

Product Data Sheet



BRAND NAME VJ 308L

AWS/ASME Class E308L -16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 308L is an extra-low carbon electrode ideal for welding 19Cr10Ni-type steels and similar stabilized stainless steels. It offers excellent weldability in all positions, easy striking, a stable arc, self-peeling slag, and a smooth, shiny final bead appearance.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.04	Mn	1.20
Cr	20.00	Si	1.00
Ni	10.00	S	0.03
Mo	0.75	P	0.04
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

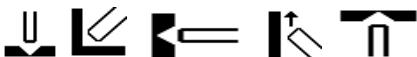
All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	460
UTS (MPa)	530
El (%)	32

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Kgs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	50	90	5
3.15 x 350	90	140	5
4.00 x 350	110	190	5
5.00 x 350	180	260	5

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 1 hour.