

## OK Autrod 16.95

A continuous solid, corrosion resisting chromium-nickel-manganese wire for welding of austenitic stainless alloys of 18% Cr, 8% Ni, 7% Mn types. OK Autrod 16.95 has a general corrosion resistance similar to that of the corresponding parent metal. The higher silicon content improves the welding properties, such as wetting. The product is a modified variant of ER307, basically with a higher Mn content to make the weld less sensitive to hot cracking. When used for joining dissimilar materials the corrosion resistance is of secondary importance. The alloy is used in a wide range of applications across the industry such as the joining of austenitic, manganese, work hardenable steels as well as armour plate and heat resistant steels.

焊丝分类	SFA/AWS A5.9 : ER307 mod EN ISO 14343-A : G 18 8 Mn Werkstoffnummer : ~1.4370
认证	CE EN 13479 DB 43.039.10 NAKS/HAKC 1.2MM VdTUV 05420

认证根据工厂所在位置而有所不同。请联系伊萨了解更多信息。

合金类型	Austenitic (18 % Cr - 8 % Ni - 7 % Mn)
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### 典型拉伸性能

条件	屈服强度 (公制)	抗拉强度 (公制)	延伸率
焊态	450 MPa	640 MPa	41 %

### 夏比V型缺口冲击性能

条件	测试温度 (公制)	冲击值
焊态	20 °C	130 J

### 全焊缝金属

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.1	6.5	1	0.020	0.010	8.5	18.5	0.1	0.1

### 焊丝成分

C	Mn	Si	Ni	Cr	Mo	Cu
0.08	7.0	0.9	8.1	18.7	0.20	0.10

### 熔敷数据

直径	安培	电压 V	送丝速度	熔敷率
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