

## Exaton 19.12.3.L

Exaton 19.12.3.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/12%Ni/3%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. Recommended fluxes for ESW are Exaton 47S and Exaton 49S, whilst Exaton 10SW for SAW. Exaton 19.12.3.L is also suitable for a single layer solution in combination with OK Flux 10.26.

| Specificaties  |                                                       |
|----------------|-------------------------------------------------------|
| Classificaties | EN ISO 14343-A : B 19 12 3 L<br>SFA/AWS A5.9 : EQ316L |
| Goedkeuringen  | CE : EN 13479<br>UKCA : EN 13479                      |

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

| draad samenstelling |     |     |         |         |    |      |     |       |           |
|---------------------|-----|-----|---------|---------|----|------|-----|-------|-----------|
| C                   | Mn  | Si  | S       | P       | Ni | Cr   | Mo  | Cu    | FN WRC-92 |
| <=0.020             | 1.8 | 0.4 | <=0.020 | <=0.020 | 13 | 18.5 | 2.9 | <=0.3 | 8         |