Exaton 49S

Exaton 49S is a basic, agglomerated flux for electroslag strip surfacing. This flux is particularly intended for high-speed welding. In spite of high welding speed, flux Exaton 49S gives excellent slag removal and bead appearance, also for niobium-alloyed strip electrodes. It is used together with strip electrodes of the chromium, chromium-nickel and chromium-nickel-molybdenum steel types with or without niobium. Exaton 49S gives the following typical chemical properties of all-weld metal for the strip electrode below. Exaton 24.13.LNb is used for corrosion resistant weld surfacing of components in the chemical, petrochemical, nuclear industry. Typical components are pressure vessels, heat exchangers, shafts, industrial piping etc.

Specificaties	
Classificaties	EN ISO 14174 : ES A FB 2B

Lasstroom	2200 A (Using 60x0.5 mm strip)
Slaktype	Fluoride basic CaF2-Al2O3
Dichtheid	nom: 1.0 Kg/l
Basiciteits Index	nom: 4.4

Normen	
Draad	**AWS/EN**
Exaton 19.12.3.L	A5.9:EQ316L/ 14343-A:B 19 12 3 L
Exaton 19.13.4.L	A5.9:EQ317L/ 14343-A:B 19 13 4 L
Exaton 19.9.L	A5.9:EQ308L/ 14343-A:B 19 9 L
Exaton 19.9.LNb	A5.9:EQ347/ 14343-A:B 19 9 Nb
Exaton 21.11.LNb	A5.9:EQ?309LNb?/ 14343-A:B 22 11 L Nb
Exaton 22.11.L	A5.9:EQ(309L)/ 14343-A:B 22 11 L
Exaton 24.13.L	A5.9:EQ309L/ 14343-A:B 23 12 L
Exaton 24.13.LNb	A5.9:EQ?309LNb?/ 14343-A:B 23 12 Nb

Goedkeuringen
Draad
*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.

draad samenstelling									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
Exaton 19.12.3.L									
<=0.020	1.8	0.4	<=0.020	<=0.020	13	18.5	2.9	<=0.3	-
Exaton 19.13.4.L									
<=0.02	1.5	0.4	<=0.020	<=0.020	14	19	3.6	<=0.3	-
Exaton 19.9.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	10	20	<=0.3	<=0.1	-
Exaton 19.9.LNb									
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-
Exaton 21.11.LNb									
<=0.015	1.8	0.2	<=0.020	<=0.020	11	21	<=0.3	<=0.3	-
Exaton 22.11.L									
<=0.015	1.8	0.2	<=0.020	<=0.020	11.5	21	<=0.3	<=0.1	-
Exaton 24.13.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	-
Exaton 24.13.LNb									
<=0.02	2	0.3	<=0.020	<=0.020	12.5	24	<=0.3	<=0.3	-

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draad samenstelling		
Nb	**Ferrite FN**	**FN WRC-92**
Exaton 19.12.3.L		
-	-	8
Exaton 19.13.4.L		
-	-	7
Exaton 19.9.L		
-	-	12
Exaton 19.9.LNb		
0.5	-	11
Exaton 21.11.LNb		
0.55	-	14
Exaton 22.11.L		
-	13	-
Exaton 24.13.L		
-	-	15
Exaton 24.13.LNb		
0.75	-	22

Typische lasmetaalanalyse (%)									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
Exaton 19.12.3.L Layer 1 with "24.13.L"									
<=0.03	-	-	-	-	12.0	17.7	2.2	-	-
Exaton 19.13.4.L Layer 1 with "24.13.L"									
<=0.03	-	-	-	-	13.0	18.5	2.7	-	-
Exaton 19.9.L Layer 1 with "24.13.L"									
<=0.03	-	-	-	-	10	19.2	-	-	-
Exaton 19.9.LNb (Layer 1 with "24.13.LNb" & Layer 2 with "19.9.LNb")									
0.02	1.4	0.3	-	-	10.5	19.6	0.1	-	0.03
Exaton 19.9.LNb									
-	-	-	-	-	-	-	-	-	-
Exaton 19.9.LNb (Layer 1 with "24.13.L" & Layer 2 with "19.9.LNb")									
0.02	1.3	0.3	-	-	10.6	19.5	0.1	-	0.03
Exaton 21.11.LNb									
-	-	-	-	-	-	-	-	-	-
Exaton 21.11.LNb (1 layer)									
0.02	1.4	0.4	-	-	9.7	18.9	0.1	-	0.05
Exaton 24.13.L									
<=0.07	-	-	-	-	10.2	19	-	-	-
Exaton 24.13.LNb									
<=0.06	-	-	-	-	9.7	18.5	-	-	-

Typische lasmetaalanalyse (%)	
Nb	**FN WRC-92**
Exaton 19.12.3.L Layer 1 with "24.13.L"	
-	6
Exaton 19.13.4.L Layer 1 with "24.13.L"	
-	6

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Typische lasmetaalanalyse (%)	
Nb	**FN WRC-92**
Exaton 19.9.L Layer 1 with "24.13.L"	
-	8
Exaton 19.9.LNb (Layer 1 with "24.13.LNb" & Layer 2 with "19.9.LNb")	
0.4	-
Exaton 19.9.LNb (Layer 1 with "24.13.L" & Layer 2 with "19.9.LNb")	
0.3	-
Exaton 21.11.LNb (1 layer)	
0.5	-
Exaton 24.13.L	
-	6
Exaton 24.13.LNb	
-	5