

# Product Data Sheet



**BRAND NAME** VJ ER312

**AWS/ASME Class** ER312

**SPECIFICATION** SFA A5.9

## Features and Applications :

VJ ER312 is a solid wire for MIG & TIG welding, available in bright finish. It gives radiographic quality weld deposit. The weld metal is highly resistant to crack and fissures. It is ideally suited for weld cast alloys of similar composition. The typical application include, welding dissimilar metals, unknown metals.

## CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.11	Mn	1.70
Cr	29.00	Si	0.50
Ni	9.5	S	0.013
Mo	0.75	P	0.013
Cu	0.75		

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	730
El (%)	25

## DIMENSIONS:

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

<b>GMAW CURRENT</b> : DC (+)	<b>SHIELDING GAS:</b> ARGON
<b>GTAW CURRENT</b> : DCEN	<b>SHIELDING GAS:</b> 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:

