Thermanit 409 Cb

Solid wire, high-alloyed, stainless

Classifications		
EN ISO 14343-A	AWS A5.9	Mat. No.
G Z 13 Nb L	ER409Nb	≈1.4009

Characteristics and typical fields of application

Stainless. Scaling resistant up to 900 °C (1652 °F).
For joining and surfacing of similar and matching steels.
Exhaust systems.

Base materials

1.4006 – X12Cr13
1.4021 – X20 Cr13
1.4024 – X15Cr13
1.4512 – X2CrTi12 / X6CrTi12 – AISI 409

Typical analysis of solid wire (wt.-%)

	C	Si	Mn	Cr	NB
wt-%	≤ 0.05	0.6	0.6	11.5	≥ 10xC

Structure: Ferrite

Mechanical properties of all-weld metal

Heattreatment	Hardness HB30
aw	≈150
750 °C / 2 h (1382 °F)	≈130

Operating data

Polarity:	Shielding gas:	ø (mm)	Spool:
DC (+)	(EN ISO 14175) M12, M13	1.0 1.2	B300 B300

Welding instruction

Materials	Preheating	Postweld heat treatment
Matching / similar steels	According to wall thickness 200 – 300 °C (392 – 572 °F)	According to wall thickness 700 – 750 °C (1292 – 1382 °F)