

Product Data Sheet



BRAND NAME VJ I

Hard Facing Electrode

Features and Applications :

VJ I is a medium coated rutile type hard facing electrode. It desoposite air hardening type of weld metal which is machinable. Suitable for welding of gears,shafts,gear wheels,hammers, pulleys and couplings etc.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.15
Mn	0.45
Si	0.30
Cr	1.0-1.5
Mo	1.0-1.5

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
THREE LAYER DEPOSIT –AS WELDED (BHN)	250

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing(Kgs)
	Min	Max	
Dia x Length			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 250°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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