

OK Autrod 16.38

A continuous solid corrosion resisting non-magnetic chromium-nickel-molybdenum wire for welding of stabilized and non-stabilized austenitic alloys of the same type as well as non magnetic steels. The alloy is corrosion resistant in seawater environment and has very good corrosion resistance to acids such as nitric acid. Excellent impact properties at low temperatures

Specifications

Classifications	EN ISO 14343-A : G 20 16 3 Mn L
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Alloy Type	Austenitic (7 % Mn - 20 % Cr - 16 % Ni - 3 % Mo)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	400 MPa	600 MPa	40 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-60 °C	90 J
As Welded	-110 °C	70 J
As Welded	-196 °C	40 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N
0.01	6.9	0.4	16.5	19.9	3.0	0.18

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (.040 in.)	80-190 A	16-24 V	2.9-8.4 m/min (114-331 in./min)	1.1-3.1 kg/h (2.4-6.8 lbs/h)
1.2 mm (.045 in.)	180-280 A	20-28 V	4.9-8.5 m/min (193-335 in./min)	2.6-4.5 kg/h (5.7-9.9 lbs/h)