

Exaton 50SW

Exaton 50SW is a basic agglomerated flux with low silicon pickup. It gives good slag removal, good tie-ins and a finely rippled surface. It is suitable for welding with either wire or strip electrodes of nickel alloy type. It is particularly suitable for surfacing with Exaton Ni72HP strip electrodes (EQNiCr-3 type). Typical applications for flux Exaton 50SW are found in nuclear and chemical equipment fields. It is also suitable for dissimilar material welding of nickel alloy grades to stainless steel grades.

Spezifikationen	
Klassifikationen	EN ISO 14174 : S A AF 2

Schweißstrom	900 A (Using 60x0.5 mm strip)
Schlackentyp	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Dichte	nom: 1.2 Kg/l
Basizitätsgrad	nom: 2.4

Klassifikationen	
Draht	EN/ISO/AWS
Exaton Ni41Cu	A5.14:ERNiFeCr-1/ 18274:S Ni 8065
Exaton Ni72HP	A5.14:ERNiCr-3/ 18274:S Ni 6082 (NiCr20Mn3Nb)

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

Typische Schweißgutrichtanalyse %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton Ni41Cu									
<=0.030	0.8	0.3	<=0.010	<=0.02	40.0	21.5	2.8	2.1	-
Exaton Ni72HP									
0.01	3.0	0.4	0.005	0.009	72.0	19.6	0.1	0.02	-

Typische Schweißgutrichtanalyse %			
Ti	Co	Fe	Nb+Ta
Exaton Ni41Cu			
-	-	30.0	-
Exaton Ni72HP			
0.15	0.02	1.0	2.2

Drahtzusammensetzung									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton Ni41Cu									
<=0.025	1.0	<=0.3	<=0.010	<=0.025	>=42.0	23.0	3.0	2.3	-
Exaton Ni72HP									
<=0.03	3.0	0.1	<=0.010	<=0.010	72.5	20.0	<=0.2	<=0.05	<=0.05

Drahtzusammensetzung			
Ti	Co	Fe	Nb+Ta
Exaton Ni41Cu			
-	-	>=22.0	-
Exaton Ni72HP			
0.4	<=0.10	<=1.0	2.6

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Typische mech. Eigenschaften					
Draht	Zustand	Streckgrenze	Zugfestigkeit	Dehnung	Kerbschlagarbeit KV
Exaton Ni72HP	Unbehandelt	320 MPa	600 MPa	40 %	120 J @ 20 °C 110 J @ -196 °C