Product Data Sheet

BRAND NAME VJ NiCrMo3

AWS/ASME Class ENiCrMo-3

SPECIFICATION SFA 5.11

Features and Applications :

VJ NiCrMo3 basic coated, low hydrogen, high nickel alloy electrode produce radiographic-quality welds with high strength, notch toughness, and resistance to abrasion, oxidation, and corrosion. It's ideal for welding Ni-Cr-Mo alloys, dissimilar materials, and surfacing on steels. Common applications include valve components, pressure vessels, heat exchangers, boiler parts, earthmoving equipment, dies, petrochemical equipment, and seawater applications..

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**Max**	**TYPICAL**	**Max**
C	0.10	Ni	55.0 Min
Mn	1.00	Cr	20.0-23.0
Fe	0.70	W	3.0-4.5
S	0.020	Nb +Ta	3.15-4.15
P	0.030	Mo	8.0-10.0
Si	0.75	Cu	0.50

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	**Typical**
UTS (MPa)	760 Min
El (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Kgs)
Dia x Length	**Min**	**Max**	**Qty / Pkt**
2.50 x 350	60	100	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 :AC/DC (+)

WELDING POSITION:

OTHER DATA:

Redrying: The electrodes should be redried at 350°C for 1 hour.

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