

## AI-0202

### Specifications

**AWS/ASME 11C SFA 5.4 E 502-15, 16**

### Description and Applications

**AI-0202** is an electrode used for welding of types 501 and 502 straight chromium steels. Principle applications are in the fabrication of equipment for the oil and chemical industries where service conditions require resistance to corrosion and oxidation at elevated temperatures (up to 650°C). Type 502 stainless steel is an air hardening material and when welded with **AI-0202** electrodes, a preheat and postheat treatment is recommended.

### Typical Weldmetal Analysis

C	Mn	Si	Cr	Fe
0.10	0.70	0.50	5.00	Bal

### Mechanical Properties of Weldmetal

	As Welded
Tensile Strength:	480MPa
Yield Strength (0.2%):	250MPa
Elongation:	30%(4D)
Charpy V:	100J (20°C)
Properties after Heat Treatment:	850°C (2 hours)

### Welding Parameters

Diameter (mm)	Current type	Amps
2.5	DC /AC	50-90
3.2	DC /AC	80-120
4.0	DC /AC	110-160

Redry 300°C/1 Hour Minimum

### Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up.

### Disclaimer

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