

## OK Autrod 308H

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type. OK Autrod 308H has a good general corrosion resistance. The alloy has a high carbon content which makes this alloy suitable for applications used at higher temperatures. The alloy is used in chemical and petrochemical plants for welding of pipes, cyclones and boilers.

### Dane techniczne

<b>Klasyfikacje</b>	EN ISO 14343-A : G 19 9 H SFA/AWS A5.9 : ER308H
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<b>Rodzaj stopu</b>	Austenitic 19% Cr - 9% Ni - High C
<b>Gaz osonowy</b>	M12, M13 (EN ISO 14175)

### Skad drutu %

C	Mn	Si	Ni	Cr	N	Nb	FN WRC-92
0.05	1.9	0.5	9.2	19.8	0.04	0.01	6

### Dane wydajności stopiwa

rednica	A	V	Prdko podawania drutu	Wydajno stopiwa
0.8 mm	50-140 A	16-22 V	3.4-11.0 m/min	0.8-2.7 kg/h
1.0 mm	80-190 A	16-24 V	2.9-8.4 m/min	1.1-3.1 kg/h
1.2 mm	180-280 A	20-28 V	4.9-8.5 m/min	2.6-4.5 kg/h