

## OK AUTROD 16.10

A corrosion resistant, chromium-nickel alloyed solid wire for welding austenitic stainless alloys of 18Cr-8Ni type. OK AUTROD 16.10 can be used in combination with OK Flux 10.93.

### Specifications

|                 |                       |
|-----------------|-----------------------|
| Classifications | SFA/AWS A5.9 : ER308L |
|-----------------|-----------------------|

|            |                  |
|------------|------------------|
| Alloy Type | Austenitic Cr-Ni |
|------------|------------------|

### Typical Tensile Properties

| Condition              | Yield Strength | Tensile Strength | Elongation |
|------------------------|----------------|------------------|------------|
| As Welded              | 450 MPa        | 620 MPa          | 36 %       |
| <b>Tested at 350°C</b> |                |                  |            |
| As Welded              | 370 MPa        | 490 MPa          | 25 %       |

### Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------|---------------------|--------------|
| As Welded | 20 °C               | 110 J        |
| As Welded | -60 °C              | 90 J         |
| As Welded | -196 °C             | 60 J         |

### Typical Wire Composition %

| C    | Mn   | Si   | S     | P     | Ni   | Cr    | Mo   | Cu   |
|------|------|------|-------|-------|------|-------|------|------|
| 0.02 | 1.80 | 0.50 | 0.010 | 0.025 | 9.20 | 19.80 | 0.20 | 0.20 |

### Deposition Data

| Diameter | Current   | Voltage   | Wire Feed Speed | Deposition Rate |
|----------|-----------|-----------|-----------------|-----------------|
| 0.8 mm   | 55-160 A  | 15-24 V   | 4.0-17.0 m/min  | 0.9-4.1 kg/h    |
| 1.0 mm   | 80-240 A  | 15-28 V   | 4.0-16.0 m/min  | 1.5-6.0 kg/h    |
| 1.2 mm   | 100-300 A | 14-28.5 V | 3.0-14.0 m/min  | 1.6-7.5 kg/h    |