Select 409Cb

Stainless Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Increased level of columbium (Cb), also known as niobium (Nb), to prevent sensitization.
- Enhanced weldability on components with excessive surface contaminants/lubes.
- Metal cored construction inherently provides better welding performance compared to solid wires.
- Designed to weld exhaust system components of similar composition, ~12 wt% chromium (Cr).

CONFORMANCES

AWS A5.22	EC409Nb
ASME SFA 5.22	EC409Nb

DIAMETERS [in (mm)]

0.045 (1.2), 0.052 (1.3), 1/16 (1.6)

POSITIONS

SHIELDING GAS

Ar + 0.5-5% CO2, Ar + 0.5-3% O2
Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Cr	Cu	Mn	Mo	Nb	Ni	P	S	Si
Argon	0.02	11.6	0.03	0.57	<0.01	0.61	0.02	0.006	0.008	0.51

Revision: 4/5/2022

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RECOMMENDED WELDING PARAMETERS

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.035 (0.9 mm)	98% Ar/2% O2	Flat & Horizontal	315 (8.0)	150	20	1/2 (13)
0.045 (1.2 mm)	98% Ar/2% O2	Flat & Horizontal	280 (7.1)	200	20	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	350 (8.9)	220	21	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	400 (10.2)	250	23	5/8 (16)
		Flat & Horizontal	475 (12.1)	275	25	5/8 (16)
0.052 (1.3 mm)	98% Ar/2% O2	Flat & Horizontal	225 (5.7)	215	20	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	350 (8.9)	280	23	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	425 (10.8)	300	25	3/4 (19)
1/16 (1.6 mm)	98% Ar/2% O2	Flat & Horizontal	225 (5.7)	260	21	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	265 (6.7)	285	22	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	300 (7.6)	310	23	3/4 - 1 (19 - 25)
		Flat & Horizontal	350 (8.9)	335	25	3/4 - 1 (19 - 25)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*

PACKAGING [lbs [kgs]]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.

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