

Product Data Sheet



BRAND NAME VJ III LH

Hard Facing Electrode

Features and Applications :

A heavy coated, low hydrogen, basic type iron powder electrode. The weld metal is non-machinable which can withstand very high corrosion and impact. Suitable for welding of Cane cutting knives, bamboo chipper knives, crushers, hammers, screw conveyors, stone crusher jaws, mine rails and conveyor buckets etc.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.70
Mn	0.80
Si	0.70
Mo	0.5-1.0
Cr	6.0-7.5
V	0.5-1.0

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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