

Exaton 10SW

Exaton 10SW is a chromium-compensating agglomerated flux giving good slag removal and a fine bead appearance. It is suitable for welding with wire and strip electrodes of the chromium & chromium-nickel and chromium-nickel-molybdenum steel types either with or without niobium. Exaton 10SW is an all round flux which can be used for many applications varying from surfacing continuous caster rolls to large components in chemical plants.

Spezifikationen

Klassifikationen	EN ISO 14174 : S A CS 2 Cr
Schweißstrom	1200 A (Using 60x0.5 mm strip)
Schlackentyp	Calcium silicate SiO ₂ -MgO-Al ₂ O ₃ -(CaF ₂)
Dichte	nom: 1.0 kg/l
Basizitätsgrad	nom: 1.0

Pulververbrauch

Spannung	Pulververbrauch / 1 kg (2,2 lb) Draht DC+
34 V	0.7 kg
30 V	0.55 kg
26 V	0.4 kg
38 V	0.9 kg

Zustand : Abmessung 4.0 mm , A 580 A , Fahrgeschwindigkeit 33 m/h

Klassifikationen

Draht	EN/ISO/AWS	AWS - unbehandelt
Exaton 19.12.3.L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F80A10-ER316L/316L
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:ER308L/ 14343-A:S 19 9 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 19.9.Nb	A5.9:ER347/ 14343-A:S 19 9 Nb	-
Exaton 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L	-
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	-

Zulassungen/Eignungsprüfungen

Draht	VdTÜV
Exaton 19.9.L	•
Exaton 19.9.LNb	•
Exaton 19.9.Nb	•
Exaton 22.8.3.L	•

Drahtzusammensetzung

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	-

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Drahtzusammensetzung									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.9.LNb									
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-
Exaton 19.9.Nb									
0.04	1.3	0.35	0.012	0.015	9.5	19.5	0.03	0.11	0.06
Exaton 21.13.3.L									
<=0.015	1.8	0.2	<=0.015	<=0.020	13.5	20.5	2.9	<=0.3	-
Exaton 22.8.3.L									
<=0.020	1.6	0.5	<=0.015	<=0.020	9	23	3.1	-	0.15
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	-

Drahtzusammensetzung					
Nb	Co	FN deLong	FN WRC	FN WRC-92	Nb+Ta
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 19.9.Nb					
0.6	0.1	5	5	-	0.6
Exaton 21.13.3.L					
-	-	-	-	13	-
Exaton 22.8.3.L					
-	-	-	-	50	-
Exaton 24.13.L					
-	-	-	-	15	-
Exaton 24.13.LNb					
0.75	-	-	-	22	-

Typische Schweißgutrichtanalyse %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L (Layer 1 with "24.13.L" & Layer 2 with "19.12.3.L")									
0.02	0.8	0.7	-	-	11.5	19.0	2.2	-	0.06
Exaton 19.13.4.L Layer 1 with "21.13.3.L"									
<=0.04	-	-	-	-	13	18.5	3.3	-	-
Exaton 19.9.L 1st layer with "24.13.L"									
<=0.03	-	-	-	-	10.0	19.7	-	-	-
Exaton 19.9.LNb (Layer 1 with "24.13.LNb")									
0.02	0.8	0.6	-	-	10.4	21.0	0.0	-	0.05
Exaton 19.9.Nb Layer 1 with "24.13.LHF" & 2 layers with "19.9.Nb"									
0.04	0.6	1.0	0.01	0.01	9.2	19.0	0.01	0.1	0.06
Exaton 22.8.3.L Layer 1 with "24.13.L" & 2 layers with "22.8.3.L"									

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Typische Schweißgutrichtanalyse %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.03	-	-	-	-	8.5	22.7	2.9	-	0.16
Exaton 24.13.L Layer 1 with "24.13.L"									
<=0.07	-	-	-	-	10.5	19.2	-	-	-
Exaton 24.13.LNb									
<=0.06	-	-	-	-	9.7	19.2	-	-	-

Typische Schweißgutrichtanalyse %

Nb	FN WRC-92	Nb+Ta
Exaton 19.12.3.L (Layer 1 with "24.13.L" & Layer 2 with "19.12.3.L")		
0	-	-
Exaton 19.13.4.L Layer 1 with "21.13.3.L"		
-	5	-
Exaton 19.9.L 1st layer with "24.13.L"		
-	8	-
Exaton 19.9.LNb (Layer 1 with "24.13.LNb")		
0.3	-	-
Exaton 19.9.Nb Layer 1 with "24.13.LHF" & 2 layers with "19.9.Nb"		
0.3	-	0.3
Exaton 22.8.3.L Layer 1 with "24.13.L" & 2 layers with "22.8.3.L"		
-	40	-
Exaton 24.13.L Layer 1 with "24.13.L"		
-	6	-
Exaton 24.13.LNb		
-	6	-

Typische mech. Eigenschaften

Draht	Zustand	Streckgrenze	Zugfestigkeit	Dehnung	Kerbschlagarbeit KV
Exaton 19.12.3.L	Unbehandelt	420 MPa	580 MPa	32 %	69 J @ 20 °C 60 J @ -40 °C 55 J @ -70 °C 50 J @ -196 °C
Exaton 19.9.L	Unbehandelt	400 MPa	580 MPa	38 %	69 J @ 20 °C 59 J @ -40 °C 40 J @ -196 °C
Exaton 19.9.Nb	Unbehandelt Joining	440 MPa	625 MPa	38 %	72 J @ 20 °C 61 J @ -40 °C 34 J @ -196 °C