

Exaton 69S

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

Spezifikationen

Klassifikationen	EN ISO 14174 : ES A FB 2B
Schweißstrom	2500 A (Using 60x0.5 mm strip)
Schlackentyp	Fluoride basic CaF ₂ -Al ₂ O ₃
Dichte	nom: 1.0 Kg/l
Basizitätsgrad	nom: 5.4

Klassifikationen

Draht	EN/ISO/AWS
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

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	V	Cu
Exaton Ni41Cu Alloy type 825 (2 layer)									
0.021	0.55	0.47	-	-	41.4	21.7	2.8	-	2.1
Exaton Ni41Cu Alloy type 825 (1 layer)									
0.029	0.57	0.46	-	-	38.5	19.9	2.7	-	1.9
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 (2 layer)									
0.02	0.05	0.50	-	-	-	21.0	8.5	-	0.01
Exaton Ni60 Alloy Type 625 (1 layer)									
0.04	0.07	0.50	-	-	Bal.	20.3	8.2	-	0.01

Typische Schweißgutrichtanalyse %

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

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Drahtzusammensetzung									
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

Drahtzusammensetzung				
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