Product Data Sheet

BRAND NAME VJ 410

AWS/ASME Class E410-16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 410 is a high-deposition electrode designed for joining similar alloys and for surfacing and overlay applications on unalloyed steels and 12.5% Cr chromium steels. The weld deposit offers excellent resistance to corrosion, erosion, pitting, and abrasion, ensuring durability in demanding environments.

Ideally suited for surfacing valves, turbine components, and steam valves made of 13% Cr steel, VJ 410 delivers superior performance in high-temperature and high-wear applications.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	**0.1**	**TYPICAL**	**Max**
C	0.06	Mn	1.00
Cr	11.80	Si	0.50
Ni	0.65	S	0.03
Mo	0.75	P	0.04
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - PWHT 730^{0}C-1 Hr	
Properties	**Typical**
UTS (MPa)	520 Min
El (%)	20 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	140	180	75
5.00 x 350	180	240	50

CURRENT :DC (+)

WELDING POSITION:

OTHER DATA:

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