

## OK TIGROD 16.53

OK TIGROD 16.53 is a corrosion resistant, chromium-nickel alloyed solid rod 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-alloyed steels.

### Specifications

<b>Classifications</b>	SFA/AWS A5.9 : ER309L
<b>Approvals</b>	PDIL : ER309L

Approvals are based on factory location. Please contact ESAB for more information.

<b>Alloy Type</b>	Austenitic Cr-Ni
<b>Shielding Gas</b>	I1 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	410 MPa	580 MPa	35 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-60 °C	100 J

### Typical Wire Composition %

C	Mn	Si	Ni	Cr
0.02	1.75	0.45	12.20	23.50