

OK Autrod 309LSi

A continuous solid corrosion resistant 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 309LSi has a good general corrosion resistance. The higher silicon content improves the welding properties, such as wetting.

| Dane techniczne | |
|---------------------|---|
| Klasyfikacje | EN ISO 14343-A : G 23 12 L Si SFA/AWS A5.9 : ER309LSi |
| Aprobaty | CE : EN 13479 CWB : ER309LSi DB : 43.039.16 UKCA : EN 13479 VdTÜV : 10020 |

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

| | |
|---------------------|---|
| Rodzaj stopu | Austenitic (with approx. 8 % 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 |
| AWS | | | |
| Po spawaniu | 430 MPa | 600 MPa | 32 % |
| ISO | | | |
| Po spawaniu | 440 MPa | 600 MPa | - |

| Udarno Charpy V | | |
|-----------------|-------------------|-----------|
| Warunki | Temperatura testu | Udarno KV |
| AWS | | |
| Po spawaniu | -50 °C | 110 J |
| ISO | | |
| Po spawaniu | 20 °C | 120 J |
| Po spawaniu | -50 °C | 110 J |

| Skad drutu % | | | | | | | | | |
|--------------|-----|-----|-------|-------|------|------|-----|-----|------|
| C | Mn | Si | S | P | Ni | Cr | Mo | Cu | N |
| 0.016 | 1.9 | 0.7 | 0.004 | 0.019 | 13.7 | 23.3 | 0.1 | 0.1 | 0.09 |

| Skad drutu % | |
|--------------|------------------|
| Nb | FN WRC-92 |
| 0.02 | 9 |

| Typowy skad chemiczny stopiwa % | | | | | | | | | |
|---------------------------------|-----|-----|-------|-------|------|----|-----|-----|------|
| C | Mn | Si | S | P | Ni | Cr | Mo | Cu | N |
| 0.02 | 1.8 | 0.7 | 0.003 | 0.015 | 13.5 | 23 | 0.1 | 0.1 | 0.07 |

| Typowy skad chemiczny stopiwa % | |
|---------------------------------|------------------|
| Nb | FN WRC-92 |
| 0.01 | 7 |

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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 |
| 1.6 mm | 230-375 A | 23-31 V | 5.5-9.0 m/min | 5.2-8.6 kg/h |

Parametry spawania

rednica drutu

1.14 mm