

Product Data Sheet



BRAND NAME VJ ERNi-1

AWS/ASME Class ERNi-1

SPECIFICATION SFA A5.14

Features and Applications :

VJ ERNi-1 ensures smooth flow, stable arc, and spatter-free welding, delivering radiographic-quality welds. It provides enhanced corrosion resistance in caustic soda service and marine environments, ideal for welding pure nickel alloys..

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Ni	96.00
Mn	0.44	Ti	2.60
Si	0.20	S	0.01
P	0.01		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
UTS (MPa)	440
El (%)	25

DIMENSIONS:

Dimension (mm)	
GTAW (Dia)	Length (mm)
1.6	1000
2.0	1000
2.4	1000
3.2	1000

GTAW CURRENT : DCEN

SHIELDING GAS: ARGON

PACKING :

GTAW : 5 kg wire put in an air-tight polythene bag and finally packed in a plastic container. Identification AWS code is punched on side of wire.

WELDING POSITION:

