

Exaton 19.9.LR

Exaton 19.9.LR is a chromium-nickel covered electrode with acid rutile coating for welding of low carbon 18% Cr/10% Ni austenitic stainless steels. In cases where creep strength is of secondary importance Exaton 19.9.LR is suitable for welding stabilized austenitic steels, e.g. ASTM 321 and 347. When a weld metal similar to the parent metal is not required Exaton 19.9.LR can be used for welding ferritic and martensitic steels. 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, easy post weld finishing. Exaton 19.9.LR gives smooth uniform beads and works in any standard weld position.

Specificaties

Classificaties	EN ISO 3581-A : E 19 9 L R 1 2 SFA/AWS A5.4 : E308L-17 Werkstoffnummer : 1.4316
Goedkeuringen	CE : EN 13479

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

Lasstroom	DC+, AC
Ferrietgehalte	FN 3-10
Legering Type	Austenitic CrNi
Coating Type	Acid Rutile

Typische Mechanische Eigenschappen

Conditionering	Rekgrens	Treksterkte	Rek
ISO			
Zoals gelast	440 MPa	600 MPa	40 %

Kerfslageigenschappen

Conditionering	Testtemperatuur	Kerfslagwaarde
ISO		
Zoals gelast	-20 °C	60 J
Zoals gelast	20 °C	75 J

Typische lasmetaalanalyse (%)

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.025	0.75	0.9	0.014	0.024	9.5	19	0.04	0.04	0.062

Typische lasmetaalanalyse (%)

FN WRC-92
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Neersmeltgegevens

Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
2.5 x 300.0 mm	50-90 A	28 V	58 %	39 sec	1.0 kg/h
3.2 x 350.0 mm	70-130 A	31 V	60 %	54 sec	1.4 kg/h
4.0 x 350.0 mm	90-180 A	32 V	60 %	56 sec	2.0 kg/h
5.0 x 350.0 mm	140-250 A	33 V	60 %	60 sec	2.8 kg/h