

Exaton 22.8.3.L

Exaton 22.8.3.L is a duplex stainless filler metal for welding duplex stainless steels. Weldability as well as properties of the all-weld metal is excellent. Corrosion resistance is equal to 904L in most applications. Exaton 22.8.3.L is used for welding of duplex stainless steels such as Alleima SAF 2205 and SAF 2304. It can also be used for welding of duplex stainless steels to carbon steel and for cladding. It is used for Submerged Arc Welding and the recommended flux is Exaton 15W.

Specifications	
Classifications	EN ISO 14343-A : S 22 9 3 N L SFA/AWS A5.9 : ER2209
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic-ferritic (22.5 % Cr - 8 % Ni - 3 % Mo - Low C)
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Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.012	1.5	0.5	0.0007	0.018	8.6	23	3.2	0.05	0.09

Typical Wire Composition %						
N	Nb	Ti	Co	PRE	FN WRC-92	W
0.15	0.01	0.003	0.04	37	55	0.01