

DESCRIPTION

Executive 409Nb wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

The addition of Niobium in Executive 409Nb forms carbides to improve corrosion resistance, increase strength at high temperature, and promote the ferritic microstructure.

APPLICATIONS & FEATURES

Executive 409Nb is a copper coated wire primarily used for the welding of automotive stainless-steel exhaust systems and components. The coating technology creates a smooth and uniform copper layer on the wire surface that remarkably improves the weldability of the wire.

It is used in environments with continued heat cycling such as exhaust and furnace manufacturing and maintenance.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Nb
0.018	11.469	0.333	0.028	0.468	0.456	0.0222	0.0025	0.037	0.354

Tensile Strength: 67,000 PSI min **Yield Strength:** 50,500 PSI min **Elongation:** 26%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
		.062"	28-31			310-350
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet



CLASSIFICATION

AWS/SFA 5.9, Class **ER409Nb**

Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.