Product Data Sheet

BRAND NAME VJ 385

AWS/ASME Class E385-16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 385 is a non-synthetic electrode that produces an extra-low carbon weld metal (20.5Cr, 25Ni, 5Mo, 1.5Cu) with excellent corrosion resistance to sulfuric, phosphoric, acetic, formic, and fatty acids. It is ideal for welding 904L and SS 317L materials, as well as joining SS 904L/317L to carbon steel.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**Max**	**TYPICAL**	**Max**
C	0.03	Mn	2.00
Cr	20.0	Si	0.40
Ni	24.0	S	0.03
Mo	4.40	P	0.03
Cu	1.80		

MECHANICAL PROPERTIES OF WELD METAL

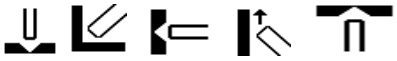
All Weld Metal - As Welded	
Properties	**Typical**
UTS (MPa)	520 Min
El (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
Dia x Length	**Min**	**Max**	**Qty / Pkt**
2.50 x 350	60	80	150
3.15 x 350	80	120	100
4.00 x 350	120	160	75
5.00 x 350	160	210	50

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

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