

ROCKWELD 502



Rockweld 502 is a basic type electrode for creep resisting steels and cast steels with 5% Cr and 0.5% Mo operating at temperatures up to 550°C. Good weldability in all positions. Low spatter loss. Smooth bead appearance. Good slag removal.

CLASSIFICATIONS

AWS	A5.5	E8015-B6 (A5.4 E502-15)
DIN	1599	E CrMo 5 B 42

CHEMICAL ANALYSIS

% Carbon	0.060	% Molybdenum	0.500
% Manganese	0.900	% Sulphur	<0.02
% Silicon	0.300	% Phosphorous	<0.02
% Chromium	5.000		

**TYPICAL MECHANICAL PROPERTIES
(ALL WELD METAL IN THE AS WELDED
CONDITION)**

Tensile Strength	600 - 700 MPa
Yield Strength	>500 MPa
% Elongation on 5d	> 18%
Impact Strength at 20°C	> 100J

PACKING DATA

Diameter (mm)	Amps	Item Number	Pack Mass (Kg)
2.50	60-90	078-316	3 x 5
3.20	85-130	078-318	3 x 5
4.00	140-180	078-320	3 x 5

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