

INCO-WELD® 409Cb is a ferritic stainless steel welding wire for the welding of type 409 and 409Ti base materials predominately in the automotive exhaust industry. Columbium has been added for preferential reaction with carbon preventing the formation of chromium carbides which may lead to a loss in corrosion resistance and strength.

*Typical Chemical Analysis (%)

Element	%	AWS Requirement
Carbon (C)	0.02	0.08 max
Chromium (Cr)	11.25	10.5-13.5
Nickel (Ni)	0.2	0.6 max
Molybdenum (Mo)	0.006	0.5 max
Manganese (Mn)	0.65	0.8 max
Silicon (Si)	0.5	1.0 max
Phosphorus (P)	0.002	0.04 max
Sulphur (S)	0.001	0.03 max
Columbium (Cb)	0.39	10 x C min/ 0.75 max
Copper (Cu)	0.06	0.75 max

*Typical Mechanical Properties

Tensile Strength	67,000 psi
Yield Strength	50,500 psi
Elongation	26%
Charpy V-Notch (RT)	

Approvals

AWS A5.9 ER409Cb
ASME SFA 5.9
Canadian Welding Bureau

*Typical GMAW welding Parameters

	Wire Diameter	Amperage	Voltage	Shielding
Short Circuit	.035"	80-160	14-22	90% He + 7½% Ar + 2½ O2
	.045"	110-220	15-23	90% He + 7½% Ar + 2½ O2
	.062"	130-250	16-23	90% He + 7½% Ar + 2½ O2
Spray Transfer	.035"	175-250	23-26	Ar + 2% O2
	.045"	225-325	24-29	Ar + 2% O2
	.062"	300-425	26-30	Ar + 2% O2

Ordering Information

GTAW		GMAW		SAW	
Diameter	Part Number	Diameter	Part Number	Diameter	Part Number
1/16	IA409CB062T	.035	IA409CB035M	3/32	
3/32	IA409CB093T	.045	IA409CB045M	1/8	
1/8	IA409CB125T			5/32	
10 lb. Tubes in 36" Lengths		30 lb. Spools / Wire Baskets		60 l.b Coils	

*All information listed is provided as typical values and may differ from actual results due to variations in weld procedures. C.P.G. disclaims any liability resulting from reliance on any of the above values.