

## Exaton 22.12.HT

Exaton 22.12.HT is an austenitic filler material for welding the high temperature steel grade Alleima 253 MA\*, UNS S30815. It is characterized by high creep strength, good resistance to oxidation and good weldability. It is used for Submerged Arc Welding in combination with Exaton Flux 15W. \* 253 MA is a trademark owned by Outokumpu OY.

| Specifications  |                                                        |
|-----------------|--------------------------------------------------------|
| Classifications | EN ISO 14343-A : S 21 10 N<br>Werkstoffnummer : 1.4835 |
| Approvals       | CE : EN 13479<br>UKCA : EN 13479                       |

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

| Typical Wire Composition % |     |     |        |       |      |      |     |      |     |
|----------------------------|-----|-----|--------|-------|------|------|-----|------|-----|
| C                          | Mn  | Si  | S      | P     | Ni   | Cr   | Mo  | Al   | Cu  |
| 0.07                       | 0.5 | 1.6 | 0.0007 | 0.020 | 10.2 | 21.0 | 0.1 | 0.01 | 0.1 |

| Typical Wire Composition % |      |       |      |        |           |      |
|----------------------------|------|-------|------|--------|-----------|------|
| N                          | Nb   | Ti    | Co   | B      | FN deLong | Ce   |
| 0.17                       | 0.01 | 0.005 | 0.05 | 0.0008 | 9         | 0.04 |