



# 2209T-1 Flux Cored Wire

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
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WASHINGTON ALLOY'S Quality  
Management System is  
Certified to **ISO 9001:2008**  
Cert # 05-R0925



## ALLOY DESCRIPTION AND APPLICATION;

2209T-1 duplex stainless steel flux cored electrodes are used to weld 22% chromium duplex stainless steel such as 2205, 2209, 2304 and other proprietary duplex stainless steels. It has a smooth running arc that deposits very high tensile strength, with resistance to stress, corrosion, cracking and pitting... 2209 may also be a good choice when welding Duplex stainless such as 2553 to carbon steels or other grades of stainless.

## TYPICAL WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO <sub>2</sub> (cfh)
0.045	215-450	140-220	25-30	1/2-1"	35-50
1/16"	175-315	190-310	28-31	5/8-1"	35-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

## TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

Carbon	0.04	Molybdenum	2.50-4.00
Manganese	0.50-2.0	Phosphorus	0.04
Silicon	1.00	Sulfur	0.03
Chromium	21.0-24.0	Nitrogen	0.08-0.20
Nickel	7.50-10.0	Copper	0.50
	Elongation	20%	
	Tensile Strength (psi)	100,000	

Iron balance and all single values are maximum percentages

**AVAILABLE SIZES:** TSF 2209T-1 = .045, 1/16"

Other sizes available – please inquire

**SPECIFICATIONS;** ANSI/AWS A5.22 E2209T0-1  
ASME SFA 5.22 E2209T0-1  
ASME F - 6

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