

OK Autrod 308H

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18% Cr - 8% Ni-type.

OK Autrod 308H has a good general corrosion resistance. The alloy has a high carbon content which makes this alloy suitable for applications used at higher temperatures. The alloy is used in chemical and petrochemical plants for welding of pipes, cyclones and boilers.

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| Классификации | AWS A5.9 : ER308H EN ISO 14343-A : G 19 9 H |
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| Тип сплава | Austenitic 19% Cr - 9% Ni - High C |
| Защитный газ | M12, M13 (EN ISO 14175) |

Хим. состав проволоки

| C | Mn | Si | Ni | Cr | N | Nb | FN WRC-92 |
|------|-----|-----|-----|------|------|------|-----------|
| 0.05 | 1.9 | 0.5 | 9.2 | 19.8 | 0.06 | 0.01 | 9 |

Данные наплавки

| Диаметр | Ток | В | Скорость подачи проволоки | Кэфф. наплавки |
|---------|-----------|---------|---------------------------|----------------|
| 0.8 mm | 50-140 A | 16-22 V | 3.4-11.0 m/min | 0.8-2.7 kg/h |
| 1.0 mm | 80-190 A | 16-24 V | 2.9-8.4 m/min | 1.1-3.1 kg/h |
| 1.2 mm | 180-280 A | 20-28 V | 4.9-8.5 m/min | 2.6-4.5 kg/h |