

Product Data Sheet



BRAND NAME VJ 309Nb

AWS/ASME Class E309Nb-16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 309Nb is a basic coated stainless steel electrode ideal for welding carbon steels, and dissimilar metals. It offers resistance to carbide precipitation and high strength at elevated temperatures, making it suitable for pressure vessels, heat exchangers, reactors.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.12	Mn	0.50-2.50
Cr	22.0-25.0	Si	1.00
Ni	12.0-14.0	S	0.03
Nb	0.70-1.0	P	0.04
Mo	0.75	Cu	0.75

MECHANICAL PROPERTIES OF WELD METAL

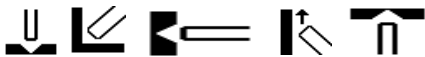
All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	550 Min
EI (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
Dia x Length	Min	Max	Qty / Pkt
2.50 x 350	50	90	150
3.15 x 350	90	140	100
4.00 x 350	140	180	75
5.00 x 350	180	240	50

CURRENT : DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 300°C for 1 hour.