OK AUTROD 16.10

An extra low carbon stainless steel solid wire for GMAW of 18Cr-8Ni type steels

Classification AWS A5.9: ER308L

DESCRIPTION

A corrosion resistant, chromium-nickel alloyed solid wire for welding austenitic stainless alloys of 18Cr-8Ni type. OK AUTROD 16.10 has good general corrosion resistance. The alloy has a low carbon content which makes it particularly suitable to the applications, where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers.

APPROVALS: NPC

WELDING CURRENT: DC+

SHIELDING GAS: Ar/O_2 or Ar/CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.03	YS (N/mm²)	420
Si	0.45	UTS (N/mm²)	590
Mn	1.70	Elongation (%)	36
Cr	20.00	Impact (CVN)	
Ni	9.80	@ -196ºC (Joules)	50

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	50-180	16-22
1.2	80-280	19-28
1.6	100-380	19-33

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK AUTROD 16.11

A Nb stabilized 20Cr-10Ni stainless steel solid wire for GMAW

Classification AWS A5.9: ER347

DESCRIPTION

A corrosion-resistant, chromium-nickel alloyed solid wire for welding stabilized austenitic chromium-nickel alloys of 18Cr-8Ni type. OK AUTROD 16.11 has good general corrosion resistance. The alloy is stabilized with niobium to improve resistance to the intergranular corrosion of the weld metal. Due to the niobium content, this alloy is recommended for use at higher temperatures.

WELDING CURRENT: DC+

SHIELDING GAS: Ar/O_2 or Ar/CO_2

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.03	YS (N/mm²)	400
Si	0.40	UTS (N/mm²)	600
Mn	1.50	Elongation (%)	35
Cr	19.50	Impact (CVN)	
Ni	9.50	@ +20ºC (Joules)	100
Nb	0.40		

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
0.8	50-180	16-22
1.2	80-280	19-28

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

OK AUTROD 16.30

An extra low carbon stainless steel solid wire for SAW of 18Cr-12Ni-2.5Mo type steels

Classification AWS A5.9: ER316L

DESCRIPTION

A corrosion resistant, chromium-nickel-molybdenum alloyed solid wire for welding austenitic stainless alloys of the 18Cr-8Ni and 18Cr-12Ni-2.5Mo types. The alloy has very good resistance to corrosion in acid and chlorinated envi-ronments. The alloy has a low carbon content which makes it particularly suitable to the applications, where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structures. OK AUTROD 16.30 can be used in combination with OK FLUX 10.92L.

TYPICAL PROPERTIES

Wire Composition (Wt.%)	
C	0.03
Si	0.40
Mn	1.70
Cr	18.50
Ni	11.80
Mo	2.70

PACKING DATA

Size (mm)	Packing 25 Kg
2.50	✓
3.15	✓
4.00	✓

PACKING: The wire can be supplied in corrugated cardboard box weighing 25 Kg.

OK AUTROD 16.53

An extra low carbon 24Cr-13Ni stainless steel solid wire for SAW

Classification AWS A5.9: ER309L

DESCRIPTION

A corrosion resistant, chromium-nickel alloyed solid wire for joining stainless steels to non-alloy or low-alloy steels and for welding austenitic stainless alloys of the 24Cr-13Ni types. The alloy is also used for welding buffer layers on C-Mn steels. OK AUTROD 16.53 can be used in combination with OK FLUX 10.92L.

TYPICAL PROPERTIES

Wire Composition (Wt.%)	
C	0.03
Si	0.45
Mn	1.75
Cr	23.50
Ni	12.50

PACKING DATA

Size (mm)	Packing 25 Kg
2.50	✓
3.15	✓
4.00	✓

PACKING: The wire can be supplied in corrugated cardboard box weighing 25 Kg.
