

## Exaton 21.13.3.L

Exaton 21.13.3.L is a chromium-nickel-molybdenum strip electrode used for corrosion resistant alloy surfacing with electro-slag welding (ESW) or with submerged arc welding (SAW). In ESW with Exaton 47S flux, single layer overlays on carbon- and low alloyed steels of 316/316L composition can be deposited. In SAW with Exaton 10SW flux, buffer layers of 18%Cr/8%Ni/2%Mo composition can be deposited on carbon- and low alloyed steels before surfacing of second layers with molybdenum containing alloys. – Combined with 19.13.4.L for the second layer it will give 317L weld deposit – Combined with 20.25.5.LCu for the second layer it will give 385 weld deposit – Other combinations and conditions are possible.

### Tekniset tiedot

#### Luokitukset

EN ISO 14343-A : B 21 13 3 L  
SFA/AWS A5.9 : EQ(309LMo)

### Langan Koostumus

| C       | Mn  | Si  | S       | P       | Ni   | Cr   | Mo  | Cu    | FN WRC-92 |
|---------|-----|-----|---------|---------|------|------|-----|-------|-----------|
| <=0.015 | 1.8 | 0.2 | <=0.015 | <=0.020 | 13.5 | 20.5 | 2.9 | <=0.3 | 13        |