

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.

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

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) 19% Cr - 12% Ni - 3% Mo - Low C - High Si
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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	400 MPa	560 MPa	37 %
Tested at 350° C.			
焊态	340 MPa	440 MPa	26 %

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	120 J
焊态	-60 °C	95 J
焊态	-110 °C	70 J
焊态	-196 °C	45 J

全焊缝金属

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

焊丝成分

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

熔敷数据

直径	安培	电压 V	送丝速度	熔敷率
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



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焊接参数

焊丝直径

0.6 mm

1.14 mm