

OK Autrod 16.38

A continuous solid corrosion resisting non-magnetic chromium-nickel-molybdenum wire for welding of stabilized and non-stabilized austenitic alloys of the same type as well as non magnetic steels. The alloy is corrosion resistant in seawater environment and has very good corrosion resistance to acids such as nitric acid. Excellent impact properties at low temperatures

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|---------------------------------------|---------------------------------|
| Classifications Wire Electrode | EN ISO 14343-A : G 20 16 3 Mn L |
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|-------------------|--|
| Alloy Type | Austenitic (7 % Mn - 20 % Cr - 16 % Ni - 3 % Mo) |
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Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------|---------------------|--------------|
| As Welded | -60 °C | 90 J |
| As Welded | -110 °C | 70 J |
| As Welded | -196 °C | 40 J |

Typical Wire Composition %

| C | Mn | Si | Ni | Cr | Mo | N |
|------|-----|-----|------|------|-----|------|
| 0.01 | 6.9 | 0.4 | 16.5 | 19.9 | 3.0 | 0.18 |

Deposition Data

| Diameter | Current | Voltage | Wire Feed Speed | Deposition Rate |
|----------|----------|---------|-----------------|-----------------|
| 1.0 mm | 80-190 A | 16-24 V | 2,9-8,4 m/min | 1,1-3,1 kg/h |