

OK Autrod 16.95

A continuous solid corrosion resisting chromium-nickel-manganese wire for welding of austenitic stainless alloys of 18% Cr, 8% Ni, 7% Mn types.

OK Autrod 16.95 has a general corrosion resistance similar to that of the corresponding parent metal. The higher silicon content improves the welding properties, such as wetting. The product is a modified variant of ER307, basically with a higher Mn content to make the weld metal less sensitive to hot cracking. When used for joining dissimilar materials the corrosion resistance is of secondary importance. The alloy is used in a wide range of applications across the industry such as joining of austenitic, manganese, work hardenable steels as well as armourplate and heat resistant steels.

Классификации	EN ISO 14343-A : G 18 8 Mn
Тип сплава	Austenitic (18 % Cr - 8 % Ni - 7 % Mn)
Защитный газ	M12, M13 (EN ISO 14175)

Типичные свойства образца с V-образным надрезом по Шарпи

Состояние	Температура испытания	Работа удара
M12 (98%Ar + 2%CO ₂) или M13 (98%Ar + 2%O ₂)		

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.1	6.5	1	0.020	0.010	8.5	18.5	0.1	0.1

Хим. состав проволоки

C	Mn	Si	Ni	Cr	Mo	Cu
0.08	7.0	0.9	8.1	18.7	0.20	0.10

Данные наплавки

Диаметр	Ток	В	Скорость подачи проволоки	Кэфф. наплавки
0.8 mm	55-160 A	15-24 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