

OK Autrod 316LSi

A continuous solid corrosion resisting chromium-nickel-molybdenum wire for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo types. OK Autrod 316LSi has a good general corrosion resistance, in particularly the alloy has very good resistance against corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties, such as wetting. The alloy is widely used in the chemical and food processing industries as well as in ship building and various types of architectural structures.

Dane techniczne

Klasyfikacje	EN ISO 14343-A : G 19 12 3 L Si SFA/AWS A5.9 : ER316LSi Werkstoffnummer : ~1.4430
Aprobaty	CE : EN 13479 CWB : ER316LSi DB : 43.039.05 DNV-GL : VL 316 L (M13) VdTÜV : 04268 NAKS/HAKC : 0.8-1.2 mm

Rodzaj stopu	Austenitic (with approx. 8 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C - High Si
---------------------	---

Typowe właściwości mechaniczne

Warunki	Granica plastyczności	Wytrzymałość na rozciąganie	Wydłużenie względne
Po spawaniu	400 MPa	560 MPa	37 %
Tested at 350°C.			
Po spawaniu	340 MPa	440 MPa	26 %

Udarowo Charpy V

Warunki	Temperatura testu	Udarowo KV
Po spawaniu	20 °C	120 J
Po spawaniu	-60 °C	95 J
Po spawaniu	-110 °C	70 J
Po spawaniu	-196 °C	45 J

Typowy skład chemiczny stopiwa %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.02	1.8	0.8	0.015	0.015	12	18.5	2.7	0.1

Skład drutu %

C	Mn	Si	Ni	Cr	Mo	Cu
0.01	1.8	0.9	12.2	18.4	2.60	0.12

Dane wydajności stopiwa

rednica	A	V	Prdko podawania drutu	Wydajno stopiwa
0.8 mm	55-160 A	12-24 V	4.0-17.0 m/min	1.0-4.1 kg/h
0.9 mm	65-220 A	15-28 V	3.5-18.0 m/min	1.1-5.4 kg/h
1.0 mm	80-240 A	15-28 V	4.0-16.0 m/min	1.5-6.0 kg/h
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h
1.6 mm	230-375 A	23-31 V	5.5-9.0 m/min	5.2-8.6 kg/h

OK Autrod 316LSi

Parametry spawania
rednica drutu
0.6 mm
1.14 mm