



Please Note: Chemistry listed below for wire/strip are typical values only.



### OK Autrod ER308L

**AWS A5.9; ER308/308L, EN 12072, S 19 9 L**

A continuous, solid, corrosion-resistant, chromium-nickel wire. **OK Autrod ER308L** had good general corrosion resistance. The alloy had a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers. OK Autrod ER308L can be used in combination with OK Flux 10.93, OK Flux 10.94 or OK Flux 10.95.

C	Mn	Si	P	S	Cr	Ni	Mo	FN
0.02	1.80	0.40	-	-	20.0	7.0	< 0.3	8.0

### Arcaloy ER308L

**AWS A5.9 / ASME SFA A5.9; ER308/308L**

A continuous, solid, corrosion-resistant, chromium-nickel wire. **Arcaloy ER308L** had good general corrosion resistance. The alloy had a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers. Arcaloy ER308L can be used in combination with OK Flux 10.93, OK Flux 10.94 or OK Flux 10.95.

C	Mn	Si	P	S	Cr	Ni	Mo	FN
0.015	1.7	0.5	-	-	20	10	0.1	9.0

### Arcaloy ER308H

**AWS A5.9 / ASME SFA A5.9; ER308/308H**

A continuous, solid, corrosion-resistant, chromium-nickel wire for welding austenitic chromium-nickel alloys of the 18% Cr-8% Ni type. **Arcaloy ER308H** had good general corrosion resistance. The alloy has high carbon content, making it suitable for applications using higher temperatures. The alloy is used in the chemical and food-processing industries, as well as for pipes, tubes and boilers. Arcaloy ER308H can be used in combination with OK Flux 10.93 or OK Flux 10.95.

C	Mn	Si	P	S	Cr	Ni	Mo	FN
0.06	1.80	0.80	-	-	20.0	10.0	0.05	7.0

### OK Autrod ER309L

**AWS A5.9; ER309/309L; EN 12072, S 23 12 L**

A continuous, solid, corrosion-resistant, chromium-nickel wire for joining stainless steels to non-alloy or low-alloy steels and for welding austenitic stainless alloys of the 24% Cr, 13% Ni types. **OK Autrod ER309L** had good general corrosion resistance. When used for joining dissimilar materials, the corrosion resistance is of secondary importance. OK Autrod ER309L can be used in combination with OK Flux 10.93 or OK Flux 10.94.

C	Mn	Si	P	S	Cr	Ni	Mo	FN
0.02	1.50	0.40	-	-	24.0	13.0	0.1	10.0

### Arcaloy ER309L

**AWS A5.9 / ASME SFA A5.9; ER309/309L**

A continuous, solid, corrosion-resistant, chromium-nickel wire for joining stainless steels to non-alloy or low-alloy steels and for welding austenitic stainless alloys of the 24% Cr, 13% Ni types. **Arcaloy ER309L** had good general corrosion resistance. When used for joining dissimilar materials, the corrosion resistance is of secondary importance. Arcaloy ER309L can be used in combination with OK Flux 10.93 or OK Flux 10.94.

C	Mn	Si	P	S	Cr	Ni	Mo	FN
0.02	1.70	0.50	-	-	23.0	13.0	0.1	10.0



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**OK Autrod 316L**  
**AWS A5.9; ER316L, EN 12072, S 19 12 3 L**

A continuous, solid, corrosion-resistant, chromium-nickel-molybdenum wire for welding austenitic stainless alloys of the 18% Cr-8% Ni-3% Mo types. **OK Autrod ER316L** has good general corrosion resistance. In particular, the alloy has very good resistance to corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in chemical and food-processing industries, as well as shipbuilding and various types of architectural structure. OK Autrod ER316L can be used in combination with OK Flux 10.93 or OK Flux 10.95.

C	Mn	Si	P	S	Cr	Ni	Mo	FN
0.02	1.8	0.4	-	-	19	12	2.7	8.0

**Arcaloy ER316L**  
**AWS A5.9 / ASME SFA A5.9; ER316/316L**

A continuous, solid, corrosion-resistant, chromium-nickel-molybdenum wire for welding austenitic stainless alloys of the 18% Cr-8% Ni-3% Mo types. **Arcaloy ER316L** has good general corrosion resistance. In particular, the alloy has very good resistance to corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in chemical and food-processing industries, as well as shipbuilding and various types of architectural structure. Arcaloy ER316L can be used in combination with OK Flux 10.93 or OK Flux 10.95.

C	Mn	Si	P	S	Cr	Ni	Mo	FN
0.02	1.9	.50	-	0.007	19.0	13.0	2.30	8.0

**OK Autrod ER2209**  
**AWS A5.9; ER2209, EN 12072, S 22 9 3 NL**

A continuous, solid, corrosion-resistant, duplex wire for the GMA welding of austenitic-ferritic stainless alloys of the 22% Cr, 5% Ni, 3% Mo types. **OK Autrod 2209** ("Duplex") has high general corrosion resistance. In media containing chloride and hydrogen sulphide, the alloy has high resistance to intergranular, pitting and especially stress corrosion. The alloy is used in a variety of applications across all industrial segments. OK Autrod 2209 is usually GMAW welded with Ar/(1-3%) O<sub>2</sub> as the shielding gas. Former name of this product was OK Autrod 16.86.

C	Mn	Si	P	S	Cr	Ni	Mo	N	Cu	FN
0.02	1.70	0.50	-	-	22.50	8.50	3.30	0.20	0.15	45.0

**OK Autrod 2509**  
**AWS A5.9; ER2594, EN 12072, S 25 9 4 NL**

A continuous, solid, corrosion-resistant, "super duplex" wire for welding austenitic-ferritic stainless alloys of the 25% Cr, 10% Ni, 4% Mo, low C type. **OK Autrod ER2509** has high resistance to intergranular corrosion and pitting. The alloy is widely used in applications where corrosion resistance is of the utmost importance. The pulp and paper industry, offshore and gas industry are areas of interest. OK Autrod ER2509 can be used in combination with OK Flux 10.94.

C	Mn	Si	P	S	Cr	Ni	Mo	N	W	FN
0.01	0.40	0.40	-	-	25.0	9.80	4.0	0.30	< 1.0	50.0