

Product Data Sheet



BRAND NAME VJ III

Hard Facing Electrode

Features and Applications :

A medium coated rutile type hard facing electrode which gives air hardenng type weld metal. The weld metal is non-machinable and has excellent resistant to corrosion and impact. Suitable for welding of Crusher hammers, Crane Wheels, Conveyor buckets, Mixer Blades, Dipper teeth and Cane cutting Knives etc..

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.75
Mn	1.00
Si	0.40
Mo	0.5-0.8
Cr	6.0-7.5
V	0.4-0.8

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
THREE LAYER DEPOSIT -AS WELDED (BHN)	550

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing(Kgs)
	Min	Max	Qty / Pkt
3.15 x 450	100	140	3.0
4.00 x 450	140	180	3.0
5.00 x 450	180	220	3.0

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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