

Exaton AXT (GTAW)

Exaton AXT is a filler metal of 307 type with increased manganese content, reducing the risk for fissuring / hot cracking that otherwise can be a problem in fully austenitic weld metals. It is suitable for joining work-hardenable steels, armor plates, austenitic stainless manganese steels and free-machining steels (such as ASTM 303) and stainless cr steels with max 18% Cr.

Specifications

Classifications	EN ISO 14343 : W 18 8 Mn SFA/AWS A5.9 : ER(307) modified
Approvals	CWB : 18 8 Mn

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (18 % Cr - 8 % Ni - 7 % Mn)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	460 MPa (67 ksi)	650 MPa (94 ksi)	41 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	140 J (104 ft-lb)
As Welded	-196 °C (-321 °F)	27 J (20 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.08	7	0.9	<=0.015	<=0.025	8	18	<=0.3	<=0.1	<=0.06