

## OK Autrod 309L

A continuous solid corrosion resisting chromium-nickel wire for welding of similar steels, wrought and cast steels of 23% Cr-12% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld. OK Autrod 309L has a good general corrosion resistance. When used for joining dissimilar materials the corrosion resistance is of secondary importance.

| Dane techniczne |   |
|-----------------|---|
| Klasyfikacje    | EN ISO 14343-A : G 23 12 L<br>SFA/AWS A5.9 : ER309L |
| Aprobaty        | CE : EN 13479<br>UKCA : EN 13479                    |

Zatwierdzenia s oparte na lokalizacji fabryki. Aby uzyska wiecej informacji, skontaktuj si z ESAB.

|              |   |
|--------------|---|
| Rodzaj stopu | Austenitic (with approx. 9 % ferrite) 24 % Cr - 13 % Ni - Low C |
| Gaz osonowy  | M12, M13 (EN ISO 14175)   |

| Typowe waciwoci mechaniczne |                      |                           |                  |
|-----------------------------|----------------------|---------------------------|------------------|
| Warunki                     | Granica plastycznoci | Wytrzymaao na rozciąganie | Wyduenie wzgldne |
| Po spawaniu                 | 440 MPa              | 600 MPa                   | 32 %             |

| Udarno Charpy V |                   |           |
|-----------------|-------------------|-----------|
| Warunki         | Temperatura testu | Udarno KV |
| Po spawaniu     | 20 °C             | 160 J     |
| Po spawaniu     | -60 °C            | 130 J     |
| Po spawaniu     | -110 °C           | 90 J      |

| Skad drutu % |     |     |       |       |      |      |      |     |      |
|--------------|-----|-----|-------|-------|------|------|------|-----|------|
| C            | Mn  | Si  | S     | P     | Ni   | Cr   | Mo   | Cu  | N    |
| 0.02         | 1.8 | 0.4 | 0.010 | 0.015 | 13.4 | 23.2 | 0.10 | 0.1 | 0.05 |

| Skad drutu % |
|--------------|
| FN WRC-92    |
| 10           |

| Typowy skad chemiczny stopiwa % |     |     |       |       |      |      |     |     |
|---------------------------------|-----|-----|-------|-------|------|------|-----|-----|
| C                               | Mn  | Si  | S     | P     | Ni   | Cr   | Mo  | Cu  |
| 0.03                            | 1.5 | 0.4 | 0.005 | 0.010 | 12.5 | 23.5 | 0.1 | 0.1 |

| Dane wydajności stopiwa |           |         |                       |                 |
|-------------------------|-----------|---------|-----------------------|-----------------|
| rednica                 | A         | V       | Prdko podawania drutu | Wydajno stopiwa |
| 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    |