



SUPERINOX 409Nb

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 **E409Nb-16**

CLASSIFICATION:

ISO 3581-AB
ES409 Nb-26

KEY FEATURES:

- Rutile based coating
- Typical 12Cr-1Nb weld deposit
- Excellent arc stability
- Easy slag removal
- Fine uniform ripples
- Fine grained ferritic microstructure
- Resist corrosion, wear and scaling up to 900°C
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of ferritic stainless steels of type 405, 409, 409Ti, 410, 420 and 409M
- Overlay of carbon, low alloy steels
- Used in catalytic convertors, exhaust silencers, mufflers, manifolds, manifold elbows
- Manufacture of coach and BOXNCR wagon buildings for transporting iron ore in Indian railways
- Repair welding in sugar factory and mining field equipments
- Surfacing of sealing faces of gas, water and steam turbines with service temperatures of up to 450°C

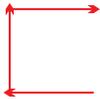
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Nb+Ta
0.07	0.7	0.8	12.9	0.9

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	PWHT: 770°C for 2 hrs	450 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-75	 AC (70 OCV)/DCEP REDRYING CONDITION: 300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	80-100		
4.0 x 350	110-140		

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.