

OK AUTROD 16.30

A corrosion resistant, chromium-nickel-molybdenum alloyed solid wire for welding austenitic stainless alloys of the 18Cr-12Ni-2.5Mo type. The alloy has very good resistance to corrosion in acid and chlorinated environments. 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.

Specifications

Classifications	SFA/AWS A5.9 : ER316L
------------------------	-----------------------

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	430 MPa	620 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-110 °C	50 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo
0.02	1.70	0.40	11.30	18.50	2.20

Deposition Data

Diameter	Current	Voltage
1.2 mm	100-280 A	15-28 V
0.8 mm	55-160 A	15-24 V