



WASHINGTON ALLOY'S Quality Management System is Certified to ISO 9001:2008 Cert # 05-R0925

409T-1 Flux Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

409T-1 stainless steel flux cored electrodes are used to weld base metals of similar composition. The Composition of this weld metal is 12 % Cr with Ti as a stabilizer which produces a ferritic microstructure.

TYPICAL WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO ₂ (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

Deposition rate lbs/hr: .045" = 6-8 lbs, 1/16" = 7-11lbs

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

CHEMISTRY (%) for Undiluted WELD METAL & PROPERTIES (AWS Requirements)

Carbon	0.10	Molybdenum	0.50
Manganese	0.80	Phosphorus	0.04
Silicon	1.00	Sulfur	0.03
Chromium	10.5-13.5	Titanium	10 x C min., 1.5 max.
Nickel	0.60	Copper	0.50
	Elongation	15% min.	
	Tensile Strength (psi)	65,000 min.	

Iron balance and all single values are maximum percentages unless noted

AVAILABLE SIZES: TSF 409T-1 = .045,
Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.22 E409T0-1/-4 or E409T1-1/-4
ASME SFA 5.22 E409T0-1/-4 or E409T1-1/-4
ASME F - 6

T0 = flat and horizontal; T1 = all position; -1 is for 100% CO₂; -4 = 75-80 Ar /CO₂

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