

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.

Classificatie draadelektrode	SFA/AWS A5.9 : ER309LSi EN ISO 14343-A : G 23 12 L Si
Goedkeuringen	CE EN 13479 CWB ER309LSi DB 43.039.16 NAKS/HAKC 1.0MM-1.2MM VdTUV 10020

Goedkeuringen zijn gebaseerd op fabriekslocatie. Contacteer ESAB voor meer informatie.

Legering Type	Austenitic (with approx. 8 % ferrite) 24 % Cr - 13 % Ni - Low C
Beschermgas	M12, M13 (EN ISO 14175)

Typische trekeigenschappen

Condition	Rekgrens	Treksterkte	Verlenging
Zoals gelast	440 MPa	600 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Zoals gelast	20 °C	120 J
Zoals gelast	-50 °C	110 J

Typische lasmetaalanalyse (%)

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	1.8	0.7	0.003	0.015	13.5	23	0.1	0.1	0.07

Typische lasmetaalanalyse (%)

Nb	FN WRC-92
0.01	7

draad samenstelling

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.016	1.9	0.7	0.004	0.019	13.7	23.3	0.1	0.1	0.09

draad samenstelling

FN WRC-92
9

Afzetgegevens

Diameter	Ampère	Volt	Draadaanvoersnelheid	Afzetwaarde
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

Lasinstellingen

Draaddiameter
1.14 mm