OK AUTROD 16.53

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/low-alloy steels.

Specifications	
Classifications	SFA/AWS A5.9 : ER309L

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

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	420 MPa	600 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	-60 °C	80 J

Typical Wire Composition %								
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**
0.02	1.70	0.40	0.010	0.025	12.30	23.50	0.10	0.10

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	1.0-4.1 kg/h
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h