



J-508

CLASSIFICATION

AWS A/SFA 5.4 E-307-16

RUTILE TYPE STAINLESS STEEL ELECTRODE

DESCRIPTION

J-508 is a rutile type stainless steel electrode producing 20.0 Cr, 10.0 Ni, 6 Mn, 1.0 Mo. Electrode is used for joining as well as hard facing. Weld deposit work hardens under impact, slag is easy to remove and the weld bead is smooth and shiny.

APPLICATIONS

The electrode is suitable for joining austenitic stainless steel of similar composition, joining austenitic Mn to itself & to mild steel, also for giving buffer layer and build up layers on crushers hammers, pulverisers plough and rolls, dipper teeths, crusher hammers etc.

CHEMICAL COMPOSITION %

C	Mn	Si	Cr	Ni
0.12 max	5.00-8.00	0.90 max	17-20	7.0-10.00

ALL WELD MECHANICAL PROPERTIES

HARDNESS (INITIAL) BHN	WORK HARDENS BHN
200-250	500-550

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

SIZE mm	3.15	4.00	5.00
CURRENT (Amps)	90-130	140-190	190-240

PRECAUTIONS

Redrying Condition : 300°c for one hour before use.
Use Short Arc During Welding

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