

Exaton 47S

Exaton 47S est un flux de soudage hautement basique pour le rechargement en bande sous laitier électroconducteur. Il offre un piquage du laitier et un aspect du cordon de soudure excellents avec des électrodes en bande alliées au niobium également. Le Flux Exaton 47S s'utilise avec des électrodes en bande en acier au chrome, chrome-nickel et chrome-nickel-molybdène avec ou sans niobium. La basicité élevée du flux Exaton 47S le rend particulièrement adapté aux rechargements en acier inoxydable duplex, super duplex et entièrement austénitiques.

Caractéristiques	
Classements	EN ISO 14174 : ES A FB 2B

Courant de soudage	1700 A (Using 60x0.5 strip)
Type de laitier	Fluoride basic CaF ₂ -Al ₂ O ₃
Densité	nom: 1.0 Kg/l
Index d'alcalinité	nom: 4.0

Condition : Volts 25 V , Volume Flux/1 kg (2.2 lb) Wire DC+ 0.5 kg , Ampères 1250 A , Vitesse de déplacement 9 m/h

Classifications		
Fil	AWS/EN	AWS
Exaton 19.12.3.L	A5.9:EQ316L/ 14343-A:B 19 12 3 L	-
Exaton 19.13.4.L	A5.9:EQ317L/ 14343-A:B 19 13 4 L	-
Exaton 19.9.L	A5.9:EQ308L/ 14343-A:B 19 9 L	-
Exaton 19.9.LNb	A5.9:EQ347/ 14343-A:B 19 9 Nb	-
Exaton 21.11.LNb	A5.9:EQ?309LNb?/ 14343-A:B 22 11 L Nb	A5.39: ESCLAD1-EQ309L(mod)/347
Exaton 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L	-
Exaton 22.11.L	A5.9:EQ(309L)/ 14343-A:B 22 11 L	A5.39: ESCLAD1-EQ309L(Mod)/308L
Exaton 22.8.3.L	A5.9:EQ2209/ 14343-A:B 22 9 3 N L	-
Exaton 24.13.L	A5.9:EQ309L/ 14343-A:B 23 12 L	-
Exaton 24.13.LNb	A5.9:EQ?309LNb?/ 14343-A:B 23 12 Nb	-
Exaton 25.22.2.LMn	14343-A:B 25 22 2 N L	-

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

Composition du fil									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L									
<=0.020	1.8	0.4	<=0.020	<=0.020	13	18.5	2.9	<=0.3	-
Exaton 19.13.4.L									
<=0.02	1.5	0.4	<=0.020	<=0.020	14	19	3.6	<=0.3	-
Exaton 19.9.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	10	20	<=0.3	<=0.1	-
Exaton 19.9.LNb									
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-
Exaton 21.11.LNb									
<=0.015	1.8	0.2	<=0.020	<=0.020	11	21	<=0.3	<=0.3	-
Exaton 21.13.3.L									
<=0.015	1.8	0.2	<=0.015	<=0.020	13.5	20.5	2.9	<=0.3	-
Exaton 22.11.L									
<=0.015	1.8	0.2	<=0.020	<=0.020	11.5	21	<=0.3	<=0.1	-
Exaton 22.8.3.L									
<=0.020	1.6	0.5	<=0.015	<=0.020	9	23	3.1	-	0.15

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Composition du fil									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 24.13.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	-
Exaton 24.13.LNb									
<=0.02	2	0.3	<=0.020	<=0.020	12.5	24	<=0.3	<=0.3	-
Exaton 25.22.2.LMn									
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	-	0.13

Composition du fil	
Nb	FN WRC-92
Exaton 19.12.3.L	
-	8
Exaton 19.13.4.L	
-	7
Exaton 19.9.L	
-	12
Exaton 19.9.LNb	
0.5	11
Exaton 21.11.LNb	
0.55	14
Exaton 21.13.3.L	
-	13
Exaton 22.11.L	
-	13
Exaton 22.8.3.L	
-	50
Exaton 24.13.L	
-	15
Exaton 24.13.LNb	
0.75	22

Analyse du métal déposé									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	12	18.2	2.3	-	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"									
<=0.03	-	-	-	-	13.2	18.5	3.4	-	-
Exaton 19.13.4.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	13	18.5	3.2	-	-
Exaton 19.9.L 1st layer with "22.11.L"									
<=0.030	-	-	-	-	10	19.5	-	-	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")									
0.01	1.2	0.4	0.009	0.014	10.5	19.2	0.1	0.06	0.03
Exaton 21.11.LNb (1-layer)									
0.02	1.3	0.5	0.001	0.01	10.1	19.3	0.1	0.03	0.05
Exaton 21.13.3.L (1 layer)									
0.02	1.1	0.4	0.002	0.013	12.5	18.7	2.7	0.06	0.03
Exaton 22.11.L									

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Analyse du métal déposé									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.06	-	-	-	-	9.7	18.5	-	-	-
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.0	-	0.15
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.1	-	0.16
Exaton 24.13.L									
0.03	1.4	0.54	0.003	0.015	10.9	19.0	0.10	0.03	0.04
Exaton 24.13.LNb (1 layer)									
0.03	1.5	0.4	0.002	0.011	10.7	20.8	0.2	0.04	0.04
Exaton 25.22.2.LMn (2 layers)									
0.02	3.5	0.4	0.002	0.016	22.0	24.6	2.0	-	0.14

Analyse du métal déposé		
Nb	FN WRC-92	Nb+Ta
Exaton 19.12.3.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.9.L 1st layer with "22.11.L"		
-	8	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")		
-	8	0.3
Exaton 21.11.LNb (1-layer)		
0.4	5	-
Exaton 21.13.3.L (1 layer)		
-	8	-
Exaton 22.11.L		
-	6	-
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 24.13.L		
-	3	-
Exaton 24.13.LNb (1 layer)		
-	13	0.6
Exaton 25.22.2.LMn (2 layers)		
-	0	-