

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.

Specificaties

Classificaties	EN ISO 3581-A : E 23 12 L R 3 2 SFA/AWS A5.4 : E309L-17 Werkstoffnummer : 1.4332
Goedkeuringen	CE : EN 13479

Goedkeuringen zijn gebaseerd op fabriekslocatie. Neem contact op met ESAB voor meer informatie.

Lasstroom	DC+, AC
Ferrietgehalte	FN 10-18
Legering Type	Austenitic CrNi
Coating Type	Acid Rutile

Typische Mechanische Eigenschappen

Conditionering	Rekgrens	Treksterkte	Rek
ISO			
Zoals gelast	480 MPa	560 MPa	35 %

Kerfslageeigenschappen

Conditionering	Testtemperatuur	Kerfslagwaarde
ISO		
Zoals gelast	20 °C	55 J
Zoals gelast	-20 °C	45 J

Typische lasmetaalanalyse (%)

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

Neersmeltgegevens

Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
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