

OK Autrod 316LSi

A continuous, solid, corrosion-resistant, chromium-nickel-molybdenum wire for welding austenitic stainless alloys of the 18% Cr -8% Ni and 18% Cr -10% Ni -3% Mo types.

OK Autrod 316LSi has good general corrosion resistance; in particular, the alloy has very good resistance to corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended when there is a risk 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 shipbuilding and various types of architectural structure.

Elettrodo filo - Classificazioni	SFA/AWS A5.9 : ER316LSi EN ISO 14343-A : G 19 12 3 L Si Werkstoffnummer : ~1.4430
Approvazioni	CE EN 13479 CWB ER316LSi DB 43.039.05 DNV-GL VL 316 L (M13) VdTUV 04268 NAKS/HAKC 0.8-1.2 mm

Le approvazioni si basano sulla localizzazione della fabbrica. Contatta ESAB per maggiori informazioni.

Tipo di lega	Austenitic (with approx. 8 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C - High Si
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Proprietà tensili tipiche

Stato	Resistenza allo snervamento	Resistenza alla trazione	Allungamento
Come saldato	400 MPa	560 MPa	37 %
Tested at 350°C.			
Come saldato	340 MPa	440 MPa	26 %

analisi tipica del deposito

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.02	1.8	0.8	0.015	0.015	12	18.5	2.7	0.1

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.01	1.8	0.9	12.2	18.4	2.60	0.12	7

Dati deposito

Diametro	Amp	Volt	Velocità di trascinamento del filo	Tasso di deposito
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

Parametri di saldatura

Diametro del filo
0.6 mm
1.14 mm