b>	Solid TIG wire with a niobium stabilised, chromium enriched, ferritic microstructure for the welding of matching alloy stainless steels.									
<b>Application</b>	Suitable for welding and repairing automotive exhaust systems, manifolds, mufflers, catalytic converters and tubing. Used for welding 409 and 409Ti grade materials.									
<b>Wire Composition (Wt. %)</b>	C	Mn	Si	Cr	Ni	Mo	Cu	Nb		
	<b>Typical.</b>	0.04	0.62	0.48	11.5	0.40	0.30	0.04	0.55	
<b>max.</b>	0.08	0.80	1.00	13.5	0.60	0.50	0.75	0.75		

<b>Typical all weld metal mechanical properties</b>	Ultimate Tensile Strength	N/mm <sup>2</sup>	600
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	460
	Elongation on 4D	%	26

<b>Wire Dia. (mm)</b>		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	min.	-	-	-	-	60	80	100
	max.	-	-	-	-	120	140	180
<b>Volt Range (Volts)</b>	min.	-	-	-	-	-	-	-
	max.	-	-	-	-	-	-	-
<b>Packaging Information</b>								
<b>Kg Per Tube</b>		-	-	-	-	5.0	5.0	5.0
<b>Storage</b>	<b>Storage</b> It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
<b>Gases</b>	<b>Gas</b> Pure Argon  <b>Flow Rate</b> 12-14 L/min							

### Current Conditions DC- and Welding Positions

