

OK Autrod 316L

A continuous solid corrosion resisting chromium-nickel-molybdenum wire for welding of austenitic stainless alloys of 18% Cr - 8% Ni and 18% Cr - 10% Ni - 3% Mo-types. OK Autrod 316L has a good general corrosion resistance, particularly against corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. 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 : ER316L EN ISO 14343-A : G 19 12 3 L Werkstoffnummer : ~1.4430
Approvals	CE EN 13479

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
SHT (1050°C 0.5h)	350 MPa	590 MPa	42 %
As Welded	440 MPa	620 MPa	37 %
Tested at 350°C.			
As Welded	340 MPa	440 MPa	26 %
SHT (1050°C 0.5h)	250 MPa	430 MPa	31 %

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
0.02	1.8	0.4	0.015	0.015	12	18.5	2.7	0.1

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.01	1.7	0.4	12.0	18.2	2.6	0.04	7

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm (0.030 in.)	55-160 A	15-24 V	4.0-17.0 m/min (157-669 in./min)	1.0-4.1 kg/h (2.2-9.0 lb/h)
0.9 mm (0.035 in.)	55-160 A	15-24 V	4.0-17.0 m/min (157-669 in./min)	1.0-4.1 kg/h (2.2-9.0 lb/h)
1.0 mm (0.040 in.)	80-240 A	15-28 V	4.0-16.0 m/min (157-630 in./min)	1.5-6.0 kg/h (3.3-13. lb/h)
1.14 mm (0.045 in.)	80-240 A	15-28 V	4.0-16.0 m/min (157-630 in./min)	1.5-6.0 kg/h (3.3-13. lb/h)
1.2 mm (0.047 in.)	100-300 A	15-29 V	3.0-14.0 m/min (118-551 in./min)	1.6-7.5 kg/h (3.5-16. lb/h)
1.6 mm (1/16 in.)	230-375 A	23-31 V	5.5-9.0 m/min (217-354 in./min)	5.2-8.6 kg/h (11.5-19. lb/h)