

Exaton 69S

69S is a highly basic, agglomerated flux for electrosag strip surfacing. It gives excellent slag removal and bead appearance. Flux 69S is used together with strip electrodes of nickel alloy type, such as EQNiCr-3, EQNiCrMo-3, EQNiFeCr-1 and ERNiCrFe-7 or similar.

Specifications

Classifications	EN ISO 14174 : ES A FB 2B
Welding Current	2500 A (Using 60x0.5 mm strip)
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃
Density	nom: 1.0 Kg/l
Basicity Index	nom: 5.4

Classifications

Wire	AWS/EN
Exaton Ni41Cu	A5.14:EQNiFeCr-1/ 18274:B Ni 8065
Exaton Ni56 ESW	A5.14:EQNiCrMo-4/ 18274:B Ni6276 (NiCr15Mo16Fe6W4)
Exaton Ni60	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)
Exaton Ni72HP	A5.14:EQNiCr-3/ 18274:B Ni 6082

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 Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
Exaton Ni41Cu Alloy type 825 (1 layer)									
0.029	0.57	0.46	-	-	38.5	19.9	2.7	-	1.9
Exaton Ni41Cu Alloy type 825 (2 layer)									
0.021	0.55	0.47	-	-	41.4	21.7	2.8	-	2.1
Exaton Ni56 ESW									
<0.02	0.1	<0.4	<0.01	<0.02	59	15.6	15.9	<0.05	<0.1
Exaton Ni60 Alloy Type 625 (1 layer)									
0.04	0.07	0.50	-	-	Bal.	20.3	8.2	-	0.01
Exaton Ni60 Alloy Type 625 (2 layer)									
0.02	0.05	0.50	-	-	-	21.0	8.5	-	0.01

Typical Weld Metal Analysis %

Nb	Co	W	Fe	Nb+Ta
Exaton Ni41Cu Alloy type 825 (1 layer)				
0.01	-	-	34	-
Exaton Ni41Cu Alloy type 825 (2 layer)				
0.01	-	-	30	-
Exaton Ni56 ESW				
-	<0.1	3.8	5	-
Exaton Ni60 Alloy Type 625 (1 layer)				
-	-	-	5.8	2.8
Exaton Ni60 Alloy Type 625 (2 layer)				
-	-	-	0.9	3.0

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Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
Exaton Ni41Cu									
<=0.025	1.0	0.3	<=0.010	<=0.025	>=42	23	3	-	2.3
Exaton Ni56 ESW									
<=0.02	0.2	0.05	<0.01	<0.01	>=50	16	16	<0.05	<0.1
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

Typical Wire Composition %				
Ti	Co	W	Fe	Nb+Ta
Exaton Ni41Cu				
-	-	-	>=22	-
Exaton Ni56 ESW				
-	<0.1	4	5	-
Exaton Ni60				
-	-	-	<=1	3.5
Exaton Ni72HP				
0.27	-	-	0.33	2.70