

Exaton 15W

Exaton 15W 是一种适用于埋弧焊的碱性焊剂，具有良好的脱渣性能和良好的表面成型。由于其碱度较高，使其适用于要求高冲击强度的奥氏体和双相不锈钢的焊接。由于对钨的烧损很小，该焊剂与稳定的焊丝一起使用时优势明显。

Exaton15w 是一种高性能焊剂，在化工、石油化工和石油天然气等诸多领域有着广泛的应用。由于Exaton15w 具有高度中性，可确保最平衡的微观结构，因此特别适用于Exaton系列的双相钢焊丝（例如22.8.3.L / 25.10.4.L）。

基于其焊接特性（不局限于良好的表面成型和焊渣自动脱落等），该焊剂还可以配合Ni-Cr-Mo-3 焊丝用于一些其它应用（例如，焊接和堆焊）。

技术参数

分类	EN ISO 14174 : S A AF 2
批准	CE : EN 13479 UKCA : EN 13479

批准基于工厂位置。请联系伊萨了解更多信息。

焊接电流	1200 A (Using 60x0.5 mm strip)
焊渣类型	Fluoride basic CaF ₂ -Al ₂ O ₃ -SiO ₂
密度	nom: 1.0 Kg/l
碱度指数	nom: 1.9

焊剂消耗

电压 V	kg焊剂/ kg焊丝 DC+直流反接
34 V	0.8 kg
30 V	0.6 kg
26 V	0.5 kg
38 V	1.0 kg

条件：尺寸 4.0 mm , 安培 580 A , 行走速度 33 m/h

分类

焊丝	AWS/EN	AWS - 焊态
Exaton 16.5.1	14343-A:S 16 5 1	-
Exaton 19.12.3.L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F75A15-ER316L/316L
Exaton 19.12.3.LCRYO	A5.9:ER316L/ 14343-A:S (19 12 3 L); 14343-B:SS316L	-
Exaton 19.9.L	A5.9:ER308L/ 14343-A:S 19 9 L	-
Exaton 19.9.Nb	A5.9:ER347/ 14343-A:S 19 9 Nb	A5.39: F90A15-ER347/347
Exaton 20.25.5.LCu	A5.9:ER385/ 14343-A:S 20 25 5 Cu L	-
Exaton 22.12.HT	14343-A:S 21 10 N	-
Exaton 22.15.3.L	A5.9:ER309LMo (mod)/ 14343-A:S 23 12 2 L	-
Exaton 22.8.3.L	A5.9:ER2209/ 14343-A:S 22 9 3 N L	A5.39: F115A15-ER2209/2209
Exaton 24.13.LHF	A5.9:ER309L/ 14343-A:S 23 12 L	-
Exaton 24.13.LNb	A5.9:ER309L (mod)/ 14343-A:S 23 12 Nb	-
Exaton 25.10.4.L	A5.9:ER2594/ 14343-A:S 25 9 4 N L	A5.39: F120A8-ER2594/2594
Exaton 25.22.2.LMn	14343-A:S 25 22 2 N L	-
Exaton 27.31.4.LCu	A5.9:ER383/ 14343-A:S 27 31 4 Cu L	-
Exaton Ni56	A5.14:ERNiCrMo-4/ 18274:S Ni 6276 (NiCr15Mo16Fe6W4)	-
Exaton Ni60 SAW	A5.14:ERNiCrMo-3/ 18274:S Ni 6625 (NiCr22Mo9Nb)	-

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认证

焊丝	BV	DNV-GL	VdTV
Exaton 19.12.3.L	-	-	•
Exaton 19.9.L	-	-	•
Exaton 19.9.Nb	-	-	•
Exaton 22.8.3.L	•	•	•
Exaton 25.10.4.L	•	•	•

全焊缝金属

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
Exaton 16.5.1									
0.02	0.9	0.7	0.012	0.025	5.5	16	1	-	-
Exaton 19.12.3.L									
0.01	1.5	0.5	0.01	0.02	12.3	18.1	2.6	-	0.08
Exaton 19.12.3.LCRYO									
0.021	1.5	0.5	0.003	0.023	12.8	18	2.3	-	0.07
Exaton 19.9.L									
0.02	1.2	0.6	0.012	0.025	10	19.5	0.15	-	0.1
Exaton 19.9.Nb									
-	-	-	-	-	-	-	-	-	-
Exaton 19.9.Nb Current: DC+, 400A, 28V, welding speed 48cm/min									
0.03	1.18	0.5	0.011	0.018	9.3	18.83	0.032	-	0.097
Exaton 20.25.5.LCu									
0.01	1.4	0.5	-	-	25	19.6	4.5	-	-
Exaton 22.8.3.L Current: DC+, 400A, 28V, 45cm/min									
0.01	1.2	0.004	-	0.018	8.36	22.6	2.95	-	0.12
Exaton 24.13.LNb									
<=0.020	1.2	0.7	<=0.015	<=0.025	12	23.5	-	-	-
Exaton 25.10.4.L									
-	-	-	-	-	-	-	-	0.05	0.1
Exaton 25.10.4.L Current: DC+, 350A, 28V, 48cm/min									
<=0.020	0.3	0.6	<=0.015	<=0.020	9.6	24.5	4	-	-
Exaton 25.22.2.LMn									
0.02	4.0	0.1	-	-	22.0	24.5	2.1	-	0.1
Exaton 27.31.4.LCu									
0.01	1.4	0.4	0.003	0.01	31.3	26.3	3.5	-	1.0
Exaton Ni56									
0.01	0.4	0.20	-	-	Bal	15.1	15.6	0.1	-
Exaton Ni60 SAW									
-	-	-	0.005	0.015	-	-	-	-	0.1
Exaton Ni60 SAW Current: DC+, 400A, 28V, travel speed: 25 m/h.									
0.02	0.2	0.4	-	-	-	22	9	-	-

全焊缝金属

N	Nb	Ti	Co	PRE	FN deLong	FN WRC	FN WRC-92	W	Fe
Exaton 16.5.1									
-	-	-	-	-	-	-	-	-	-

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全焊缝金属

N	Nb	Ti	Co	PRE	FN deLong	FN WRC	FN WRC-92	W	Fe
Exaton 19.12.3.L									
0.05	-	-	-	-	-	-	9	-	-
Exaton 19.12.3.LCRYO									
0.06	-	-	-	-	-	-	3	-	-
Exaton 19.9.L									
0.05	-	-	0.1	-	-	-	6	-	-
Exaton 19.9.Nb									
-	-	-	-	-	6	6	-	-	-
Exaton 19.9.Nb Current: DC+, 400A, 28V, welding speed 48cm/min									
0.063	0.56	-	0.14	-	-	-	-	-	-
Exaton 20.25.5.LCu									
-	-	-	-	-	-	-	-	-	-
Exaton 22.8.3.L Current: DC+, 400A, 28V, 45cm/min									
0.135	<0.003	-	-	34	-	-	52	-	-
Exaton 24.13.LNb									
-	0.7	-	-	-	-	-	-	-	-
Exaton 25.10.4.L									
-	<0.01	<0.001	0.04	42	-	-	55	<0.01	-
Exaton 25.10.4.L Current: DC+, 350A, 28V, 48cm/min									
0.21	-	-	-	-	-	-	-	-	-
Exaton 25.22.2.LMn									
0.12	-	-	-	-	-	-	-	-	-
Exaton 27.31.4.LCu									
0.06	-	-	-	-	-	-	-	-	-
Exaton Ni56									
-	-	-	0.1	-	-	-	-	3.6	6.8
Exaton Ni60 SAW									
-	-	-	-	-	-	-	-	-	-
Exaton Ni60 SAW Current: DC+, 400A, 28V, travel speed: 25 m/h.									
-	-	-	-	-	-	-	-	-	5

全焊缝金属

Nb+Ta									
Exaton 19.9.Nb Current: DC+, 400A, 28V, welding speed 48cm/min									
0.6									
Exaton Ni60 SAW									
3									

焊丝成分

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
Exaton 16.5.1									
0.01	1.4	0.3	0.009	0.015	5.5	16.2	1.0	0.04	0.006
Exaton 19.12.3.L									
<0.020	1.8	0.4	<0.015	<0.025	12.5	18.5	2.6	-	-
Exaton 19.12.3.LCRYO									
0.02	1.8	0.4	0.003	0.012	13.3	18.5	2.3	-	0.01

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焊丝成分

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
Exaton 19.9.L									
<0.025	1.8	0.4	<0.015	<0.025	10.0	20	<0.5	-	-
Exaton 19.9.Nb									
0.04	1.3	0.35	0.012	0.015	9.5	19.5	0.03	-	-
Exaton 20.25.5.LCu									
<=0.020	1.8	0.4	<=0.015	<=0.015	25	20	4.5	-	-
Exaton 22.12.HT									
0.07	0.5	1.6	0.0007	0.020	10.2	21.0	0.1	-	0.01
Exaton 22.15.3.L									
<=0.025	1.5	0.4	<=0.015	<=0.025	15	21.5	2.7	-	-
Exaton 22.8.3.L									
0.012	1.5	0.5	0.0007	0.018	8.6	23	3.2	0.05	-
Exaton 24.13.LHF									
0.01	1.8	0.4	0.001	0.011	13.4	23.8	0.04	0.05	-
Exaton 24.13.LNb									
0.01	2.1	0.3	0.001	0.013	12.5	24	0.02	-	-
Exaton 25.10.4.L									
0.012	0.4	0.3	0.0005	0.015	9.5	25	4	0.05	-
Exaton 25.22.2.LMn									
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	-	-
Exaton 27.31.4.LCu									
0.01	1.7	0.1	0.001	0.012	31.0	27.0	3.5	-	0.04
Exaton Ni56									
0.007	0.5	0.02	0.002	0.005	58	16	16	0.03	-

焊丝成分

Cu	N	Nb	Ti	Co	B	PRE	FN deLong	FN WRC	FN WRC-92
Exaton 16.5.1									
0.01	0.02	0.01	0.01	0.03	-	-	-	-	-
Exaton 19.12.3.L									
-	<0.060	-	-	-	-	-	-	-	-
Exaton 19.12.3.LCRYO									
0.06	0.06	0.01	0.005	0.03	-	-	-	-	2
Exaton 19.9.L									
<0.3	<0.08	-	-	<0.20	-	-	-	-	-
Exaton 19.9.Nb									
0.11	0.06	0.6	-	0.1	-	-	5	5	-
Exaton 20.25.5.LCu									
1.5	-	-	-	-	-	-	-	-	-
Exaton 22.12.HT									
0.1	0.17	0.01	0.005	0.05	0.0008	-	9	-	-
Exaton 22.15.3.L									
-	-	-	-	-	-	-	-	-	-
Exaton 22.8.3.L									
0.09	0.15	0.01	0.003	0.04	-	37	-	-	55
Exaton 24.13.LHF									

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焊丝成分

Cu	N	Nb	Ti	Co	B	PRE	FN deLong	FN WRC	FN WRC-92
0.03	0.05	0.03	0.004	0.03	-	-	14	13	-
Exaton 24.13.LNb									
0.01	0.05	0.8	0.005	0.02	-	-	-	-	-
Exaton 25.10.4.L									
0.07	0.25	0.01	0.003	0.04	-	42	-	-	50
Exaton 25.22.2.LMn									
0.05	0.13	-	-	-	-	-	-	-	0
Exaton 27.31.4.LCu									
1.0	0.05	0.02	-	0.03	-	-	-	-	-
Exaton Ni56									
0.02	-	-	-	0.02	-	-	-	-	-

焊丝成分

Ce	W	Fe	Nb+Ta
Exaton 19.9.Nb			
-	-	-	0.6
Exaton 22.12.HT			
0.04	-	-	-
Exaton 22.8.3.L			
-	0.01	-	-
Exaton 25.10.4.L			
-	0.01	-	-
Exaton Ni56			
-	3.7	5.8	-

机械性能典型值

焊丝	条件	屈服强度	抗拉强度	延伸率	夏比V形缺口
Exaton 16.5.1	PWHT (4 hour(s))	490 MPa	850 MPa	20 %	40 J @ 20 ° C
Exaton 19.12.3.L	焊态 2.4mm Feed Speed 48cm/min 350A DC+ 28V	390 MPa	545 MPa	42 %	65 J @ -60 ° C 52 J @ -110 ° C 27 J @ -196 ° C
Exaton 19.12.3. LCRYO	焊态	415 MPa	560 MPa	34 %	88 J @ -60 ° C 70 J @ -110 ° C 46 J @ -196 ° C
Exaton 19.9.L	焊态	390 MPa	560 MPa	35 %	90 J @ 20 ° C 35 J @ -196 ° C
Exaton 19.9.Nb	焊态	470 MPa	640 MPa	39 %	95 J @ 20 ° C 40 J @ -110 ° C 25 J @ -196 ° C
Exaton 20.25.5.LCu	焊态	345 MPa	550 MPa	40 %	125 J @ 20 ° C 100 J @ -196 ° C
Exaton 22.12.HT	焊态	400 MPa	580 MPa	35 %	120 J @ 20 ° C
Exaton 22.15.3.L	焊态	400 MPa	600 MPa	40 %	140 J @ 20 ° C
Exaton 22.8.3.L	焊态	650 MPa	810 MPa	29 %	85 J @ -40 ° C 65 J @ -60 ° C 29 J @ -110 ° C
Exaton 24.13.LHF	焊态	410 MPa	600 MPa	40 %	140 J @ 20 ° C
Exaton 24.13.LNb	焊态	400 MPa	600 MPa	35 %	90 J @ 20 ° C

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机械性能典型值

焊丝	条件	屈服强度	抗拉强度	延伸率	夏比V形缺口
Exaton 25.10.4.L	焊态 DC+	680 MPa	870 MPa	24 %	70 J @ 20 ° C 45 J @ -50 ° C 42 J @ -60 ° C
Exaton 25.22.2.LMn	焊态 DC+	335 MPa	575 MPa	42 %	120 J @ 20 ° C
Exaton Ni56	焊态 HI 1.6-1.8 kJ /mm DC+	450 MPa	700 MPa	45 %	100 J @ -60 ° C 80 J @ -196 ° C
Exaton Ni60 SAW	焊态	445 MPa	715 MPa	45 %	93 J @ -60 ° C 82 J @ -196 ° C