

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.

Especificaciones	
Clasificaciones	EN ISO 14174 : S A AB 2 Cr

Corriente de soldadura	1200
Densidad	nom: 1.0 Kg/l
Índice de basicidad	nom: 0.85

Clasificaciones	
Hilo	AWS según EN (Euro Norma)
Exaton 19.9.LQ	A5.9:EQ308L/ 14343:B 19 9 L
Exaton 24.13.LQ	A5.9:EQ309L/ 14343:B 23 12 L

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

% Composición hilo (valores típicos)									
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	-

% Composición hilo (valores típicos)	
Co	Ferrite FN
Exaton 19.9.LQ	
<0.05	-
Exaton 24.13.LQ	
-	15

% Análisis metal depositado (valores típicos)					
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