

OK Autrod 13.23 GMAW

ER80SNi1

Description

OK Autrod 13.23 is a 0.9Ni-alloyed (ER80S-Ni1), copper-coated, solid wire for the GMAW of low-temperature, fine-grained steels. The wire provides good impact toughness down to -50°C and is especially suitable for use in the offshore industry.

Welding current

DC(+)

Classifications

SFA/AWS A5.28 ER80SNi1

Wire composition

C	Si	Mn	Ni	Mo
0.1	0.6	1.0	0.9	0.3

Typical mech. properties all weld metal

Yield stress, MPa	480
Tensile strength, MPa	560
Elongation, %	30

Charpy V

Test temps, °C	Impact values, J
+20	150
0	130
-46	70
-60	20

Approvals

BV SA4Y40M

Welding parameters

Diameter, mm	Wire feed, m/min	Welding current, A	Arc voltage, V	Deposition rate kg weld metal/hour
0.8	2.0-10.8	40-170	16-22	0.4-2.6
1.0	2.7-14.7	80-280	18-28	1.0-5.4
1.2	2.7-12.4	120-350	20-33	1.5-6.6
1.6	3.1-8.1	225-480	26-38	3.3-11.6