

## Exaton 24.13.LHF

Exaton 24.13.LHF welding wire is particularly suitable for overlay welding and joining dissimilar steels, for example austenitic stainless steels to low alloyed or non alloyed steels. It has excellent resistance to hot cracking due to its enhanced ferrite content. It is used for Submerged Arc Welding and recommended flux is Exaton 15W.

| Specifications  |                                                     |
|-----------------|-----------------------------------------------------|
| Classifications | EN ISO 14343-A : S 23 12 L<br>SFA/AWS A5.9 : ER309L |
| Approvals       | CE : EN 13479<br>UKCA : EN 13479<br>VdTÜV : 03771   |

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

| Typical Wire Composition % |     |     |       |       |      |      |      |      |      |
|----------------------------|-----|-----|-------|-------|------|------|------|------|------|
| C                          | Mn  | Si  | S     | P     | Ni   | Cr   | Mo   | V    | Cu   |
| 0.01                       | 1.8 | 0.4 | 0.001 | 0.011 | 13.4 | 23.8 | 0.04 | 0.05 | 0.03 |

| Typical Wire Composition % |      |       |      |           |        |
|----------------------------|------|-------|------|-----------|--------|
| N                          | Nb   | Ti    | Co   | FN deLong | FN WRC |
| 0.05                       | 0.03 | 0.004 | 0.03 | 14        | 13     |