

Exaton 47S

Exaton 47S is a highly basic welding flux for electroslag strip surfacing. It gives excellent slag removal and bead appearance also for niobium-alloyed strip electrodes. Flux Exaton 47S is used together with strip electrodes of steel types chromium, chromium-nickel and chromium-nickel-molybdenum with or without niobium. The high basicity of flux Exaton 47S makes it especially suitable for duplex, super-duplex and fully austenitic stainless steel surfacings.

Specifiche	
Classificazioni	EN ISO 14174 : ES A FB 2B

Corrente di saldatura	1700 A (Using 60x0.5 strip)
Tipo di scoria	Fluoride basic CaF ₂ -Al ₂ O ₃
Densit	nom: 1.0 Kg/l
Indice di basicit	nom: 4.0

Stato : Volt 25 V , kg flusso/ kg filo DC+ 0.5 kg , Amp 1250 A , Velocit di avanzamento 9 m/h

Classificazioni		
filo	SFA/AWS - EN ISO	AWS-come saldato
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:EQ308L/ 14343-A:B 19 9 L	-
Exaton 19.9.LNb	A5.9:EQ347/ 14343-A:B 19 9 Nb	-
Exaton 21.11.LNb	A5.9:EQ?309LNb?/ 14343-A:B 22 11 L Nb	A5.39: ESCLAD1-EQ309L(mod)/347
Exaton 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L	-
Exaton 22.11.L	A5.9:EQ(309L)/ 14343-A:B 22 11 L	A5.39: ESCLAD1-EQ309L(Mod)/308L
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	-
Exaton 25.22.2.LMn	14343-A:B 25 22 2 N L	-

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

analisi tipica del deposito									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	12	18.2	2.3	-	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"									
<=0.03	-	-	-	-	13.2	18.5	3.4	-	-
Exaton 19.13.4.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	13	18.5	3.2	-	-
Exaton 19.9.L 1st layer with "22.11.L"									
<=0.030	-	-	-	-	10	19.5	-	-	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")									
0.01	1.2	0.4	0.009	0.014	10.5	19.2	0.1	0.06	0.03
Exaton 21.11.LNb (1-layer)									
0.02	1.3	0.5	0.001	0.01	10.1	19.3	0.1	0.03	0.05
Exaton 21.13.3.L (1 layer)									
0.02	1.1	0.4	0.002	0.013	12.5	18.7	2.7	0.06	0.03
Exaton 22.11.L									
<=0.06	-	-	-	-	9.7	18.5	-	-	-

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analisi tipica del deposito									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.1	-	0.16
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.0	-	0.15
Exaton 24.13.L									
0.03	1.4	0.54	0.003	0.015	10.9	19.0	0.10	0.03	0.04
Exaton 24.13.LNb (1 layer)									
0.03	1.5	0.4	0.002	0.011	10.7	20.8	0.2	0.04	0.04
Exaton 25.22.2.LMn (2 layers)									
0.02	3.5	0.4	0.002	0.016	22.0	24.6	2.0	-	0.14

analisi tipica del deposito		
Nb	FN WRC-92	Nb+Ta
Exaton 19.12.3.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.9.L 1st layer with "22.11.L"		
-	8	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")		
-	8	0.3
Exaton 21.11.LNb (1-layer)		
0.4	5	-
Exaton 21.13.3.L (1 layer)		
-	8	-
Exaton 22.11.L		
-	6	-
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 24.13.L		
-	3	-
Exaton 24.13.LNb (1 layer)		
-	13	0.6
Exaton 25.22.2.LMn (2 layers)		
-	0	-

Typical Wire Composition %									
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									

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Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.015	1.8	0.35	<=0.015	<=0.015	10	20	<=0.3	<=0.1	-
Exaton 19.9.LNb									
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-
Exaton 21.11.LNb									
<=0.015	1.8	0.2	<=0.020	<=0.020	11	21	<=0.3	<=0.3	-
Exaton 21.13.3.L									
<=0.015	1.8	0.2	<=0.015	<=0.020	13.5	20.5	2.9	<=0.3	-
Exaton 22.11.L									
<=0.015	1.8	0.2	<=0.020	<=0.020	11.5	21	<=0.3	<=0.1	-
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	-
Exaton 25.22.2.LMn									
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	-	0.13

Typical Wire Composition %	
Nb	FN WRC-92
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 21.11.LNb	
0.55	14
Exaton 21.13.3.L	
-	13
Exaton 22.11.L	
-	13
Exaton 22.8.3.L	
-	50
Exaton 24.13.L	
-	15
Exaton 24.13.LNb	
0.75	22