

Product Data Sheet



BRAND NAME VJ 9018B9

AWS/ASME Class E9018-B9

SPECIFICATION SFA A5.5

Features and Applications :

VJ 9018B9 is a high-performance basic coated electrode designed for welding 9Cr-1Mo-V-Nb weld deposits. It offers excellent strength, creep resistance up to 600°C, and improved resistance to strain, corrosion, and oxidation due to the addition of Vanadium (V) and Niobium (Nb). Ideal for welding turbine rotors, thermoelectric power plants, and petrochemical plants.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.10
Mn	0.45
Si	0.18
Ni	0.60
V	0.20
Cu	0.010
Cr	9.00
Mo	1.00

MECHANICAL PROPERTIES OF WELD METAL

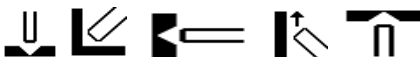
All Weld Metal - PWHT - 760°C- 2 Hr	
Properties	Typical
YS (MPa)	575
UTS (MPa)	670
El (%)	21

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	70	100	150
3.15 x 450	100	130	100
4.00 x 450	140	180	70
5.00 x 450	180	240	45

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 2 hour.