

## Exaton 19.9.L

Exaton 19.9.L is a chromium-nickel strip electrode used for electro-slag welding (ESW) or submerged arc welding (SAW) to deposit a second layer corrosion resistant alloy of 18%Cr/8%Ni composition on carbon- and low alloyed steels. The buffer layer is deposited using an over-alloyed consumable, such as 22.11.L or 24.13.L. Recommended fluxes are Exaton 10SW, 47S and 49S.

| Tekniska data    |                                                    |
|------------------|----------------------------------------------------|
| Klassificeringar | EN ISO 14343-A : B 19 9 L<br>SFA/AWS A5.9 : EQ308L |
| Godkännanden     | CE : EN 13479<br>UKCA : EN 13479                   |

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

|              |                                                              |
|--------------|--------------------------------------------------------------|
| Legeringstyp | Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C |
|--------------|--------------------------------------------------------------|

| Trådens sammansättning % |     |      |         |         |    |    |       |       |           |
|--------------------------|-----|------|---------|---------|----|----|-------|-------|-----------|
| C                        | Mn  | Si   | S       | P       | Ni | Cr | Mo    | Cu    | FN WRC-92 |
| <=0.015                  | 1.8 | 0.35 | <=0.015 | <=0.015 | 10 | 20 | <=0.3 | <=0.1 | 12        |