

Exaton 19.9.LNb

Exaton 19.9.LNb is a niobium stabilized chromium-nickel strip electrode used for electro-slag welding (ESW) or submerged arc welding (SAW) to deposit a second layer corrosion resistant alloy of stabilized 19%Cr/9%Ni composition on carbon- and low alloyed steels. The buffer layer is deposited using an over-alloyed consumable, such as 21.11.LNb or 24.13.LNb. Recommended fluxes for ESW are Exaton 47S and Exaton 49S, whilst Exaton 10SW for SAW.

Specifications

Classifications

EN ISO 14343-A : B 19 9 Nb
SFA/AWS A5.9 : EQ347

Typical Wire Composition %

| C | Mn | Si | S | P | Ni | Cr | Mo | Cu | N |
|--------|-----|-----|--------|--------|------|----|-------|-------|---|
| <=0.02 | 1.8 | 0.4 | <=0.02 | <=0.02 | 10.5 | 20 | <=0.3 | <=0.3 | - |

Typical Wire Composition %

| Nb | FN WRC-92 |
|-----|-----------|
| 0.5 | 11 |