



Supplier of Welding Alloys

## Stainless Steel Flux Cored Wire

### Oxford Alloy® 2209T-1

**SPECIFICATIONS**

AWS 5.22  
ASME SFA 5.22

**CLASSIFICATIONS**

AWS E2209T1-1/T1-4

**DESCRIPTION / APPLICATION**

Oxford Alloy E2209T1-1/T1-4 is an all position duplex stainless steel flux cored wire. This flux cored wire is used for welding ferritic-austenitic (duplex) steels, especially those with high resistance to stress corrosion cracking. It is designed for the welding of 22Cr-5Ni-2Mo-0.15N duplex stainless steel (UNS S31803), commonly known as 2205. This flux cored wire is also used for welding on stainless structures where a particularly high strength is required. Oxford Alloy E2209T1-1/T1-4 was developed for all position welding. This flux cored wire will deposit welds at substantially higher welding currents than other stainless steel flux cored wires, resulting in a higher deposition rate. The slag is self-peeling and minimizes cleanup. Oxford Alloy E2209T1-1/T1-4 was formulated for use with 75% Argon/25% CO<sub>2</sub> shielding gas; however, straight CO<sub>2</sub> may also be used. The 75/25 mixture will produce a smooth arc with virtually no spatter and slightly higher yield and tensile strengths than CO<sub>2</sub>. The mechanical properties and deposit analysis will meet AWS 5.22 specifications with either gas.

AWS Chemical Composition						
C	Mn	Si	Cr	Ni	Mo	P
0.04 max	0.5-2.0	1.0 max	21.0-24.0	7.5-10.0	2.5-4.0	0.04 max
S	Cu	N				
0.03 max	0.5 max	0.08-2.0				

**TYPICAL MECHANICAL PROPERTIES**

Tensile strength: 118,900 psi 820 MPa

Yield strength: 99,325 psi 685 MPa

Elongation: 27%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

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