

Exaton 47S

Exaton 47S elektro-cüruf erit yüzey kaplaması için kullanılan oldukça bazik bir kaynak özlü telidir. Niyobyum ağırlıklı erit elektrotlar için de mükemmel cüruf giderme ve diki görünümü sağlar. Flux Exaton 47S niyobyumlu veya niyobyumsuz krom, krom-nikel ve krom-nikel-molibden çelik tiplerinin erit elektrotları ile birlikte kullanılır. Exaton 47S özlü telin yüksek bazikli, onu özellikle dubleks, süper dubleks ve tamamen östenitik paslanmaz çelik yüzeyler için uygun hale getirir.

Teknik Özellikler	
Snflandrmalar	EN ISO 14174 : ES A FB 2B

Kaynak Akım	1700 A (Using 60x0.5 strip)
Cüruf Tipi	Fluoride basic CaF ₂ -Al ₂ O ₃
Younluk	nom: 1.0 Kg/l
Bazite Endeksi	nom: 4.0

Koul : Volt 25 V , kg Özlü Tel / kg Tel DC+ 0.5 kg , Amper 1250 A , Hareket Hz 9 m/h

Snflandrmalar		
Tel	SFA/AWS - EN ISO	AWA - Kaynaklı Olarak
Exaton 19.12.3.L	A5.9:EQ316L/ 14343-A:B 19 12 3 L	-
Exaton 19.13.4.L	A5.9:EQ317L/ 14343-A:B 19 13 4 L	-
Exaton 19.9.L	A5.9:EQ308L/ 14343-A:B 19 9 L	-
Exaton 19.9.LNb	A5.9:EQ347/ 14343-A:B 19 9 Nb	-
Exaton 21.11.LNb	A5.9:EQ?309LNb?/ 14343-A:B 22 11 L Nb	A5.39: ESCLAD1-EQ309L(mod)/347
Exaton 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L	-
Exaton 22.11.L	A5.9:EQ(309L)/ 14343-A:B 22 11 L	A5.39: ESCLAD1-EQ309L(Mod)/308L
Exaton 22.8.3.L	A5.9:EQ2209/ 14343-A:B 22 9 3 N L	-
Exaton 24.13.L	A5.9:EQ309L/ 14343-A:B 23 12 L	-
Exaton 24.13.LNb	A5.9:EQ?309LNb?/ 14343-A:B 23 12 Nb	-
Exaton 25.22.2.LMn	14343-A:B 25 22 2 N L	-

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

Tipik Tel Bileimi %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L									
<=0.020	1.8	0.4	<=0.020	<=0.020	13	18.5	2.9	<=0.3	-
Exaton 19.13.4.L									
<=0.02	1.5	0.4	<=0.020	<=0.020	14	19	3.6	<=0.3	-
Exaton 19.9.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	10	20	<=0.3	<=0.1	-
Exaton 19.9.LNb									
<=0.02	1.8	0.4	<=0.02	<=0.02	10.5	20	<=0.3	<=0.3	-
Exaton 21.11.LNb									
<=0.015	1.8	0.2	<=0.020	<=0.020	11	21	<=0.3	<=0.3	-
Exaton 21.13.3.L									
<=0.015	1.8	0.2	<=0.015	<=0.020	13.5	20.5	2.9	<=0.3	-
Exaton 22.11.L									
<=0.015	1.8	0.2	<=0.020	<=0.020	11.5	21	<=0.3	<=0.1	-
Exaton 22.8.3.L									
<=0.020	1.6	0.5	<=0.015	<=0.020	9	23	3.1	-	0.15

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Tipik Tel Bileimi %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 24.13.L									
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	-
Exaton 24.13.LNb									
<=0.02	2	0.3	<=0.020	<=0.020	12.5	24	<=0.3	<=0.3	-
Exaton 25.22.2.LMn									
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	-	0.13

Tipik Tel Bileimi %	
Nb	FN WRC-92
Exaton 19.12.3.L	
-	8
Exaton 19.13.4.L	
-	7
Exaton 19.9.L	
-	12
Exaton 19.9.LNb	
0.5	11
Exaton 21.11.LNb	
0.55	14
Exaton 21.13.3.L	
-	13
Exaton 22.11.L	
-	13
Exaton 22.8.3.L	
-	50
Exaton 24.13.L	
-	15
Exaton 24.13.LNb	
0.75	22

Tipik Kaynak Metali Analizi %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	12	18.2	2.3	-	-
Exaton 19.13.4.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	13	18.5	3.2	-	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"									
<=0.03	-	-	-	-	13.2	18.5	3.4	-	-
Exaton 19.9.L 1st layer with "22.11.L"									
<=0.030	-	-	-	-	10	19.5	-	-	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")									
0.01	1.2	0.4	0.009	0.014	10.5	19.2	0.1	0.06	0.03
Exaton 21.11.LNb (1-layer)									
0.02	1.3	0.5	0.001	0.01	10.1	19.3	0.1	0.03	0.05
Exaton 21.13.3.L (1 layer)									
0.02	1.1	0.4	0.002	0.013	12.5	18.7	2.7	0.06	0.03
Exaton 22.11.L									

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Tipik Kaynak Metali Analizi %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.06	-	-	-	-	9.7	18.5	-	-	-
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.1	-	0.16
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.0	-	0.15
Exaton 24.13.L									
0.03	1.4	0.54	0.003	0.015	10.9	19.0	0.10	0.03	0.04
Exaton 24.13.LNb (1 layer)									
0.03	1.5	0.4	0.002	0.011	10.7	20.8	0.2	0.04	0.04
Exaton 25.22.2.LMn (2 layers)									
0.02	3.5	0.4	0.002	0.016	22.0	24.6	2.0	-	0.14

Tipik Kaynak Metali Analizi %		
Nb	FN WRC-92	Nb+Ta
Exaton 19.12.3.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "22.11.L"		
-	6	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"		
-	6	-
Exaton 19.9.L 1st layer with "22.11.L"		
-	8	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")		
-	8	0.3
Exaton 21.11.LNb (1-layer)		
0.4	5	-
Exaton 21.13.3.L (1 layer)		
-	8	-
Exaton 22.11.L		
-	6	-
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"		
-	45	-
Exaton 24.13.L		
-	3	-
Exaton 24.13.LNb (1 layer)		
-	13	0.6
Exaton 25.22.2.LMn (2 layers)		
-	0	-