

Product Data Sheet

Hard Facing Electrode



BRAND NAME VJ CAST

AWS/ASME Class Est

SPECIFICATION SFA 5.15

Features and Applications :

VJ CAST low heat input electrode for welding cast iron where machinability is not prime consideration. The electrode should be preferred when a strong and rigid joints is to be obtained between two cast iron parts and also suitable for joining difficults to weld cast iron.joining cast iron to carbon or low alloy steel for reclamation and repair of foundry defects, damaged or cracked casting.Also suitable for welding rusty, corroded,dirty,greasy and oil soaked casting.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	1.60
Mn	1.20
Si	0.60
S	0.03
Cu	0.80
Fe	Rem
Ni	48.50

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing(Kgs)
	Min	Max	Qty / Pkt
Dia x Length			
3.15 x 450	100	140	2.0
4.00 x 450	140	180	2.0
5.00 x 450	180	220	2.0

CURRENT : AC/DC (+)

OTHER DATA:

Redrying: The electrodes should be redried at 300°C for 1 hour.
Welding Technique Use stringer bead technique and avoid high current. Use Shorts arc.
For more information, please feel free to contact us.



Manufactured by :
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