

Product Data Sheet



BRAND NAME VJ NiCrFe2

AWS/ASME Class ENiCrFe-2

SPECIFICATION SFA 5.11

Features and Applications :

VJ NiCrFe2 is a high nickel electrode is ideal for welding NiCrFe alloys and dissimilar metals, offering radiographic-quality welds with excellent mechanical properties, crack resistance, and high-temperature performance. Suitable for valve components, impellers, pressure vessels, heat exchangers, reactors, petrochemical equipment, offshore/onshore equipment.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.10	Ni	62.0 Min
Mn	1.0-3.50	Cr	13.0-17.0
Fe	12.00	Nb	0.50-3.0
S	0.020	Mo	0.50-2.50
P	0.030	Si	0.75

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	550 Min
El (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Kgs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	50	90	5.0
3.15 x 350	100	140	5.0
4.00 x 350	140	180	5.0
5.00 x 350	190	250	5.0

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.