

Тел Esab заваръчна за МИГ заваряване на неръждаема стомана 0.8 мм, 5 кг, ОК Autrod 16.12



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Product Data Sheet

G 'Gas-shielded metal-arc welding'

OK Autrod 16.12

Signed by Mats Linde	Approved by Mats Öhman/Barbro Karlström	Reg no EN002141	Cancelling EN001121	Reg date 2004-06-17	Page 1 (2)
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REASON FOR ISSUE

Chemical composition modified.

GENERAL

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type.

OK Autrod 16.12 has a good general corrosion resistance. The alloy has a low carbon content which makes this alloy particularly recommended where 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 for pipes, tubes and boilers.

Shielding Gas: M12, M13 (EN439)

Alloy Type: Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C - High Si

CLASSIFICATIONS Wire Electrode

EN 12072 G 19 9 LSi
SFA/AWS A5.9 ER308LSi
Werkstoffnummer ~1.4316

APPROVALS

Ü 43.039/1
DB 43.039.01
DNV 308L MS (-60 °C)
Sepros UNA 485178
UDT DIN 8556
VdTÜV 04267

CHEMICAL COMPOSITION

Compound	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.01		0.030
Si	0.8	0.65	1.00
Mn	1.8	1.0	2.5
P	0.015		0.030
S	0.015	0.005	0.020
Cr	20	19.5	21.0
Ni	10	9.0	11.0
Mo	0.1		0.3
Cu	0.1		0.3
N			0.08
Others total			0.50

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MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal					
	As welded		SHT 1050°C 0.5h	Tested at 350°C.		Tested at 350°C.
	Min	Typ	Typ	As welded	SHT 1050°C 0.5h	Typ
Rp0.2 (MPa)	320	370	340	370	240	
Rm (MPa)	510	620	600	490	460	
A4-A5 (%)	30	36	43	25	28	
Charpy V at 20°C (J)		110	90			
Charpy V at -60°C (J)		90	80			
Charpy V at -196°C (J)		60	60			

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W		H		Feed		U	
	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
Ø										
0.6										
0.8	55	160	12		1.0	4.1	4.0	17.0	15	24
0.9	65	220	13		1.1	5.4	3.5	18.0	15	28
1.0	80	240	15		1.5	6.0	4.0	16.0	15	28
1.2	100	300	18		1.6	7.5	3.0	14.0	15	29
1.6	230	375	22		5.2	8.6	5.5	9.0	23	29

W = Gas consumption (l / min)

= Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)

Продукт: [Тел Esab заваръчна за МИГ заваряване на неръждаема стомана 0.8 мм, 5 кг, ОК Autrod 16.12](#)

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