

Product Data Sheet



BRAND NAME VJ ER308

AWS/ASME Class ER308

SPECIFICATION SFA A5.9

Features and Applications :

VJ ER308 is a solid wire for MIG & TIG welding available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality welds.

It is ideally suited for welding of stainless steels of similar composition like 304 and equivalents, for overlays, surfacing, and repairing castings of similar materials.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.08	Mn	1.20
Cr	20.00	Si	0.30-0.65
Ni	10.00	S	0.03
Mo	0.75	P	0.03
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	580
El (%)	38

DIMENSIONS:

Dimension (mm)	
GMAW	GTAW
0.80	1.6
1.20	2.0
1.60	2.4
	3.2

GMAW CURRENT : DC (+)	SHIELDING GAS: ARGON
GTAW CURRENT : DCEN	SHIELDING GAS: ARGON

PACKING :

GTAW : 5 kg wire put in a plastic container. Identification AWS code is punched on side of wire.

GMAW :The wire can be supplied in plastic spool packed in a cardboard box weighing 15.0 kg.

WELDING POSITION:

