

Exaton 34S

Exaton 34S is a neutral slightly chromium compensating welding flux for submerged arc welding giving good slag removal and fine bead appearance. It is suitable for surfacing with strip and wire electrodes and can also be used for joining. Exaton 34S is intended primarily for welding with strip or wire electrodes of austenitic types such as 19.9.LQ and 24.13.LQ for nuclear and chemical applications.

Mszaki leírás	
Osztályozások	EN ISO 14174 : S A AB 2 Cr

Hegesztési áramersség	1200
Srség	nom: 1.0 Kg/l
Bázikussági index	nom: 0.85

Besorolások	
Huzal	AWS/EN
Exaton 19.9.LQ	A5.9:EQ308L/ 14343:B 19 9 L
Exaton 24.13.LQ	A5.9:EQ309L/ 14343:B 23 12 L

Jóváhagyások	
Huzal	
*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.	

Huzal összetétel									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.9.LQ									
<0.025	1.8	0.4	<0.015	<0.025	10	19.5	-	<0.10	<0.06
Exaton 24.13.LQ									
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	-

Huzal összetétel	
Co	Ferrite FN
Exaton 19.9.LQ	
<0.05	-
Exaton 24.13.LQ	
-	15

Varratfém analízis					
C	Mn	Si	Ni	Cr	Mo
Exaton 19.9.LQ					
0.02	1.3	0.8	9.2	20.5	0.1
Exaton 24.13.LQ					
0.02	1.3	0.8	12.1	23.5	0.1