

Product Data Sheet



BRAND NAME VJ Ni1

AWS/ASME Class ENi -1

SPECIFICATION SFA 5.11

Features and Applications :

This electrode deposits a weld metal of 95% Ni and 2.5% Ti, ideal for welding commercially pure nickel, carbon steel, and dissimilar metals like nickel to stainless or alloy steels, providing corrosion resistance in caustic soda and marine environments. Used in dry halogen gas storage, pressure vessels, heat exchangers, offshore equipment, chlorination, organo-chemical equipment, alkali solutions, and seawater applications.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.10	Ni	92.0 Min
Mn	0.75	Al	1.00
Fe	0.75	Ti	1.0-4.0
S	0.020	Cu	0.25
P	0.030	Si	1.25

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	410 Min
El (%)	20 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Kgs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	60	90	3.5
3.15 x 350	90	130	3.5
4.00 x 350	130	180	3.5
5.00 x 350	170	230	3.5

CURRENT :DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 300°C for 1 hour.

Welding Technique Use a short arc and a stringer bead, applying the minimum required current to reduce heat input.