

OK AUTROD 16.13



An austenitic stainless steel wire for welding
25 Cr, 20 Ni type of steels by SAW with OK Flux 10.92L



Classification AWS A5.9: ER 310

DESCRIPTION

OK AUTROD 16.13 is fully austenitic welding wire for submerged arc welding of heat resistant steels of the 25 Cr-20 Ni type which can withstand scaling at temperatures of upto 1100°C-1150°C. The arc and current characteristics of the wire help a smooth weld performance giving outstanding bead finish.

TYPICAL WIRE COMPOSITION (%)

C	Mn	Si	Cr	Ni	S	P
0.11	1.90	0.45	26.8	20.80	0.015	0.015

TYPICAL WELDMETAL COMPOSITION WITH OK FLUX 10.92L

Weldmetal Composition (%)				Mechanical Properties	
C	0.10	Si	0.40	YS	310 N/mm ²
Cr	26	S	0.015	UTS	540 N/mm ²
Mn	1.7	P	0.017	EL (L=4d)	36%
Ni	21			Impact (CVN) at -196°C	60J

PACKING DATA

Size (mm)	Packing 25 Kg
2.50	✓
3.15	✓

PACKING: The wires are packed in corrugated cardboard boxes.