

Product Data Sheet



BRAND NAME VJ 309L
AWS/ASME Class E309L -16
SPECIFICATION SFA A5.4

Features and Applications :

VJ 309L is a rutile-coated, extra-low carbon 24 Cr/12 Ni type electrode with controlled ferrite (3-8 FN) weld deposit. high-temperature scaling resistance up to 1100°C. The electrode perform weldability in all positions, easy striking, stable arc, self-peeling slag, and a shiny, finely rippled final bead. Ideal for joining similar stainless steels, dissimilar metals (carbon/low-alloy steels to stainless), straight chrome steels, and overlaying on carbon steel.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.04	Mn	1.80
Cr	22.0-25.0	Si	0.75
Ni	12.0-14.0	S	0.03
Mo	0.50	P	0.03
Cu	0.50		

MECHANICAL PROPERTIES OF WELD METAL

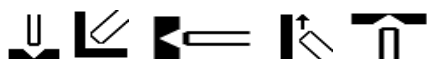
All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	520
El (%)	30 Min

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 : AC/DC (+)

WELDING POSITION:



OTHER DATA:

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