

Exaton 24.13.L

Exaton 24.13.L is suitable for joining stainless Cr-Ni steels of the 309 type, Cr-steels and dissimilar steels e.g. austenitic stainless steel to carbon or low-alloyed steels for service up to 320°C (610°F). Widely used as barrier layer between carbon/low alloy steel and different stainless grades in cladding operations. It is used for Submerged Arc Welding and the recommended flux is Exaton 15W.

Specifications

Classifications	EN ISO 14343-A : S 23 12 L SFA/AWS A5.9 : ER309L
Approvals	CE : EN 13479

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

Alloy Type	Austenitic (with approx. 9 % ferrite) 24 % Cr - 13 % Ni - Low C
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Typical Tensile Properties

Condition	Yield Strength
As Welded	16 MPa

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Co
<0.02	1.8	0.4	<0.015	<0.02	13.5	23.5	<0.3	<0.2	<0.1

Deposition Data

Length	Fusion time per electrode at 90% I max	Deposition Rate
2 mm	2 sec	2.1 kg/h

Recommended Welding Parameters

Current	Wire Diameter	TTW Dist.
80 A	1 mm	1 mm