

OK AUTROD 16.53



An extra low carbon 24% Cr, 13% Ni stainless steel wire for SAW



Classification AWS A5.9: ER 309L

DESCRIPTION

OK AUTROD 16.53 is 24% Cr, 13% Ni type bare stainless steel wire with extra low carbon for submerged arc welding and cladding of austenitic corrosion resisting steel. The arc and current carrying characteristics assure excellent weld appeal. OK AUTROD 16.53 is suitable for similar alloys in wrought or cast form and also for joining dissimilar steels such as "18 - 8" to mild steel or carbon steel or low alloy steel.

TYPICAL WIRE COMPOSITION (%)

| C | Mn | Si | Cr | Ni | S | P |
|------|-----|-----|----|----|-------|-------|
| 0.02 | 1.6 | 0.4 | 24 | 13 | 0.015 | 0.015 |

TYPICAL WELDMETAL COMPOSITION WITH OK FLUX 10.92L

| Weldmetal Composition (%) | | | | Mechanical Properties | |
|---------------------------|-------|----|-------|-----------------------|-----------------------|
| C | 0.025 | Si | 0.40 | YS | 440 N/mm ² |
| Cr | 24.00 | S | 0.015 | UTS | 600 N/mm ² |
| Mn | 1.8 | P | 0.017 | EL (L=4d) | 35% |
| Ni | 13.00 | | | Impact (CVN) at -60°C | 110J |

PACKING DATA

| Size (mm) | Packing 25 Kg |
|-----------|---------------|
| 2.50 | ✓ |
| 3.15 | ✓ |

PACKING: The wires are packed in corrugated cardboard boxes.