

## Exaton 24.13.LR

Exaton 24.13.LR is a high alloyed chromium-nickel covered electrode with rutile coating for welding of dissimilar joints between stainless steel and mild or low alloyed steels. It is also used to create buffer layers with a composition of 18%Cr/8%Ni before overlay alloys are deposited. The electrode has excellent arc stability, low spatter and fast burn off rate with minimal stub loss. It is also characterized by improved moisture resistance, self peeling slag, high resistance to porosity and easy post weld finishing. It provides smooth uniform beads and works in any standard weld position. Typical applications include welding of stainless steel to low alloyed steels, buffer layers on low alloy steels before overlays with 304 composition, welding of stainless steels of 23%Cr/12%Ni type, joining of ferritic/martensitic stainless steels of 12-18%Cr type.

### Specifications

<b>Classifications</b>	EN ISO 3581-A : E 23 12 L R 3 2 SFA/AWS A5.4 : E309L-17 Werkstoffnummer : 1.4332
<b>Approvals</b>	CE : EN 13479

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

<b>Welding Current</b>	DC+, AC
<b>Ferrite Content</b>	FN 10-18
<b>Alloy Type</b>	Austenitic CrNi
<b>Coating Type</b>	Acid Rutile

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	480 MPa	560 MPa	35 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	20 °C	55 J
As Welded	-20 °C	45 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	FN WRC-92
0.02	0.8	1	0.014	0.021	12.5	23	0.06	0.046	14

### Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	45-90 A	28 V	60 %	38 sec	1.1 kg/h
3.2 x 350.0 mm	65-120 A	29 V	60 %	51 sec	1.6 kg/h
4.0 x 350.0 mm	85-180 A	31 V	60 %	51 sec	2.5 kg/h
5.0 x 350.0 mm	110-250 A	32 V	60 %	58 sec	3.3 kg/h