



PRODUCT DATA SHEET

Stainless Steel Bare Wire

Weld Process: Used for Mig, Tig, & Submerged Arc

Alloy: 502 Class: ER502 See ER80S-B6 AWS A.5.28

Conforms to Certification: AWS A5.9 / ASME SFA 5.9

Alloy: DM502



PRODUCT

DATA SHEET

AWS Chemical Composition Requirements

C = 0.10 max	P = 0.03 max
Cr = 4.6 – 6.0	S = 0.03 max
Ni = 0.60 max	Mo = 0.45 – 0.65
Mn = 0.60 max	Cu = 0.75 max
Si = 0.50 max	

Deposited Chemical Composition % (Typical)

C = 0.07	Si = 0.36	Mn = 0.44
P = 0.009	S = 0.006	Cr = 5.45
Mo = 0.55		

Deposited All Weld Metal Properties

Data is typical for ER502 weld metal deposited by mig using argon + 2% oxygen and tig using 100% argon as the shielding gas. Data on sub-arc is dependent on the type of flux used.

Mechanical Properties (R.T.)

Yield Strength	60,500psi
Tensile Strength	78,500psi
Elongation	32%

Application

ER502 is used for welding 502 base materials, frequently tube or pipe. Preheating and post-weld heat treatment is required.

Recommended Welding Parameters

GMAW “Mig Process”

Reversed Polarity

Wire Diameter	Wire Feed	Amps	Volts	Shielding Gas	Gas CFH
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Short Arc Welding

.030	13-26	40-120	16-20	Argon+2% O ₂	25
.035	13-26	60-140	16-22	Argon+2% O ₂	25

Spray Arc Welding

.035	20-39	140-220	24-29	Argon+2% O ₂	38
.045	16-30	160-260	25-30	Argon+2% O ₂	38
1/16	10-16	230-350	27-31	Argon+2% O ₂	38

GTAW “Tig Process”

Wire Diameter	Amps DCEN	Voltage	Gases
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.035	60-90	12-15	Argon 100%
.045	80-110	13-16	Argon 100%
1/16	90-130	14-16	Argon 100%
3/32	120-175	15-20	Argon 100%

Note: Parameters for tig welding are dependent upon plate thickness and welding position.

Other shielding Gases may be used for Mig and Tig welding. Shielding gases are chosen taking Quality, Cost, and Operability into consideration

Submerged Arc Welding

Reverse Polarity is suggested

Wire Diameter	Amps	Volts
3/32	250-450	28-32
1/8	300-500	29-34
5/32	400-600	30-35
3/16	500-700	30-35

Both Agglomerated and fused fluxes can be used for submerged arc welding.

Note: The chemical composition of the flux mainly affects the chemistry of the weld metal and consequently its corrosion resistance and Mechanical properties.