

Exaton 79S

Exaton 79S is a newly designed highly basic, agglomerated flux for electrosag strip cladding providing excellent slag removal and bead appearance. When used in combination Exaton Ni72HP (EQNiCr-3 grade) strip, it delivers a homogeneous corrosion resistant weld surfacing of components in the nuclear industry and chemical equipment – for example, tube sheets and closure heads of steam generators.

Specifications

Classifications	EN ISO 14174 : ES A FB 2B DC
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Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃
Density	nom: 1.0 kg/dm ³
Basicity Index	nom: 5.4

Classifications

Wire	AWS/EN	AWS - As Welded
Exaton Ni60	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)	-
Exaton Ni72HP	A5.14:EQNiCr-3/ 18274:B Ni 6082	A5.39: ESCLAD2-EQNiCr-3/NiCr-3 (mod)

Approvals

Combined with Wire

*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Ti
Exaton Ni60									
<=0.03	0.2	0.2	<=0.010	<=0.015	>=60	22	9	-	-
Exaton Ni72HP									
<=0.030	3	0.1	<=0.01	<=0.01	72	20	-	0.01	0.27

Typical Wire Composition %

Fe	Nb+Ta
Exaton Ni60	
<=1	3.5
Exaton Ni72HP	
0.33	2.70

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Nb
Exaton Ni60									
0.019	0.08	0.46	-	-	Bal.	21.8	9.2	0.05	3.3
Exaton Ni72HP									
-	-	-	-	-	-	-	-	-	-
Exaton Ni72HP 2 layers									
0.010	2.7	0.50	0.01	0.01	71.0	19.0	-	0.02	-

Typical Weld Metal Analysis %

Ti	Fe	Nb+Ta
Exaton Ni60		
-	2.1	-
Exaton Ni72HP		

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Typical Weld Metal Analysis %

Ti	Fe	Nb+Ta
0.05	-	2.9
Exaton Ni72HP 2 layers		
-	3.5	-