

## OK Autrod 308LSi

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type. OK Autrod 308LSi has a good general corrosion resistance. The alloy has a low carbon content making it particularly recommended where there is a risk 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 for pipes, tubes and boilers.

|      |  |
|------|--|
| 焊丝分类 | SFA/AWS A5.9 : ER308LSi<br>EN ISO 14343-A : G 19 9 L Si<br>Werkstoffnummer : ~1.4316   |
| 认证   | BV 308L SA BT (M12)<br>CE EN 13479<br>CWB ER308LSi<br>DB 43.039.01<br>DNV-GL VL 308 L (M13)<br>NAKS/HAKC 0.8-1.2 mm<br>VdTUV 04267 |

认证根据工厂所在位置而有所不同。请联系伊萨了解更多信息。

|      |  |
|------|--|
| 合金类型 | Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C - High Si |
|------|--|

### 典型拉伸性能

| 条件                       | 屈服强度 (公制) | 抗拉强度 (公制) | 延伸率  |
|--------------------------|-----------|-----------|------|
| 焊态                       | 400 MPa   | 570 MPa   | 36 % |
| <b>Tested at 350° C.</b> |           |           |      |
| 焊态                       | 370 MPa   | 490 MPa   | 25 % |

### 夏比V型缺口冲击性能

| 条件 | 测试温度 (公制) | 冲击值   |
|----|-----------|-------|
| 焊态 | 20 °C     | 110 J |
| 焊态 | -60 °C    | 70 J  |
| 焊态 | -196 °C   | 45 J  |

### 全焊缝金属

| C    | Mn  | Si  | S     | P     | Ni | Cr | Mo  | Cu  |
|------|-----|-----|-------|-------|----|----|-----|-----|
| 0.01 | 1.8 | 0.8 | 0.015 | 0.015 | 10 | 20 | 0.1 | 0.1 |

### 焊丝成分

| C    | Mn  | Si  | Ni   | Cr   | Mo   | Cu   | Ferrite FN |
|------|-----|-----|------|------|------|------|------------|
| 0.01 | 1.8 | 0.9 | 10.5 | 19.9 | 0.15 | 0.10 | 9          |

### 熔敷数据

| 直径     | 安培        | 电压 V    | 送丝速度           | 熔敷率          |
|--------|-----------|---------|----------------|--------------|
| 0.8 mm | 55-160 A  | 15-24 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 | 23-29 V | 5.5-9.0 m/min  | 5.2-8.6 kg/h |

### 焊接参数

| 焊丝直径   |
|--------|
| 0.6 mm |



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### 焊接参数

焊丝直径

1.14 mm