

# Satin Glide® 409CB Stainless-Steel Welding Wire



Satin Glide® 409CB Stainless-Steel Welding Wire is a ferritic stainless-steel filler metal that is designed for joining and welding 409 stainless steel.

The high-temperature resistance of this stainless-steel welding wire means that it can be used in elevated temperature environments, achieving remarkably strong weld. It promotes excellent flow characteristics and produces smooth and clean welds with pleasing bead appearances while offering good penetration.

## Manufacturing Advantages

- All metal transfer modes of GMAW
- Robotic, mechanized, or semi-automatic welding
- Single and multi-pass weldments
- Dissimilar base metal welding
- Compatible with various ferritic stainless-steel base metals
- Modified with columbium for special heat-resistant welding on base metals
- Minimalized spatter during welding for cleaner welds with less post-weld cleaning

## Welding Positions

All position welding is possible when using the correct shielding gas blends, welding process, and welding parameters.

## Shielding Gas Blends

- Short Circuit Transfer: 90% Helium, 7-1/2% Argon, 2-1/2% CO<sub>2</sub>
- Spray Transfer: 95-98% Argon, 2-5% CO<sub>2</sub>
- Spray Transfer: 98-99% Argon, 1-2% O<sub>2</sub>
- Flow rate: 35-50 CFH

## Applications

- Agricultural Equipment
- Auto Body
- Automotive Exhaust
- General Fabrication
- Heavy Equipment
- Pipe Welding
- Pressure Vessels
- Railcars
- Shipbuilding
- Structures
- Trailers

## Specifications

Meets or Exceeds:

- AWS A5.9/A5.9M: ER409Nb
- ASME SFA-A5.9: ER409Nb
- ASME Section III Nuclear requirements

## Storage

Welding wire should be stored in a dry, enclosed environment and in its originally sealed package.

# Satin Glide® 409CB Stainless-Steel Welding Wire

## Typical Wire Chemistry Percentages (as required per AWS)

ASME SFA 5.9	AWS A5.9/ AWS A5.9M	Carbon	Cr	Ni	Mn	Si	OTHER
Yes	Yes	0.05 Max	11.00/12.00	0.50 Max	0.45/0.75	0.45/0.75	Cb 10xC Min/0.60



3602 North Perkins Road  
Stillwater, OK 74075  
Customer Service: 1-800-777-1618  
[www.NSARC.com](http://www.NSARC.com)