

OK Autrod 13.16

OK Autrod 13.16 is a 1.3Cr-0.5Mo-alloyed (ER80S-B2), copper-coated, solid wire for the GMAW of creep-resistant steels of the same composition, but it is also suitable for welding high strength steels. The wire has a high purity chemistry with a guaranteed Brascato factor $X < 15$.

Specifications

Classifications	EN ISO 21952-B : G 55A 1CM SFA/AWS A5.28 : ER80S-B2
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Alloy Type	Low-alloyed, 1,3Cr-0,5Mo
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
Ar / 1-3% O₂ (M13) AWS			
Stress Relieved 1 hour(s) 620 °C	540 MPa	640 MPa	26 %

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	80-280 A	18-28 V	1.0-5.4 m/min	1.0-5.4 kg/h
1.2 mm	120-350 A	20-33 V	1.5-6.6 m/min	1.5-6.6 kg/h