



J-507

CLASSIFICATION

AWS A/SFA 5.4 E-430-15

FERRITIC STAINLESS STEEL ELECTRODE For Joining and Surfacing Application

DESCRIPTION

J-507 is a basic coated low hydrogen electrode depositing 17 Cr weld metal which is highly resistant to corrosion, oxidation & scaling up to 900°C.

APPLICATIONS

The electrode is suitable for welding AISI 430 and similar composition casting, surfacing carbon, low alloy and chromium steels and surfacing of valves impellers, turbine blades etc.

CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni	Mo	S	P
0.10 max	1.0 max	0.15-0.60	15.0-18.0	0.6 max	0.75 max	0.03 max	0.04 max

ALL WELD MECHANICAL PROPERTIES

UTS, MPa	EL%
490 min	20 min

RECOMMENDED CURRENT CHARACTERISTICS : AC/DC (+)

SIZE mm DxL	2.50x350	3.15x350	4.00x350
CURRENT (Amps)	60-90	90-130	130-160

PRECAUTIONS

Redrying Condition : 300°c for one hour before use.
PWHT : 780°C for two hours.

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