

Exaton 50SW

Exaton 50SW is a basic agglomerated flux with low silicon pickup. It gives good slag removal, good tie-ins and a finely rippled surface. It is suitable for welding with either wire or strip electrodes of nickel alloy type. It is particularly suitable for surfacing with Exaton Ni72HP strip electrodes (ENiCr-3 type). Typical applications for flux Exaton 50SW are found in nuclear and chemical equipment fields. It is also suitable for dissimilar material welding of nickel alloy grades to stainless steel grades.

Tekniset tiedot

Luokitukset	EN ISO 14174 : S A AF 2
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Hitsausvirta	900 A (Using 60x0.5 mm strip)
Kuonatyyppi	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Tiheys	nom: 1.2 Kg/l
Emäksisyys	nom: 2.4

Luokittelut

Lanka	AWS / EN
Exaton Ni41Cu	A5.14:ERNiFeCr-1/ 18274:S Ni 8065
Exaton Ni72HP	A5.14:ERNiCr-3/ 18274:S Ni 6082 (NiCr20Mn3Nb)

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.

Hitsiaineen Koostumus

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton Ni41Cu									
<=0.030	0.8	0.3	<=0.010	<=0.02	40.0	21.5	2.8	2.1	-
Exaton Ni72HP									
0.01	3.0	0.4	0.005	0.009	72.0	19.6	0.1	0.02	-

Hitsiaineen Koostumus

Ti	Co	Fe	Nb+Ta
Exaton Ni41Cu			
-	-	30.0	-
Exaton Ni72HP			
0.15	0.02	1.0	2.2

Langan Koostumus

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton Ni41Cu									
<=0.025	1.0	<=0.3	<=0.010	<=0.025	>=42.0	23.0	3.0	2.3	-
Exaton Ni72HP									
<=0.03	3.0	0.1	<=0.010	<=0.010	72.5	20.0	<=0.2	<=0.05	<=0.05

Langan Koostumus

Ti	Co	Fe	Nb+Ta
Exaton Ni41Cu			
-	-	>=22.0	-
Exaton Ni72HP			
0.4	<=0.10	<=1.0	2.6

Exaton 50SW

Tyypilliset mekaaniset ominaisuudet					
Lanka	Tila	Myötöraja	Murtolujuus	Venymä	Charpy V -iskutkeys
Exaton Ni72HP	Hitsatussa tilassa	320 MPa	600 MPa	40 %	120 J @ 20 °C 110 J @ -196 °C