OK Autrod 316LSi

A continuous solid corrosion resisting chroumium-nickel-molybdenium 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 risc 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 : NV 316 L UKCA : EN 13479 VdTÜV : 04268

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

Rodzaj stopu	Austenitic (with approx. 8 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C - High Si
Gaz osonowy	M12, M13 (EN ISO 14175)

Typowe waciwoci mechaniczne			
Warunki	**Granica plastycznoci**	**Wytrzymao na rozciganie**	**Wyduenie wzgldne**
AWS			
Po spawaniu	460 MPa	630 MPa	40 %
ISO Tested at 350°C.			
Po spawaniu	340 MPa	440 MPa	26 %
ISO			
Po spawaniu	400 MPa	560 MPa	37 %

Udarno Charpy V		
Warunki	**Temperatura testu**	**Udarno KV**
AWS		
Po spawaniu	-196 °C	50 J
ISO		
Po spawaniu	20 °C	120 J
Po spawaniu	-60 °C	95 J
Po spawaniu	-110 °C	70 J
Po spawaniu	-196 °C	45 J

Skad drutu %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.012	1.7	0.75	0.013	0.015	11.8	18.4	2.6	0.1	0.06

Skad drutu %
FN WRC-92
8

Typowy skad chemiczny stopiwa %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**FN WRC-92**

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Typowy skad chemiczny stopiwa %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**FN WRC-92**
0.02	1.8	0.8	0.015	0.015	12	18.5	2.7	0.1	6
-	-	-	-	-	-	-	-	-	6

Dane wydajnoci 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

Parametry spawania
rednica drutu
0.6 mm
1.14 mm