

OK Autrod 309MoL SAW

S 23 12 2 L

Description

OK Autrod 309MoL is a stainless-steel, over-alloyed wire for submerged arc welding. It is suitable for joining stainless Cr-Ni and Cr-Ni-Mo steels 304, 309 or 316 to ensure corrosion resistance in the pulp and paper industry, for example. It is also suitable for dissimilar steels when alloying with Mo is essential. OK Autrod 309MoL can be used in combination with OK Flux 10.93 or OK Flux 10.92.

Classifications

EN 12072 S 23 12 2 L

Wire composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.6	22.0	14.8	2.7	<0.3

OK Autrod 310 SAW

ER310

Description

A continuous, solid, corrosion-resistant, chromium-nickel wire for welding heat-resistant austenitic steels of the 25% Cr, 20% Ni type. OK Autrod 310 has good general oxidation resistance, especially at high temperatures, due to its high Cr content. The alloy is fully austenitic and is therefore sensitive to hot cracking. Common applications include industrial furnaces and boiler parts, as well as heat exchangers. OK Autrod 310 can be used in combination with OK Flux 10.92.

Classifications

SFA/AWS A5.9 ER310
EN 12072 S 25 20

Wire composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu
0.1	0.5	1.8	26.0	21.0	<0.3	<0.3

OK Autrod 312 SAW

ER312

Description

A continuous, solid, corrosion-resistant, chromium-nickel wire for welding stainless steels of the 29% Cr, 9% Ni type. OK Autrod 312 has good oxidation resistance at high temperatures due to its high content of Cr. The alloy is widely used for joining dissimilar steels, especially if one of the components is fully austenitic, and for steels that are difficult to weld, i.e. machine components, tools and austenitic-manganese steels. OK Autrod 312 can be used in combination with OK Flux 10.93 or OK Flux 10.92.

Classifications

SFA/AWS A5.9 ER312
EN 12072 S 29 9

Wire composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu
<0.15	0.5	1.8	30.5	9.5	<0.3	<0.3