

Exaton 50SW

Exaton 50SW is a basic agglomerated flux with low silicon pickup. It gives good slag removal, good tie-ins and a finely rippled surface. It is suitable for welding with either wire or strip electrodes of nickel alloy type. It is particularly suitable for surfacing with Exaton Ni72HP strip electrodes (EQNiCr-3 type). Typical applications for flux Exaton 50SW are found in nuclear and chemical equipment fields. It is also suitable for dissimilar material welding of nickel alloy grades to stainless steel grades.

Dane techniczne

Klasyfikacje	EN ISO 14174 : S A AF 2
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Prd spawania	900 A (Using 60x0.5 mm strip)
Typ ulu	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Gsto	nom: 1.2 Kg/l
Wskanik zasadowoci	nom: 2.4

Klasyfikacje

Drut	AWS/EN
Exaton Ni41Cu	A5.14:ERNiFeCr-1/ 18274:S Ni 8065
Exaton Ni72HP	A5.14:ERNiCr-3/ 18274:S Ni 6082 (NiCr20Mn3Nb)

Dopuszczenia

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

Skad drutu %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton Ni41Cu									
<=0.025	1.0	<=0.3	<=0.010	<=0.025	>=42.0	23.0	3.0	2.3	-
Exaton Ni72HP									
<=0.03	3.0	0.1	<=0.010	<=0.010	72.5	20.0	<=0.2	<=0.05	<=0.05

Skad drutu %

Ti	Co	Fe	Nb+Ta
Exaton Ni41Cu			
-	-	>=22.0	-
Exaton Ni72HP			
0.4	<=0.10	<=1.0	2.6

Typowy skad chemiczny stopiwa %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton Ni41Cu									
<=0.030	0.8	0.3	<=0.010	<=0.02	40.0	21.5	2.8	2.1	-
Exaton Ni72HP									
0.01	3.0	0.4	0.005	0.009	72.0	19.6	0.1	0.02	-

Typowy skad chemiczny stopiwa %

Ti	Co	Fe	Nb+Ta
Exaton Ni41Cu			
-	-	30.0	-
Exaton Ni72HP			
0.15	0.02	1.0	2.2

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Typowe właściwości mechaniczne					
Drut	Warunki	Granica plastyczności	Wytrzymałość na rozciąganie	Wydłużenie względne	Udarno KV
Exaton Ni72HP	Po spawaniu	320 MPa	600 MPa	40 %	120 J @ 20 °C 110 J @ -196 °C