Product Data Sheet

BRAND NAME VJ 310

AWS/ASME Class E310-16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 310 electrode a nominal composition of 26.5% Chromium (Cr) and 21% Nickel (Ni), making it ideal for welding stainless steels of similar composition in both cast and wrought forms. Additionally, it is well-suited for surfacing low-alloy steels where a 310-grade deposit is required. This electrode exhibits exceptional resistance to oxidation and maintains high-temperature toughness, making it highly suitable for demanding applications, particularly in chemical processing plants and other high-temperature environments

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**Max**	**TYPICAL**	**Max**
C	0.12	Mn	1.30
Cr	26.00	Si	0.75
Ni	21.00	S	0.03
Mo	0.75	P	0.03
Cu	0.20		

MECHANICAL PROPERTIES OF WELD METAL

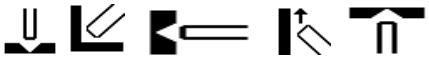
All Weld Metal - As Welded	
Properties	**Typical**
UTS (MPa)	580
El (%)	34

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	130	100
4.00 x 350	130	170	75
5.00 x 350	170	220	50

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

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