

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.

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

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	DC+, AC
Ferrithalt	FN 10-18
Legeringstyp	Austenitic CrNi
Höljtyp	Acid Rutile

Typiska mekaniska värden			
Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	480 MPa	560 MPa	35 %

Slagseghetsdata Charpy V		
Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	-20 °C	45 J
Helsvetsgods	20 °C	55 J

Svetsgodsanalys %									
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

Insmälningsdata					
Diameter	Ström	Bågspänning	Verkningsgrad (%)	Smälttid per elektrod vid 90% av maxström	Insvetstal vid 90 % I max
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