

Exaton 24.13.LNb

Exaton 24.13.LNb is a niobium stabilized chromium-nickel strip electrode used for submerged arc welding (SAW) to deposit a buffer layer of stabilized corrosion resistant alloy of 19%Cr/9%Ni composition on carbon and low alloyed steels. In high speed electro-slag welding (ESW) it can be used for single layer deposits of 347 composition on carbon- and low alloyed steels. It can also be combined with 19.9.LNb for surfacing of two layer overlays. Recommended fluxes for ESW are Exaton 47S and Exaton 49S, whilst Exaton 10SW for SAW.

Specifications

Classifications	EN ISO 14343-A : B 23 12 Nb SFA/AWS A5.9 : EQ?309LNb?
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Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Nb
<=0.02	2	0.3	<=0.020	<=0.020	12.5	24	<=0.3	<=0.3	0.75

Typical Wire Composition %

FN WRC-92

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