

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 has good general corrosion resistance. 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 for pipes, tubes and boilers.

Specifications

Classifications	SFA/AWS A5.9 : ER308L
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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	590 MPa	36 %

Typical Charpy V-Notch Properties

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

Typical Wire Composition %

C	Mn	Si	Ni	Cr
0.025	1.70	0.40	9.50	19.80

Deposition Data

Diameter	Current	Voltage
0.8 mm	55-160 A	15-24 V
1.2 mm	100-280 A	19-28 V