

OK Autrod 309LSi

A continuous solid corrosion resistant chromium–nickel wire for welding of similar steels, wrought and cast steels of 23% Cr–12% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld. OK Autrod 309LSi has a good general corrosion resistance. The higher silicon content improves the welding properties, such as wetting.

焊丝分类	SFA/AWS A5.9 : ER309LSi EN ISO 14343-A : G 23 12 L Si Werkstoffnummer : ~1.4332
认证	CE EN 13479 CWB ER309LSi DB 43.039.16 NAKS/HAKC 1.0MM-1.2MM VdTUV 10020

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 (with approx. 8 % ferrite) 24 % Cr - 13 % Ni - Low C
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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	440 MPa	600 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	160 J
焊态	-60 °C	130 J
焊态	-110 °C	90 J

全焊缝金属

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	1.8	0.8	0.005	0.010	13	24	0.1	0.1	0.12

全焊缝金属

Nb	FN WRC-92
0.02	10

焊丝成分

C	Mn	Si	Ni	Cr	Mo	Cu
0.02	1.7	0.9	13.5	23.4	0.15	0.12

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



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焊接参数

焊丝直径

1.14 mm