OK AUTROD 16.11

A corrosion-resistant, chromium-nickel-niobium 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.

Specifications	
Classifications	SFA/AWS A5.9 : ER347

Alloy Type	Austenitic Cr-Ni-Nb
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	400 MPa	600 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	20 °C	100 J

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**Nb**
0.02	1.70	0.40	0.010	0.025	9.50	19.50	0.10	0.10	0.35

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h