

Product Data Sheet



BRAND NAME VJ 309
AWS/ASME Class E309 -16
SPECIFICATION SFA A5.4

Features and Applications :

VJ 309 is a basic coated, all positional electrode depositing a weld metal of the type 23Cr-13Ni. The weld metal is extremely tough, resistant to corrosion and oxidation at elevated temperatures, up to 1100°C. It can be used for joining similar chemical composition stainless steels, dissimilar metal joining between carbon and low alloy steels to stainless and joining straight chrome steels and overlay on dissimilar steels

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.015	Mn	0.50-2.50
Cr	22.0-25.0	Si	1.00
Ni	12.0-14.0	S	0.03
Mo	0.50	P	0.04
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

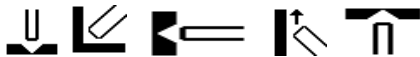
All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	550 Min
EI (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	50	80	150
3.15 x 350	80	130	100
4.00 x 350	130	170	75
5.00 x 350	170	230	50

CURRENT : DC (+)

WELDING POSITION:



OTHER DATA:

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