

Exaton 69S

The chemical compositions below are typical results after weld surfacing on A533.

Specifications	
Classifications	EN ISO 14174 : ES A FB 2B

Welding Current	2500 A (Using 60x0.5 mm strip)
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃
Density	nom: 1.0 Kg/l
Basicity Index	nom: 5.4

Classifications_SAW	
Wire	AWS/EN
Exaton Ni41Cu	A5.14:EQNiFeCr-1/ 18274:B Ni 8065
Exaton Ni56 ESW	A5.14:EQNiCrMo-4/ 18274:B Ni6276 (NiCr15Mo16Fe6W4)
Exaton Ni60	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)
Exaton Ni72HP	A5.14:EQNiCr-3/ 18274:B Ni 6082

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

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
Exaton Ni41Cu Alloy type 825 (1 layer)									
0.029	0.57	0.46	-	-	38.5	19.9	2.7	-	1.9
Exaton Ni41Cu Alloy type 825 (2 layer)									
0.021	0.55	0.47	-	-	41.4	21.7	2.8	-	2.1
Exaton Ni56 ESW									
<0.02	0.1	<0.4	<0.01	<0.02	59	15.6	15.9	<0.05	<0.1
Exaton Ni60 Alloy Type 625 (1 layer)									
0.04	0.07	0.50	-	-	Bal.	20.3	8.2	-	0.01
Exaton Ni60 Alloy Type 625 (2 layer)									
0.02	0.05	0.50	-	-	-	21.0	8.5	-	0.01

Typical Weld Metal Analysis %				
Nb	Co	W	Fe	Nb+Ta
Exaton Ni41Cu Alloy type 825 (1 layer)				
0.01	-	-	34	-
Exaton Ni41Cu Alloy type 825 (2 layer)				
0.01	-	-	30	-
Exaton Ni56 ESW				
-	<0.1	3.8	5	-
Exaton Ni60 Alloy Type 625 (1 layer)				
-	-	-	5.8	2.8
Exaton Ni60 Alloy Type 625 (2 layer)				
-	-	-	0.9	3.0

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Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
Exaton Ni41Cu									
<=0.025	1.0	0.3	<=0.010	<=0.025	>=42	23	3	-	2.3
Exaton Ni56 ESW									
<=0.02	0.2	0.05	<0.01	<0.01	>=50	16	16	<0.05	<0.1
Exaton Ni60									
<=0.03	0.2	0.2	<=0.010	<=0.015	>=60	22	9	-	-
Exaton Ni72HP									
<=0.030	3	0.1	<=0.01	<=0.01	72	20	-	-	0.01

Typical Wire Composition %				
Ti	Co	W	Fe	Nb+Ta
Exaton Ni41Cu				
-	-	-	>=22	-
Exaton Ni56 ESW				
-	<0.1	4	5	-
Exaton Ni60				
-	-	-	<=1	3.5
Exaton Ni72HP				
0.27	-	-	0.33	2.70