Product Data Sheet

BRAND NAME VJ 312

AWS/ASME Class E312-16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 312 is a rutile coated all positional electrode that produces crack-free, high-strength welds in carbon steel, low alloy steels, stainless steel. It is ideal for welding unknown composition steels, leaf springs, and coil springs, offering excellent radiographic quality. Best used below 420°C to prevent brittle phases, it's perfect for maintenance, pressure vessels, storage tanks, boiler components, and industries like oil & petrochemical, paper & pulp, chemical, food, and seawater applications.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**Max**	**TYPICAL**	**Max**
C	0.15	Mn	0.50-2.50
Cr	28.0-32.0	Si	1.00
Ni	8.0-10.50	S	0.03
Mo	0.75	P	0.04
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

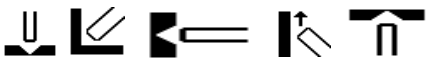
All Weld Metal - As Welded	
Properties	**Typical**
UTS (MPa)	660 Min
El (%)	22 Min

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	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.