

Exaton 19.9.LNb

Exaton 19.9.LNb is a niobium stabilized chromium-nickel strip electrode used for electro-slag welding (ESW) or submerged arc welding (SAW) to deposit a second layer corrosion resistant alloy of stabilized 19%Cr/9%Ni composition on carbon- and low alloyed steels. The buffer layer is deposited using an over-alloyed consumable, such as 21.11.LNb or 24.13.LNb. Recommended fluxes for ESW are Exaton 47S and Exaton 49S, whilst Exaton 10SW for SAW.

Specifications

Classifications	EN ISO 14343-A : B 19 9 Nb SFA/AWS A5.9 : EQ347
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Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-

Typical Wire Composition %

Nb	FN WRC-92
0.5	11