



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

250HT Carbon Steel Flux-Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
825 Groves Street
Lowell, NC 28098
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION:

Washington Alloy 250 HT is for building-up mild and low alloy steel parts to within 3/16"-3/8" of their original size. Weld deposits will be part ferritic - part martensitic in structure. Our 250 HT weld deposits have good compressive strength and resistance to plastic deformation. Weld deposits are easily machined in the "as welded" position. An excellent underlayment prior to hardsurfacing Underlaying for Hardsurfacing, such as Steel mill Wobblers and Pods, Shafting, Small Rolls, Pump Parts and many more items.

IMPACT RESISTANCE ; Very Good ABRASION RESISTANCE ; Poor
COMPRESSION ; Good

TYPICAL FCAW WELDING PROCEDURES; DCEP OPTIMUM IN BOLD (FLAT)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO ₂ (cfh)
0.045	195- 300 -475	125- 205 -265	20- 24 -28	1/2-1"	35-45
0.052	150- 270 -320	140- 255 -320	22- 25 -29	1/2-1"	40-50
1/16"	135- 240 -240	250- 310 -350	23- 25 -29	3/4-1.75"	40-50

Procedures may vary with change in position, base metals, filler metals, equipment, and other changes.
1-2 VOLTS LOWER USED WITH MIXED GAS

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

Carbon	0.057	Chromium	1.29
Manganese	1.17	Iron	Balance
Silicon	0.51	Molybdenum	0.01
Phosphorus	0.012		
Sulfur	0.005		
Hardness Rockwell C = 20-26			



AVAILABLE SIZES: THF 250HT= Spools of .045, 1/16"

Other sizes available – please inquire

WA. ALLOY CO.

10-22 DC

SPECIFICATIONS; Internal , JIS Z 3326-2007 YF2A-C-250

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