

Select 409Cb

Description:

SELECT 409Cb is a composite metal cored electrode for gas-shielded arc welding. This electrode is intended for joining ferritic stainless steel sheet and thin gauge material where niobium (columbium) stabilization is preferred over titanium. The recommended shielding gas is 98% argon- 2% oxygen, with a suggested flow rate of 40-55 cfh, and a minimum dew point of - 40° F.

Classification:

- EC409Cb per ANSI/AWS A5.22, SFA 5.22.
- AWS A5.9:2006

Characteristics:

SELECT 409Cb is a premium, composite metal cored electrode for joining stainless steels of similar composition. The arc transfer is extremely smooth and stable, very quiet, with virtually no spatter emission. Weld deposit cosmetics are excellent: the bead is uniform with superb tie in. This electrode offers much more welder appeal than solid electrodes, with enhanced welding speed and the ability to handle poor fit up better. The deposited metal is ferritic stainless steel. Modern manufacturing techniques and equipment provide the highest level of consistency and performance in the marketplace.

Applications:

SELECT 409Cb is ideally suited to those applications involving the fabrication of automotive exhaust systems, and is primarily used in this area. Specific applications include the welding of catalytic converters, mufflers, manifolds, tubing and other exhaust system components.

Typical Deposit Composition:

<u>Wt%</u>	<u>C</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Si</u>	<u>Cr</u>	<u>Cb(Nb)</u>
	.02	.60	.010	.010	.58	11.60	.66

Suggested Parameters:

<u>Diam. (in.)</u>	<u>Optimum</u>			<u>Range</u>		
	<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>	<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>
.045"	255	410	25-26	180-330	240-600	22-28
.052"	300	350	24-25	220-460	220-620	23-30
1/16"	360	300	26	230-520	160-550	22-31

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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.