

Product Data Sheet



BRAND NAME VJ ERNiCrMo-3

AWS/ASME Class ERNiCrMo-3

SPECIFICATION SFA A5.14

Features and Applications :

VJ ERNiCrMo-3 is a solid wire for TIG welding. It is ideal for welding Ni-Cr-Mo alloys to themselves and to steel, and for surfacing steel. The wires are used in applications where the temperature ranges from cryogenic to 540°C. It is also suitable for welding Ni base alloys to steel. Ideal for valves, valve seats, impellers, guide points, bushing.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.09	Cr	21.90
Mn	0.05	Mo	8.70
Fe	0.62	Nb+Ta	3.65
Si	0.12	Ni	Bal.

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As weld	
Properties	Typical
UTS (MPa)	770
EI (%)	35

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:

