

Exaton 19.12.3.L

Exaton 19.12.3.L is a chromium-nickel-molybdenum strip electrode used for electro-slag welding (ESW) or submerged arc welding (SAW) to deposit a second layer corrosion resistant alloy of 19%Cr/12%Ni/3%Mo composition on carbon- and low alloyed steels. The buffer layer is deposited using an over-alloyed consumable, such as 21.13.3.L, 22.11.L or 24.13.L. Recommended fluxes for ESW are Exaton 47S and Exaton 49S, whilst Exaton 10SW for SAW. Exaton 19.12.3.L is also suitable for a single layer solution in combination with OK Flux 10.26.

Specifications

Classifications	EN ISO 14343-A : B 19 12 3 L SFA/AWS A5.9 : EQ316L
Approvals	CE : EN 13479 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	Cu	FN WRC-92
<=0.020	1.8	0.4	<=0.020	<=0.020	13	18.5	2.9	<=0.3	8