

Exaton AXT (GMAW)

Exaton AXT is a filler metal with increased manganese content, reducing the risk for fissuring / hot cracking that otherwise can be a problem in fully austenitic weld metals. It is suitable for joining work-hardenable steels, armor plates, austenitic stainless manganese steels and stainless cr steels with max 18% Cr.

Specifications

Classifications	EN ISO 14343 : G 18 8 Mn SFA/AWS A5.9 : ER(307) modified
Approvals	CE : EN 13479 CWB DB : 43.118.10

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	460 MPa (67 ksi)	650 MPa (94 ksi)	41 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	140 J (104 ft-lb)
As Welded	-196 °C (-321 °F)	27 J (20 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.08	7	0.9	<=0.015	<=0.025	8	18	<=0.3	<=0.1	<=0.06