

OK Autrod 309LSi

A continuous solid corrosion resistant chromium-nickel wire for welding of similar steels, wrought and cast steels of 23% Cr-12% Ni types. The alloy is also used for welding of buffer layers on CMn steels and welding of dissimilar joints. When using the wire for buffer layers and dissimilar joints it is necessary to control the dilution of the weld.

OK Autrod 309LSi has a good general corrosion resistance. The higher silicon content improves the welding properties, such as wetting.

Classificações	SFA/AWS A5.9 : FBTS SFA/AWS A5.9 : VdTUV 10020 SFA/AWS A5.9 : EN ISO 14343 G 23 12 Lsi SFA/AWS A5.9 : ER309LSi
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Tipo da Liga	Austenitic (with approx. 8 % ferrite) 24 % Cr - 13 % Ni - Low C
Gás de protecção	M12, M13 (EN ISO 14175)

Teste Charpy

Condição	Temperatura de Teste	Valor de Impacto
Como Soldado	20 °C	120 J
Como Soldado	-50 °C	110 J

Deposição

Diâmetro	Corrente	Tensão	Taxa de Deposição
0.8 mm	55-160 A	15-24 V	1.0-4.1 kg/h
0.9 mm	65-220 A	15-28 V	1.1-5.4 kg/h
1.0 mm	80-240 A	15-28 V	1.5-6.0 kg/h
1.2 mm	100-300 A	15-29 V	1.6-7.5 kg/h
1.6 mm	230-375 A	23-31 V	5.2-8.6 kg/h

Parâmetros de soldadura

Diâmetro do Arame	1.14 mm
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