



J506Fe

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Introduction:

J506Fe is a low-hydrogen-potassium-iron-powder coated carbon steel electrode. The iron powder in the coating increases the deposited rate. It has very good usability that enables it to have stable arc, low-spatter, removal of slag is easy and performs all-position welding. The deposited metal has good mechanical properties that offer very good low temperature toughness.

Uses:

It is applied in welding structures made of carbon steel and low-alloy steel such as 16Mn.

Chemical Composition (%)

Chemical Composition	C	Mn	Si	S	P	Ni	Cr	Mo	V
Guarantee Value	≤0.15	≤1.60	≤0.90	≤0.035	≤0.035	≤0.30	≤0.20	≤0.30	≤0.08
General Result	0.077	1.07	0.54	0.005	0.014	0.011	0.028	0.007	0.016

Mechanical Properties of Deposited Metal

Test Item	Rm (N/mm ²)	Rel (N/mm ²)	A (%)	KV2(J) -30°C
Guarantee Value	≥490	≥400	≥20	≥27
General Result	550	455	32	156

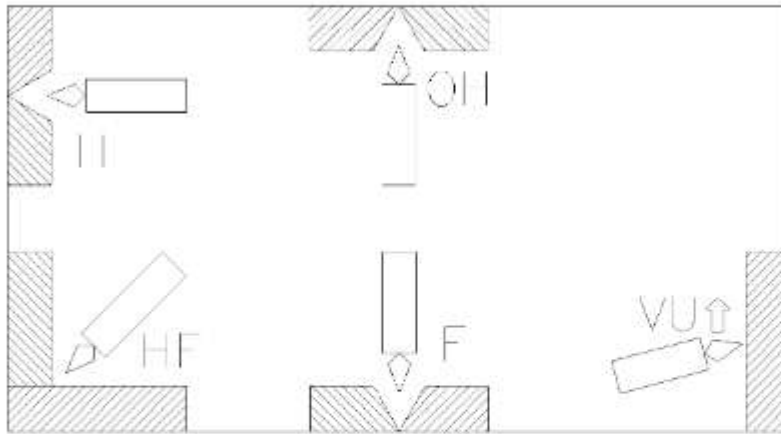
Reference Current (DC)

Diameter	φ2.5	φ3.2	φ4.0	φ5.0
Amperage	60 ~ 100	80 ~ 140	110 ~ 210	160 ~ 230

Notes:

1. The electrode must be preheated at the temperature of 350° C for 1 hour. Preheat the rod whenever it is used.
2. The impurities such as rust, oil stains and moisture must be cleared off of the work piece.
3. Short arc is required to perform welding. Narrow weld path is preferred.

Welding Positions:



CCS CERTIFICATE



LR CERTIFICATE



ABS CERTIFICATE



GL CERTIFICATE