

## OK Autrod 16.95

A continuous solid, corrosion resisting chromium-nickel-manganese wire for welding of austenitic stainless alloys of 18% Cr, 8% Ni, 7% Mn types. OK Autrod 16.95 has a general corrosion resistance similar to that of the corresponding parent metal. The higher silicon content improves the welding properties, such as wetting. The product is a modified variant of ER307, basically with a higher Mn content to make the weld less sensitive to hot cracking. When used for joining dissimilar materials the corrosion resistance is of secondary importance. The alloy is used in a wide range of applications across the industry such as the joining of austenitic, manganese, work hardenable steels as well as armour plates and heat resistant steels.

Specifications	
<b>Classifications</b>	EN ISO 14343-A : G 18 8 Mn SFA/AWS A5.9 : ER307 (mod) Werkstoffnummer : ~1.4370
<b>Approvals</b>	CE : EN 13479 DB : 43.039.10 NAKS/HAKC : 1.2MM VdTÜV : 05420

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type</b>	Austenitic (18 % Cr - 8 % Ni - 7 % Mn)
<b>Shielding Gas</b>	M12, M13 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	450 MPa	640 MPa	41 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	20 °C	130 J

Typical Wire Composition %					
C	Mn	Si	Ni	Cr	Mo
0.08	7.0	0.9	8.1	18.7	0.20

Deposition Data		
Diameter	Current	Voltage
0.8 mm	55-160 A	15-24 V
0.9 mm	65-220 A	15-28 V
1.0 mm	80-240 A	15-28 V
1.2 mm	100-300 A	15-29 V
1.6 mm	230-375 A	23-31 V