



!!!! WARNING !!!!



WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.

BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND MATERIAL SAFETY DATA SHEET (MSDS).

THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.

DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.

SEE THE PRODUCT WARNING LABEL AND MSDS FOR COMPLETE WARNING INFORMATION.



CROWN ALLOYS COMPANY

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Crown ER 409Cb

Ferritic Stainless Steel Welding Wire - MIG and TIG

Typical Applications:

Crown ER 409Cb is a ferritic stainless steel welding wire. The addition of columbium results in a preferential reaction with carbon, which will prevent the chromium from forming carbides. This improves corrosion resistance, increase strength at elevated temperatures, and promotes a ferritic microstructure. **Crown ER 409Cb** is most often used to weld 409 or 409Ti base stainless steels. It is used primarily in the automotive industry for welding catalytic converters and other parts of the exhaust system.

Specifications:

AWS A5.9/A5.9M
ER 409Cb

- | | |
|--------------------|------------------|
| ➤ Tensile Strength | up to 67,000 PSI |
| ➤ Yield Strength | up to 50,500 PSI |
| ➤ Elongation | up to 26% |

Procedure:

Clean weld area thoroughly. Vee out where necessary.

- **For MIG (Gas Metal Arc Welding)** Use DC reverse polarity (DCEP). Use a shielding gas of 98/99% Argon plus 2/1% oxygen. Or use 97% Argon plus 3% CO₂. Gas flow should be 25 to 45 CFH.

	Amperage	Volts
.035 x 30#	155-185	28-30
.045 x 30#	175-225	29-32

- **For TIG (Gas Tungsten Arc Welding)** Use DC straight polarity (DCEN). Use 100% Argon shielding gas. Gas flow should be 25 to 35 CFH.

Sizes:

(MIG)
.035 } All sizes are available in 2# and 8" and 30# spools.
.045 }

(TIG):
.045 x 36"
1/16 x 36"
3/32 x 36"
1/8 x 36"