

Exaton 10SW

Exaton 10SW is a chromium-compensating agglomerated flux giving good slag removal and a fine bead appearance. It is suitable for welding with wire and strip electrodes of the chromium & chromium-nickel and chromium-nickel-molybdenum steel types either with or without niobium. Exaton 10SW is an all round flux which can be used for many applications varying from surfacing continuous caster rolls to large components in chemical plants.

Tekniset tiedot

Luokitukset	EN ISO 14174 : S A CS 2 Cr
Hitsausvirta	1200 A (Using 60x0.5 mm strip)
Kuonattyyppe	Calcium silicate SiO ₂ -MgO-Al ₂ O ₃ -(CaF ₂)
Tiheys	nom: 1.0 kg/l
Emäksisyys	nom: 1.0

Jauheenkulutus

Jännite	Jauheen kulutus lankakiloa kohti DC+
34 V	0.7 kg
30 V	0.55 kg
26 V	0.4 kg
38 V	0.9 kg

Tila : Ulottuvuus 4.0 mm , A 580 A , Siirtonopeus 33 m/h

Luokittelut

Lanka	AWS / EN	AWS - hitsatussa tilassa
Exaton 19.12.3.L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F80A10-ER316L/316L
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:ER308L/ 14343-A:S 19 9 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 19.9.Nb	A5.9:ER347/ 14343-A:S 19 9 Nb	-
Exaton 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L	-
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	-

Hyväksynät

Lanka	VdTÜV
Exaton 19.9.L	•
Exaton 19.9.LNb	•
Exaton 19.9.Nb	•
Exaton 22.8.3.L	•

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 10SW

Langan Koostumus

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.9.LNb									
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-
Exaton 19.9.Nb									
0.04	1.3	0.35	0.012	0.015	9.5	19.5	0.03	0.11	0.06
Exaton 21.13.3.L									
<=0.015	1.8	0.2	<=0.015	<=0.020	13.5	20.5	2.9	<=0.3	-
Exaton 22.8.3.L									
<=0.020	1.6	0.5	<=0.015	<=0.020	9	23	3.1	-	0.15
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	-

Langan Koostumus

Nb	Co	FN deLong	FN WRC	FN WRC-92	Nb+Ta
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 19.9.Nb					
0.6	0.1	5	5	-	0.6
Exaton 21.13.3.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 (Layer 1 with "24.13.L" & Layer 2 with "19.12.3.L")									
0.02	0.8	0.7	-	-	11.5	19.0	2.2	-	0.06
Exaton 19.13.4.L Layer 1 with "21.13.3.L"									
<=0.04	-	-	-	-	13	18.5	3.3	-	-
Exaton 19.9.L 1st layer with "24.13.L"									
<=0.03	-	-	-	-	10.0	19.7	-	-	-
Exaton 19.9.LNb (Layer 1 with "24.13.LNb")									
0.02	0.8	0.6	-	-	10.4	21.0	0.0	-	0.05
Exaton 19.9.Nb Layer 1 with "24.13.LHF" & 2 layers with "19.9.Nb"									
0.04	0.6	1.0	0.01	0.01	9.2	19.0	0.01	0.1	0.06
Exaton 22.8.3.L Layer 1 with "24.13.L" & 2 layers with "22.8.3.L"									

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Hitsiaineen Koostumus

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.03	-	-	-	-	8.5	22.7	2.9	-	0.16
Exaton 24.13.L Layer 1 with "24.13.L"									
<=0.07	-	-	-	-	10.5	19.2	-	-	-
Exaton 24.13.LNb									
<=0.06	-	-	-	-	9.7	19.2	-	-	-

Hitsiaineen Koostumus

Nb	FN WRC-92	Nb+Ta
Exaton 19.12.3.L (Layer 1 with "24.13.L" & Layer 2 with "19.12.3.L")		
0	-	-
Exaton 19.13.4.L Layer 1 with "21.13.3.L"		
-	5	-
Exaton 19.9.L 1st layer with "24.13.L"		
-	8	-
Exaton 19.9.LNb (Layer 1 with "24.13.LNb")		
0.3	-	-
Exaton 19.9.Nb Layer 1 with "24.13.LHF" & 2 layers with "19.9.Nb"		
0.3	-	0.3
Exaton 22.8.3.L Layer 1 with "24.13.L" & 2 layers with "22.8.3.L"		
-	40	-
Exaton 24.13.L Layer 1 with "24.13.L"		
-	6	-
Exaton 24.13.LNb		
-	6	-

Tyypilliset mekaaniset ominaisuudet

Lanka	Tila	Myötöraja	Murtolujuus	Venymä	Charpy V -iskutitkeys
Exaton 19.12.3.L	Hitsatussa tilassa	420 MPa	580 MPa	32 %	69 J @ 20 °C 60 J @ -40 °C 55 J @ -70 °C 50 J @ -196 °C
Exaton 19.9.L	Hitsatussa tilassa	400 MPa	580 MPa	38 %	69 J @ 20 °C 59 J @ -40 °C 40 J @ -196 °C
Exaton 19.9.Nb	Hitsatussa tilassa Joining	440 MPa	625 MPa	38 %	72 J @ 20 °C 61 J @ -40 °C 34 J @ -196 °C