

Exaton 19.9.L

Exaton 19.9.L is a chromium-nickel strip electrode used for electro-slag welding (ESW) or submerged arc welding (SAW) to deposit a second layer corrosion resistant alloy of 18%Cr/8%Ni composition on carbon- and low alloyed steels. The buffer layer is deposited using an over-alloyed consumable, such as 22.11.L or 24.13.L. Recommended fluxes are Exaton 10SW, 47S and 49S.

Specifications	
Classifications	EN ISO 14343-A : B 19 9 L SFA/AWS A5.9 : EQ308L
Approvals	CE : EN 13479 UKCA : EN 13479

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

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C
------------	--

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	FN WRC-92
<=0.015	1.8	0.35	<=0.015	<=0.015	10	20	<=0.3	<=0.1	12