

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.

Spezifikationen	
Klassifikationen	EN ISO 14174 : S A AB 2 Cr

Schweißstrom	1200
Dichte	nom: 1.0 Kg/l
Basizitätsgrad	nom: 0.85

Klassifikationen	
Draht	EN/ISO/AWS
Exaton 19.9.LQ	A5.9:EQ308L/ 14343:B 19 9 L
Exaton 24.13.LQ	A5.9:EQ309L/ 14343:B 23 12 L

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

Drahtzusammensetzung									
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	-

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

Typische Schweißgutrichtanalyse %					
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