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 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 the joining of austenitic, manganese, work hardenable steels as well as armour plate and heat resistant steels.

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

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

Alloy Type:	Austenitic (18 % Cr - 8 % Ni - 7 % Mn)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	450 MPa	640 MPa	41 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C	130 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu
0.08	7.0	0.9	8.1	18.7	0.20	0.10

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
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