

Exaton 34S

Exaton 34S is a neutral slightly chromium compensating welding flux for submerged arc welding giving good slag removal and fine bead appearance. It is suitable for surfacing with strip and wire electrodes and can also be used for joining. Exaton 34S is intended primarily for welding with strip or wire electrodes of austenitic types such as 19.9.LQ and 24.13.LQ for nuclear and chemical applications.

Specifikace

Klasifikace	EN ISO 14174 : S A AB 2 Cr
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Svaovací proud	1200
Hustota	nom: 1.0 Kg/l
Index bazicity	nom: 0.85

Klasifikace

Svaovací drát	AWS/EN
Exaton 19.9.LQ	A5.9:EQ308L/ 14343:B 19 9 L
Exaton 24.13.LQ	A5.9:EQ309L/ 14343:B 23 12 L

Schválení

Svaovací drát

*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.

Typické složení drátu %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.9.LQ									
<0.025	1.8	0.4	<0.015	<0.025	10	19.5	-	<0.10	<0.06
Exaton 24.13.LQ									
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	-

Typické složení drátu %

Co	Ferrite FN
Exaton 19.9.LQ	
<0.05	-
Exaton 24.13.LQ	
-	15

Typického chemického složení svarového kovu v %

C	Mn	Si	Ni	Cr	Mo
Exaton 19.9.LQ					
0.02	1.3	0.8	9.2	20.5	0.1
Exaton 24.13.LQ					
0.02	1.3	0.8	12.1	23.5	0.1