

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 (EQNiCr-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.

Mszaki leírás	
Osztályozások	EN ISO 14174 : S A AF 2

Hegesztési áramerősség	900 A (Using 60x0.5 mm strip)
Salaktípus	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Srség	nom: 1.2 Kg/l
Bázikussági index	nom: 2.4

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

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.	

Varratfém analízis									
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	-

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

Huzal összetétel									
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

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

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Jellegzetes mechanikai tulajdonságok					
Huzal	Állapot	Folyáshatár	Szakítószilárdság	Szakadási nyúlás	Charpy-féle V vizsgálat
Exaton Ni72HP	Hegesztett állapot	320 MPa	600 MPa	40 %	120 J @ 20 °C 110 J @ -196 °C