

Exaton 22.12.HT

Exaton 22.12.HT is an austenitic filler material for welding the high temperature steel grade Alleima 253 MA*, UNS S30815. It is characterized by high creep strength, good resistance to oxidation and good weldability. It is used for Submerged Arc Welding in combination with Exaton Flux 15W. * 253 MA is a trademark owned by Outokumpu OY.

Specifications	
Classifications	EN ISO 14343-A : S 21 10 N Werkstoffnummer : 1.4835
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.07	0.5	1.6	0.0007	0.020	10.2	21.0	0.1	0.01	0.1

Typical Wire Composition %						
N	Nb	Ti	Co	B	FN deLong	Ce
0.17	0.01	0.005	0.05	0.0008	9	0.04