



J-505

CLASSIFICATION

AWS A/SFA 5.4 E-312-16

ELECTRODE FOR HIGH STRENGTH STAINLESS STEEL For Dissimilar Joining

DESCRIPTION

J-505 is a rutile type stainless steel electrode, specially designed for welding similar and dissimilar steels. Electrode produces crack free high strength joint in carbon steel, low alloy steel, stainless steel including difficult to weld steels.

APPLICATIONS

- * Dissimilar joints between stainless steel & high carbon steels and unknown steel.
- * Welding difficult to weld steels ex, high c hardenable tool, die and spring steels, 13 Mn steels, free cutting steels, high temperature steels, cast steels
- * Suitable for problematic steels with higher strength such as pressing dies, trimming tools, armor plates.

CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	S	P
0.15 max	0.7-2.0	0.3-0.9	28.0-32.0	8.0-10.5	0.03 max	0.03 max

ALL WELD MECHANICAL PROPERTIES

UTS, MPa	EL%
700-860	22v 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