

502

SPECIAL ELECTRODE WITH NODULAR-MARTENSITIC TYPE FILLER METAL FOR CORROSION RESISTANT CHROMIUM STEEL UP TO 600°C.

CLASSIFICATION A.W.S: E-502-16

APPLICATIONS: This welding rod has been specially formulated to weld oil industry pipelines and parts made out of AISI-501 and AISI-502 steel with a Chromium content between 4 and 6 % and 0.5% Molybdenum.

CHARACTERISTICS AND PROCEDURE: The welds resulting from this welding rod have good corrosion resistance at high temperatures. This electrode can be used in all positions. The slag is easily removed. Clean the base metal to remove dirt, scales, grease and rust. To prevent the joint area from hardening, it is necessary to use preheating and postweld heating. Care should be taken not to let the temperature drop below 200° C during the whole process. Keep the arc short and tilt the welding rod slightly in the same direction as the weld. Let the slag stand over the filler metal till it all cools down. Avoid overheating the base metal. Make sure you remove the slag between one pass and the next.

TENSILE RESISTANCE:	6,678 KG./CM2 (95,000 PSI) con tratamiento térmico.
ELONGATION:	30 %
POSITIONS:	ALL
CURERNT:	AC OR DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	Si	Cr	Mo	2.38 mm - 3/32"	50-70
0.06	0.55	1.0	5.10	0.56	3.25 mm - 1/8"	80-100
					4.0 mm - 5/32"	110-130
					5.0 mm - 3/16"	140-170