

Product Data Sheet



BRAND NAME VJ 2553
AWS/ASME Class E2553 -16
SPECIFICATION SFA 5.4

Features and Applications :

VJ 2553 is a rutile-coated electrode for super duplex stainless steel, offering high-strength welds with a duplex austenitic-ferritic microstructure. It ensures radiographic-quality, all-position welding with easy slag removal. Ideal for offshore, chemical, petrochemical, pulp, paper, and textile industries. Provides excellent resistance to pitting, corrosion, and stress corrosion cracking.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.03	Cr	25.0
Mn	0.80	Ni	7.20
Si	0.50	Mo	3.40
Cu	2.00	N	0.15
S	0.01	P	0.01

MECHANICAL PROPERTIES OF WELD METAL

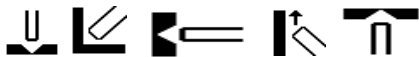
All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	790
EI (%)	19

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Kgs)
	Min	Max	Qty / Pkt
Dia x Length			
2.50 x 350	60	90	5.0
3.15 x 350	90	120	5.0
4.00 x 350	110	150	5.0

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

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