

COR™STAIN 502 FC

DESCRIPTION

COR™STAIN 502 FC is an AISI 5%Cr-0.5%Mo steel designed for heat resistance. This wire is available in metal core or flux core.

APPLICATIONS

502 FC is used to weld chrome-moly pipe and tube, and other similar base materials. It is also used as an underlay for harder heat resisting filler metals.

PROCEDURE

502 FC is an air-hardening alloy: Maintain a preheat/interpass temperature of at least 350°F. Post heat according to base material. Recommended post heat is at 1575°F for one hour per inch thickness.

WELDING PARAMETERS

Type	Size	Volts	Amps	Shielding Gas	Stickout
MC-G	.045"	18-21	150-200	CO ₂ or Ar-CO ₂ mixture	0.5"
FC-G	.045"	24-28	150-200	CO ₂ or Ar-CO ₂ mixture	0.5"
FC-G	1/16"	26-30	200-300	CO ₂ or Ar-CO ₂ mixture	0.75"

MECHANICAL PROPERTIES

Hardness: 32-37 Rc

CLASSIFICATION

AWS A5.22, Class E502T0-X