

Exaton SX (GTAW)

Exaton SX is a high silicon containing austenitic stainless steel wire for joining grades, such as UNS S32615 (e.g. Alleima® SX). The wire is developed for use in concentrated sulfuric acid and in high concentrated nitric acid. Exaton SX GTAW is used for joining and overlay welding.

Specifications

Classifications	EN ISO 14343-A : W Z 18 13 Si Cu L
Approvals	CE : EN 13479 UKCA : EN 13479

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

Alloy Type	Austenitic - 19%Cr 13%Ni 5%Si 2%Cu - Low C
Shielding Gas	I1, I3 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	420 MPa (61 ksi)	750 MPa (109 ksi)	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	50 J (37 ft-lb)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.7	4.9	0.002	0.011	13.5	18.5	0.02	2.0	0.06

Typical Wire Composition %

Nb	Co
0.01	0.02

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.7	4.8	0.001	0.014	13.2	18.4	0.03	1.9	0.04

Typical Weld Metal Analysis %

Nb	Co
0.01	0.03