

# M-409Cb

**AWS ER409Cb**

**FOR STAINLESS STEEL**

## Typical applications

Welding of ferrite stainless alloys of the 13%Cr types (AISI409)

It is suitable for automotive exhaust fabricators such as front pipe, bellows, flange.

## Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr	Nb+Ta
0.01	0.45	0.46	0.23	11.40	0.36

## Typical mechanical properties of all-weld-metal

Shielding Gas	T · S (850℃) N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	IV (J)
Ar+2%O <sub>2</sub>	30.6	56	—

## Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by