

## Exaton 69S

The chemical compositions below are typical results after weld surfacing on A533.

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

|              |                                                                 |
|--------------|-----------------------------------------------------------------|
| Hitsausvirta | 2500 A (Using 60x0.5 mm strip)                                  |
| Kuonatyyppe  | Fluoride basic CaF <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> |
| Tiheys       | nom: 1.0 Kg/l                                                   |
| Emäksisyys   | nom: 5.4                                                        |

| Luokittelut     |                                                    |
|-----------------|----------------------------------------------------|
| Lanka           | AWS / EN                                           |
| Exaton Ni41Cu   | A5.14:EQNiFeCr-1/ 18274:B Ni 8065                  |
| Exaton Ni56 ESW | A5.14:EQNiCrMo-4/ 18274:B Ni6276 (NiCr15Mo16Fe6W4) |
| Exaton Ni60     | A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)    |
| Exaton Ni72HP   | A5.14:EQNiCr-3/ 18274:B Ni 6082                    |

| Hyväksynät                                                                                                                                                                                       |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Lanka                                                                                                                                                                                            |  |
| *Selected production units only. Please contact ESAB for more information. Visit <a href="http://esab.com">esab.com</a> to download specific flux/wire combination fact sheets for more details. |  |

| Hitsiaineen Koostumus                  |      |      |       |       |      |      |      |       |      |
|----------------------------------------|------|------|-------|-------|------|------|------|-------|------|
| C                                      | Mn   | Si   | S     | P     | Ni   | Cr   | Mo   | V     | Cu   |
| Exaton Ni41Cu Alloy type 825 (2 layer) |      |      |       |       |      |      |      |       |      |
| 0.021                                  | 0.55 | 0.47 | -     | -     | 41.4 | 21.7 | 2.8  | -     | 2.1  |
| Exaton Ni41Cu Alloy type 825 (1 layer) |      |      |       |       |      |      |      |       |      |
| 0.029                                  | 0.57 | 0.46 | -     | -     | 38.5 | 19.9 | 2.7  | -     | 1.9  |
| Exaton Ni56 ESW                        |      |      |       |       |      |      |      |       |      |
| <0.02                                  | 0.1  | <0.4 | <0.01 | <0.02 | 59   | 15.6 | 15.9 | <0.05 | <0.1 |
| Exaton Ni60 Alloy Type 625 (2 layer)   |      |      |       |       |      |      |      |       |      |
| 0.02                                   | 0.05 | 0.50 | -     | -     | -    | 21.0 | 8.5  | -     | 0.01 |
| Exaton Ni60 Alloy Type 625 (1 layer)   |      |      |       |       |      |      |      |       |      |
| 0.04                                   | 0.07 | 0.50 | -     | -     | Bal. | 20.3 | 8.2  | -     | 0.01 |

| Hitsiaineen Koostumus                  |      |     |     |       |
|----------------------------------------|------|-----|-----|-------|
| Nb                                     | Co   | W   | Fe  | Nb+Ta |
| Exaton Ni41Cu Alloy type 825 (2 layer) |      |     |     |       |
| 0.01                                   | -    | -   | 30  | -     |
| Exaton Ni41Cu Alloy type 825 (1 layer) |      |     |     |       |
| 0.01                                   | -    | -   | 34  | -     |
| Exaton Ni56 ESW                        |      |     |     |       |
| -                                      | <0.1 | 3.8 | 5   | -     |
| Exaton Ni60 Alloy Type 625 (2 layer)   |      |     |     |       |
| -                                      | -    | -   | 0.9 | 3.0   |
| Exaton Ni60 Alloy Type 625 (1 layer)   |      |     |     |       |
| -                                      | -    | -   | 5.8 | 2.8   |

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| Langan Koostumus       |     |      |        |        |     |    |    |       |      |
|------------------------|-----|------|--------|--------|-----|----|----|-------|------|
| C                      | Mn  | Si   | S      | P      | Ni  | Cr | Mo | V     | Cu   |
| <b>Exaton Ni41Cu</b>   |     |      |        |        |     |    |    |       |      |
| ≤0.025                 | 1.0 | 0.3  | ≤0.010 | ≤0.025 | ≥42 | 23 | 3  | -     | 2.3  |
| <b>Exaton Ni56 ESW</b> |     |      |        |        |     |    |    |       |      |
| ≤0.02                  | 0.2 | 0.05 | ≤0.01  | ≤0.01  | ≥50 | 16 | 16 | ≤0.05 | ≤0.1 |
| <b>Exaton Ni60</b>     |     |      |        |        |     |    |    |       |      |
| ≤0.03                  | 0.2 | 0.2  | ≤0.010 | ≤0.015 | ≥60 | 22 | 9  | -     | -    |
| <b>Exaton Ni72HP</b>   |     |      |        |        |     |    |    |       |      |
| ≤0.030                 | 3   | 0.1  | ≤0.01  | ≤0.01  | 72  | 20 | -  | -     | 0.01 |

| Langan Koostumus       |      |   |      |       |
|------------------------|------|---|------|-------|
| Ti                     | Co   | W | Fe   | Nb+Ta |
| <b>Exaton Ni41Cu</b>   |      |   |      |       |
| -                      | -    | - | ≥22  | -     |
| <b>Exaton Ni56 ESW</b> |      |   |      |       |
| -                      | ≤0.1 | 4 | 5    | -     |
| <b>Exaton Ni60</b>     |      |   |      |       |
| -                      | -    | - | ≤1   | 3.5   |
| <b>Exaton Ni72HP</b>   |      |   |      |       |
| 0.27                   | -    | - | 0.33 | 2.70  |