

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

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