

Exaton 19.13.4.L

Exaton 19.13.4.L is a chromium-nickel-molybdenum strip electrode used for electro-slag welding (ESW) or submerged arc welding (SAW) to deposit a second layer corrosion resistant alloy of 19%Cr/13%Ni/4%Mo composition on carbon- and low alloyed steels. The buffer layer is deposited using an over-alloyed consumable, such as 21.13.3.L, 22.11.L or 24.13.L. Exaton 19.13.4.L is also suitable for a single layer solution in combination with OK Flux 10.26.

Specifications

Classifications	EN ISO 14343-A : B 19 13 4 L SFA/AWS A5.9 : EQ317L
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Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	FN WRC-92
<=0.02	1.5	0.4	<=0.020	<=0.020	14	19	3.6	<=0.3	7