K-502-15

AWS E502-15
JIS DT2516
KS DT2516

FOR HEAT-RESISTING STEEL

Typical applications

Welding of heat treated high tensile strength steel for aircraft parts, such as SAE 4130.
Welding of 5%Cr-0.5%Mo steel used in oil refining and chemical industries.

Coating

Low hydrogen type.

Characteristics on Usage

① Preheat at 250~350℃ and postheat treat at 730~760℃ because of high self-hardening properties of the deposited weld metal.
② Redry the electrode at 300~350℃ for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Mo
0.08	0.35	0.84	5.25	0.55

Typical mechanical properties of all-weld-metal

Y · P N/mm²{kgf/mm²}	T · S N/mm²{kgf/mm²}	El (%)	PWHT
450 {46}	580 {59}	31	850℃×1hr. S·R

Sizes available and recommended currents (DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp.	F	50~90	75~115	120~160	160~210	210~260
	V&OH	50~80	70~110	90~130	–	–

Welding positions

Approved by