

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 metal 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 joining of austenitic, manganese, work hardenable steels as well as armourplate and heat resistant steels.

Specifications	
Classifications	EN ISO 14343-A : G 18 8 Mn SFA/AWS A5.9 : ER307 (mod) Werkstoffnummer : ~1.4370
Approvals	CE : EN 13479 DB : 43.039.10 NAKS/HAKC : 1.2MM VdTUV : 05420

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (18 % Cr - 8 % Ni - 7 % Mn)
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	450 MPa (65 ksi)	640 MPa (93 ksi)	41 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	130 J (96 ft-lb)

Typical Wire Composition %						
C	Mn	Si	Ni	Cr	Mo	Cu
0.08	7.0	0.9	8.1	18.7	0.20	0.10

Typical Weld Metal Analysis %								
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

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm (0.030 in.)	55-160 A	15-24 V	4.0-17.0 m/min (157-669 in./min)	1.0-4.1 kg/h (2.2-9.0 lbs/h)
0.9 mm (0.035 in.)	65-220 A	15-28 V	3.5-18.0 m/min (138-709 in./min)	1.1-5.4 kg/h (2.4-11. lbs/h)
1.0 mm (0.040 in.)	80-240 A	15-28 V	4.0-16.0 m/min (157-630 in./min)	1.5-6.0 kg/h (3.3-13. lbs/h)
1.2 mm (0.047 in.)	100-300 A	15-29 V	3.0-14.0 m/min (118-551 in./min)	1.6-7.5 kg/h (3.5-16. lbs/h)
1.6 mm (1/16 in.)	230-375 A	23-31 V	5.5-9.0 m/min (217-354 in./min)	5.2-8.6 kg/h (11.5-19. lbs/h)