

# Product Data Sheet

**BRAND NAME** VJ ERNiCrMo-14

**AWS/ASME Class** ERNiCrMo-14

**SPECIFICATION** SFA A5.14



## Features and Applications :

VJ ERNiCrMo-14 is a solid wire for TIG welding, designed for severe corrosion environments requiring resistance to reducing, oxidizing and pitting conditions. It is suitable for welding wrought and cast nickel alloys (ASTM B574, B575, B619, B622, B628, UNS N06686) to itself, steel, other nickel-based alloys, and for steel cladding.

## CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.01	Cr	19.0-23.0
Mn	1.00	Mo	15.0-17.0
Fe	5.00	W	3.0-4.0
Si	0.08	Ni	Rem.
P	0.02	Cu	0.50
S	0.02	Al	0.50

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
UTS (MPa)	760
El (%)	35

## DIMENSIONS:

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

<b>GTAW CURRENT</b> : DCEN	<b>SHIELDING GAS:</b> ARGON
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## 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:

