

OK TIGROD 16.53

An extra low carbon 24Cr-13Ni stainless steel solid rod for GTAW

Classification AWS A5.9: ER309L

DESCRIPTION

OK TIGROD 16.53 is a corrosion resistant, chromium-nickel alloyed solid rod for joining stainless steels to non-alloy or low-alloy steels and for welding austenitic stainless alloys of the 24Cr-13Ni types. The alloy is also used for welding buffer layers on C-Mn steels.

APPROVALS: NPC, PDIL & TOYO

WELDING CURRENT: DC-

SHIELDING GAS: Ar

TYPICAL PROPERTIES

Wire Composition (Wt.%)		All Weld Mechanical Properties	
C	0.03	YS (N/mm ²)	410
Si	0.45	UTS (N/mm ²)	580
Mn	1.75	Elongation (%)	35
Cr	23.50	Impact (CVN)	
Ni	12.20	@ -60°C (Joules)	100

PACKING DATA

Size (mm)	Length (mm)	Packing (5 Kg.)
1.6	1000	✓
2.0	1000	✓
2.5	1000	✓
3.15	1000	✓

PACKING: The rods are packed in tubes weighing 5 kg.