Product Data Sheet

BRAND NAME VJ 320

AWS/ASME Class E320-15

SPECIFICATION SFA A5.4

Features and Applications :

VJ 320 is a basic-coated, all-position electrode with 20% Cr, 34% Ni, 2.5% Mo, and 3.5% Cu, with Nb addition. It offers excellent oxidation resistance up to 1100°C and superior corrosion resistance, especially against sulfuric and sulfurous acids. Suitable for cast and wrought alloys without post-weld heat treatment, it is ideal for high-pressure valves and chemical industries, ensuring durability in extreme environments.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**Max**	**TYPICAL**	**Max**
C	0.07	Mn	1.25
Cr	19.0-21.0	Si	1.00
Ni	33.00	S	0.03
Mo	2.20	P	0.04
Cu	3.40	Nb	1.00

MECHANICAL PROPERTIES OF WELD METAL

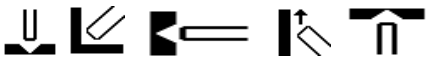
All Weld Metal - As Welded	
Properties	**Typical**
UTS (MPa)	550 Min
El (%)	30 Min

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	120	100
4.00 x 350	120	160	75
5.00 x 350	160	200	50

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

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