

Product Data Sheet



BRAND NAME VJ ERNiCrCoMo-1

AWS/ASME Class ERNiCrCoMo-1

SPECIFICATION SFA A5.14

Features and Applications :

VJ ERNiCrCoMo-1 is a solid wire for GTAW available welding of nickel-chromium-cobalt-molybdenum alloys. It is also suitable for cast heat-resistant alloys and dissimilar metal welding, ensuring superior performance in high-temperature applications up to 1150°C. especially when welding on base metal of Nickel-Iron- Chromium alloys. Specially recommended for welding furnace heating elements, reformer tubes etc

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.06	Cr	21.800
Mn	0.20	Mo	9.05
Fe	0.75	Al	1.25
Co	12.45	Ni	Bal.

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
UTS (MPa)	630
El (%)	25

DIMENSIONS:

GTAW	
Dia (mm)	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:

