

# Product Data Sheet



**BRAND NAME** VJ II

Hard Facing Electrode

## Features and Applications :

VJ II is a medium-coated rutile-type hardfacing electrode that deposits an air-hardening carbon-chromium alloy weld metal, ideal for surfacing carbon and low-alloy steels. The weld metal is machinable with carbide tools. For hard base materials, a buffer layer of VJ-7018 is recommended to enhance adhesion and performance.

This electrode provides excellent resistance to moderate abrasion and heavy impact, making it suitable for welding conveyor parts, cams, couplings, gear shafts, sprockets, pulleys, brake shoes, axles, shear blades, steel mill rolls, crane wheels, and dredge pump doors. VJ II ensures durability and reliability in demanding industrial environments.

## CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.30
Mn	0.40-0.70
Si	0.20-0.40
P	0.03
Cr	2.5-3.0
S	0.03

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
THREE LAYER DEPOSIT -AS WELDED (BHN)	350

## DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing(pcs)
	Min	Max	Qty / Pkt
3.15 x 450	100	140	120
4.00 x 450	140	180	70
5.00 x 450	180	220	50

## 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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