



# A002

天津市金桥焊材集团有限公司  
Tianjin Jinqiao Welding Materials Group Co., Ltd.

GB/T 983 E308L-16

AWS A5.4 E308L-16

## Introduction:

A002 is a kind of Titanium calcium type coating with ultra-low carbon Cr19Ni10 stainless steel electrode. Carbon content of deposited metal is less than or equal to 0.04%. The intergranular corrosion resistance is good. Excellent welding performance and heat resistance, high strength coating, the porosity resistance is good. AC/DC both can be applied.

## Uses:

Used for welding ultra-low-carbon Cr19Ni10 stainless steel structures, and also used for 06Cr18Ni11Ti corrosion-resistant stainless steel structures whose working temperature is lower than 300° C. Mainly used in the manufacture of synthetic fiber, chemical fertilizer, oil and other equipments

## Chemical Composition (%)

Chemical Composition	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Guarantee Value	≤0.04	0.50 ~ 2.50	≤1.00	≤0.030	≤0.040	18.0-21.0	9.0-12.0	≤0.75	≤0.75
General Result	0.024	1.30	0.62	0.008	0.020	19.90	9.80	0.040	0.035

## Mechanical Properties of Deposited Metal

Test Item	Rm(N/mm <sup>2</sup> )	A (%)
Guarantee Value	≥510	≥30
General Result	580	45

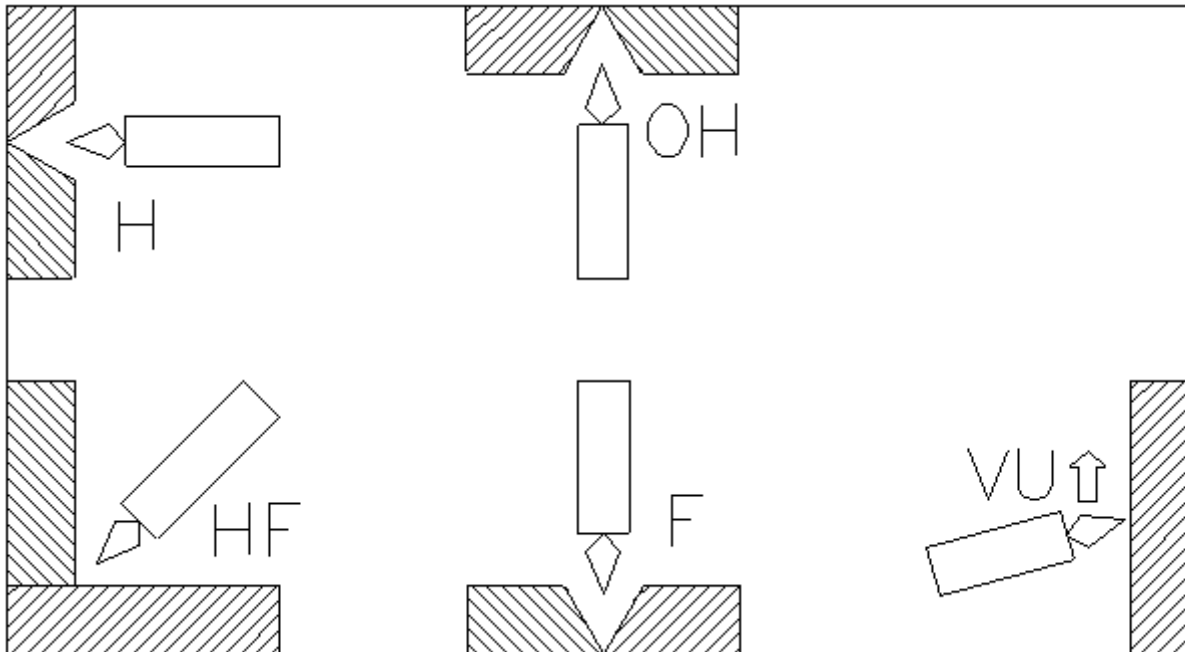
## Reference Current ((AC OR DC<sup>+</sup>))

Diameter (mm)	φ2.0	φ2.5	φ3.2	φ4.0	φ5.0
Welding Current (Amps)	40~80	50~100	70~130	100~160	140~200

## Notes:

- 1.The electrode must be preheated at the temperature of 300° C for 1 hour. Preheat the rod whenever it is used.
- 2.Preferred DC power supply, electric current should not be high.

## Welding Positions:



CCS CERTIFICATE



LR CERTIFICATE



BV CERTIFICATE



ABS CERTIFICATE



DNV CERTIFICATE