

## **OK Autrod 316LSi**

A continuous solid corrosion resisting chroumium-nickel-molybdenium wire for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo types.

OK Autrod 316LSi has a good general corrosion resistance, in particularly the alloy has very good resistance against corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risc of intergranular corrosion. The higher silicon content improves the welding properties, such as wetting. The alloy is widely used in the chemical and food processing industries as well as in ship building and various types of architectural structures.

Classifications Wire Electrode	SFA/AWS A5.9 : ER316LSi EN ISO 14343-A : G 19 12 3 L Si Werkstoffnummer : ~1.4430
Approvals	CE EN 13479 CWB ER316LSi DB 43.039.05 DNV:-GL VL 316 L (M13) VdTUV 04268 NAKS/HAKC 0.8-1.2 mm

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 12% Ni - 3% Mo - Low C - High Si
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Tensile Properties				
Condition	Yield Strength	Tensile Strength	Elongation	
As Welded	400 MPa	560 MPa	37 %	
Tested at 350°C.				
As Welded	340 MPa	440 MPa	26 %	

Typical Charpy V-Notch Properties			
Condition	Testing Temperature	Impact Value	
As Welded	20 °C	120 J	
As Welded	-60 °C	95 J	
As Welded	-110 °C	70 J	
As Welded	-196 °C	45 J	

Typical W	Veld Metal Ana	alysis %						
С	Mn	Si	s	P	Ni	Cr	Мо	Cu
0.02	1.8	0.8	0.015	0.015	12	18.5	2.7	0.1

Typical Wi	re Composition %						
С	Mn	Si	Ni	Cr	Мо	Cu	
0.01	1.8	0.9	12.2	18.4	2.60	0.12	

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	55-160 A	12-24 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

Recommend	ded Welding Parameters
Wire Diameter	r
0.6 mm	
1.14 mm	