



NexaWeld®

J-502

CLASSIFICATION

AWS A/SFA 5.4 E-309L

A LOW CARBON STAINLESS STEEL ELECTRODE For Buffer Layer and Dissimilar Metal

DESCRIPTION

An all position SS electrode giving 25/12 Cr/Ni deposit with excellent resistance to chemical corrosion and heat resistance. Gives stable arc, low spatter, smooth weld profile, easily removable slag. The weld deposit is of radiographic quality and withstand temperature upto 1100°C.

APPLICATIONS

Suitable for welding 25/12 stainless steel grades like AISI 309. Welding stainless steel to carbon steel and low alloy steel, for overlaying on mild steel, welding clad steels.

CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	S	P
0.04 max	1.0-2.5	0.90 max	22.0-25.0	12.0-14.0	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES

UTS, MPa	EL%	Ferrite No.
520-600	30-40	10-15

RECOMMENDED CURRENT CHARACTERISTICS : AC (70 OCV) DC (+)

SIZE mm DxL	2.50x350	3.15x350	4.00x350	5.00x350
CURRENT (Amps)	50-75	80-100	110-140	150-180

PRECAUTIONS

Redrying Condition : 250°c for one hour before use.

Packing Specification - **Supplied in 2 Kgs x 5 Pkts = 10 Kgs**