

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.

Tekniska data

Klassificeringar	EN ISO 14174 : S A AF 2
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Svetsström	900 A (Using 60x0.5 mm strip)
Slaggtyp	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Densitet	nom: 1.2 Kg/l
Basisitets index	nom: 2.4

Klassificering

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

Godkännanden

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

Trådens sammansättning %

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

Trådens sammansättning %

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

Svetsgodsanalys %

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	-

Svetsgodsanalys %

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

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Mekaniska egenskaper

Tråd	Villkor	Sträckgräns	Brottgräns	Förlängning	Charpy V-Notch
Exaton Ni72HP	Helsvetsgods	320 MPa	600 MPa	40 %	120 J @ 20 °C 110 J @ -196 °C