



J-504

CLASSIFICATION

AWS A/SFA 5.4 E-310-16

ELECTRODE FOR HIGH TEMPERATURE OXIDATION RESISTANT

DESCRIPTION

J-504 is a rutile coated electrode to deposit 25 Cr / 20 Ni. The electrode is specially designed for oxidation and scaling resistance at elevated temperatures at 1200°C with excellent weld metal finish, low spatter and easily removable slag.

APPLICATIONS

Suitable for welding AISI 310 type steel, clad steel of clad steels. high temperature furnace parts, gas turbine, combustion chambers, hardenable steels and dissimilar steels etc.

CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	S	P
0.08-0.12	1.0-2.5	0.3-0.7	25.0-28.0	20.0-22.5	0.03 max	0.04 max

ALL WELD MECHANICAL PROPERTIES

UTS, MPa	EL%
560-660	30 min

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**