

Exaton 24.13.LR

Exaton 24.13.LR is a high alloyed chromium-nickel covered electrode with rutile coating for welding of dissimilar joints between stainless steel and mild or low alloyed steels. It is also used to create buffer layers with a composition of 18%Cr/8%Ni before overlay alloys are deposited. The electrode has excellent arc stability, low spatter and fast burn off rate with minimal stub loss. It is also characterized by improved moisture resistance, self peeling slag, high resistance to porosity and easy post weld finishing. It provides smooth uniform beads and works in any standard weld position. Typical applications include welding of stainless steel to low alloyed steels, buffer layers on low alloy steels before overlays with 304 composition, welding of stainless steels of 23%Cr/12%Ni type, joining of ferritic/martensitic stainless steels of 12-18%Cr type.

Spezifikationen

Klassifikationen	EN ISO 3581-A : E 23 12 L R 3 2 SFA/AWS A5.4 : E309L-17 Werkstoffnummer : 1.4332
Zulassungen	CE : EN 13479

Zulassungen basieren auf dem Werksstandort. Bitte kontaktieren Sie ESAB für weitere Informationen.

Schweißstrom	DC+, AC
Ferritanteil	FN 10-18
Legierungstyp	Austenitic CrNi
Umhüllungstyp	Acid Rutile

Typische Festigkeitseigenschaften

Zustand	Streckgrenze	Zugfestigkeit	Dehnung
ISO			
Unbehandelt	480 MPa	560 MPa	35 %

Typische Kerbschlagzähigkeit

Zustand	Prüftemperatur	Kerbschlagarbeit
ISO		
Unbehandelt	20 °C	55 J
Unbehandelt	-20 °C	45 J

Typische Schweißgutrichtanalyse %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	FN WRC-92
0.02	0.8	1	0.014	0.021	12.5	23	0.06	0.046	14

Leistungsdaten

Durchmesser	Strom	Volt	Ausbringen (%)	Abschmelzzeit / Elektrode	Abschmelzleistung bei 90 % I max
2.5 x 300.0 mm	45-90 A	28 V	60 %	38 sec	1.1 kg/h
3.2 x 350.0 mm	65-120 A	29 V	60 %	51 sec	1.6 kg/h
4.0 x 350.0 mm	85-180 A	31 V	60 %	51 sec	2.5 kg/h
5.0 x 350.0 mm	110-250 A	32 V	60 %	58 sec	3.3 kg/h