

Exaton 47S

Exaton 47S is a highly basic welding flux for electroslag strip surfacing. It gives excellent slag removal and bead appearance also for niobium-alloyed strip electrodes. Flux Exaton 47S is used together with strip electrodes of steel types chromium, chromium-nickel and chromium-nickel-molybdenum with or without niobium. The high basicity of flux Exaton 47S makes it especially suitable for duplex, super-duplex and fully austenitic stainless steel surfacings.

Tekniset tiedot	
Luokitukset	EN ISO 14174 : ES A FB 2B

Hitsausvirta	1700 A (Using 60x0.5 strip)
Kuonatyyppe	Fluoride basic CaF ₂ -Al ₂ O ₃
Tiheys	nom: 1.0 Kg/l
Emäksisyys	nom: 4.0

Tila : Jännite 25 V , Jauheen kulutus lankakiloa kohti DC+ 0.5 kg , A 1250 A , Siirtonopeus 9 m/h

Luokittelut		
Lanka	AWS / EN	AWS - hitsatussa tilassa
Exaton 19.12.3.L	A5.9:EQ316L/ 14343-A:B 19 12 3 L	-
Exaton 19.13.4.L	A5.9:EQ317L/ 14343-A:B 19 13 4 L	-
Exaton 19.9.L	A5.9:EQ308L/ 14343-A:B 19 9 L	-
Exaton 19.9.LNb	A5.9:EQ347/ 14343-A:B 19 9 Nb	-
Exaton 21.11.LNb	A5.9:EQ?309LNb?/ 14343-A:B 22 11 L Nb	A5.39: ESCLAD1-EQ309L(mod)/347
Exaton 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L	-
Exaton 22.11.L	A5.9:EQ(309L)/ 14343-A:B 22 11 L	A5.39: ESCLAD1-EQ309L(Mod)/308L
Exaton 22.8.3.L	A5.9:EQ2209/ 14343-A:B 22 9 3 N L	-
Exaton 24.13.L	A5.9:EQ309L/ 14343-A:B 23 12 L	-
Exaton 24.13.LNb	A5.9:EQ?309LNb?/ 14343-A:B 23 12 Nb	-
Exaton 25.22.2.LMn	14343-A:B 25 22 2 N L	-

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

Langan Koostumus									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L									
<=0.020	1.8	0.4	<=0.020	<=0.020	13	18.5	2.9	<=0.3	-
Exaton 19.13.4.L									
<=0.02	1.5	0.4	<=0.020	<=0.020	14	19	3.6	<=0.3	-
Exaton 19.9.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	10	20	<=0.3	<=0.1	-
Exaton 19.9.LNb									
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-
Exaton 21.11.LNb									
<=0.015	1.8	0.2	<=0.020	<=0.020	11	21	<=0.3	<=0.3	-
Exaton 21.13.3.L									
<=0.015	1.8	0.2	<=0.015	<=0.020	13.5	20.5	2.9	<=0.3	-
Exaton 22.11.L									
<=0.015	1.8	0.2	<=0.020	<=0.020	11.5	21	<=0.3	<=0.1	-
Exaton 22.8.3.L									
<=0.020	1.6	0.5	<=0.015	<=0.020	9	23	3.1	-	0.15

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Langan Koostumus									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 24.13.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	-
Exaton 24.13.LNb									
<=0.02	2	0.3	<=0.020	<=0.020	12.5	24	<=0.3	<=0.3	-
Exaton 25.22.2.LMn									
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	-	0.13

Langan Koostumus	
Nb	FN WRC-92
Exaton 19.12.3.L	
-	8
Exaton 19.13.4.L	
-	7
Exaton 19.9.L	
-	12
Exaton 19.9.LNb	
0.5	11
Exaton 21.11.LNb	
0.55	14
Exaton 21.13.3.L	
-	13
Exaton 22.11.L	
-	13
Exaton 22.8.3.L	
-	50
Exaton 24.13.L	
-	15
Exaton 24.13.LNb	
0.75	22

Hitsiaineen Koostumus									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	12	18.2	2.3	-	-
Exaton 19.13.4.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	13	18.5	3.2	-	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"									
<=0.03	-	-	-	-	13.2	18.5	3.4	-	-
Exaton 19.9.L 1st layer with "22.11.L"									
<=0.030	-	-	-	-	10	19.5	-	-	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")									
0.01	1.2	0.4	0.009	0.014	10.5	19.2	0.1	0.06	0.03
Exaton 21.11.LNb (1-layer)									
0.02	1.3	0.5	0.001	0.01	10.1	19.3	0.1	0.03	0.05
Exaton 21.13.3.L (1 layer)									
0.02	1.1	0.4	0.002	0.013	12.5	18.7	2.7	0.06	0.03
Exaton 22.11.L									

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Hitsiaineen Koostumus									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.06	-	-	-	-	9.7	18.5	-	-	-
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.1	-	0.16
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.0	-	0.15
Exaton 24.13.L									
0.03	1.4	0.54	0.003	0.015	10.9	19.0	0.10	0.03	0.04
Exaton 24.13.LNb (1 layer)									
0.03	1.5	0.4	0.002	0.011	10.7	20.8	0.2	0.04	0.04
Exaton 25.22.2.LMn (2 layers)									
0.02	3.5	0.4	0.002	0.016	22.0	24.6	2.0	-	0.14

Hitsiaineen Koostumus		
Nb	FN WRC-92	Nb+Ta
Exaton 19.12.3.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"		
-	6	-
Exaton 19.9.L 1st layer with "22.11.L"		
-	8	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")		
-	8	0.3
Exaton 21.11.LNb (1-layer)		
0.4	5	-
Exaton 21.13.3.L (1 layer)		
-	8	-
Exaton 22.11.L		
-	6	-
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 24.13.L		
-	3	-
Exaton 24.13.LNb (1 layer)		
-	13	0.6
Exaton 25.22.2.LMn (2 layers)		
-	0	-