

Product Data Sheet



BRAND NAME VJ 316L

AWS/ASME Class E316L-16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 316L is a rutile-coated, stainless steel 316-type electrode designed to deposit extra-low carbon 18Cr-12Ni-2.30Mo weld metal. The deposits offer exceptional corrosion and scaling resistance to acids, salts, and temperatures up to 800°C, with excellent resistance to pitting corrosion by chlorides and intergranular corrosion. It provides a self-releasing slag and a weld bead that is extremely smooth and shiny. Ideal for welding 316 and 317 stainless steels, and used in industries such as petrochemical, food, chemical, fertilizers, paint and dye, pressure vessels, storage tanks, offshore and onshore oil industries, nuclear components, heat exchangers, reactors, and more.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.04	Mn	1.0-2.50
Cr	17.0-20.0	Si	0.75
Ni	12.0-14.0	S	0.03
Mo	2.0-3.0	P	0.03
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

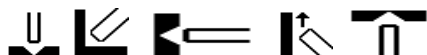
All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	490 Min
El (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
Dia x Length	Min	Max	Qty / Pkt
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.