

Exaton 21.13.3.L

Exaton 21.13.3.L is a chromium-nickel-molybdenum strip electrode used for corrosion resistant alloy surfacing with electro-slag welding (ESW) or with submerged arc welding (SAW). In ESW with Exaton 47S flux, single layer overlays on carbon- and low alloyed steels of 316/316L composition can be deposited. In SAW with Exaton 10SW flux, buffer layers of 18%Cr/8%Ni/2%Mo composition can be deposited on carbon- and low alloyed steels before surfacing of second layers with molybdenum containing alloys. – Combined with 19.13.4.L for the second layer it will give 317L weld deposit – Combined with 20.25.5.LCu for the second layer it will give 385 weld deposit – Other combinations and conditions are possible.

Specifications

Classifications

EN ISO 14343-A : B 21 13 3 L

SFA/AWS A5.9 : EQ(309LMo)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	FN WRC-92
<=0.015	1.8	0.2	<=0.015	<=0.020	13.5	20.5	2.9	<=0.3	13