

Product Data Sheet



BRAND NAME VJ 410NiMo

AWS/ASME Class E410NiMo-15

SPECIFICATION SFA A5.4

Features and Applications :

The VJ 410NiMO is a specially designed rutile-coated stainless steel electrode, ideal for surfacing applications on machine parts exposed to severe corrosion, erosion, pitting, and impact. It deposits a weld metal containing 13Cr, 4Ni, and 0.5 Mo, making it perfect for high-pressure valves, valve seats, turbine blades, and pulp and paper plant machinery. Additionally, it is suitable for castings, similar materials, and light gauge types of 410, 410S, and 405 base metals.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.06	Mn	1.00
Cr	11.0-12.5	Si	0.90
Ni	4.0-5.0	S	0.03
Mo	0.40-0.70	P	0.04
Cu	0.75		

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - PWHT 620°C-1 Hr	
Properties	Typical
UTS (MPa)	760 Min
El (%)	15 Min
Hardness (BHN)	300-350

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.