Product Data Sheet

BRAND NAME VJ NiCrFe3

AWS/ASME Class ENiCrFe-3

SPECIFICATION SFA 5.11

Features and Applications :

VJ NiCrFe3 nickel - based electrode, designed with an Inconel-type alloy, produces high-quality radiographic welds with superior mechanical properties. It performs excellently at both high and cryogenic temperatures,for welding 9% Ni steels, dissimilar metals, Ni-Cr-Fe alloys, surfacing on steels, and cladding components exposed to heat, corrosion, and low temperatures.

Perfect for valve components, impellers, pressure vessels, heat exchangers, reactors, boiler parts, petrochemical equipment, offshore and onshore installations, chemical industries..

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**Max**	**TYPICAL**	**Max**
C	0.10	Ni	59.0 Min
Mn	5.0-9.5	Cr	13.0-17.0
Fe	10.00	Nb	1.0-2.50
S	0.015	Ti	1.0
P	0.030	Cu	0.50
Si	1.00		

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)
Dia x Length	**Min**	**Max**	**Qty / Pkt**
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 250°C for 1 hour.

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