

Exaton 34S

Exaton 34S is a neutral slightly chromium compensating welding flux for submerged arc welding giving good slag removal and fine bead appearance. It is suitable for surfacing with strip and wire electrodes and can also be used for joining. Exaton 34S is intended primarily for welding with strip or wire electrodes of austenitic types such as 19.9.LQ and 24.13.LQ for nuclear and chemical applications.

Specifications

Classifications	EN ISO 14174 : S A AB 2 Cr
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Welding Current	1200
Density	nom: 1.0 Kg/l
Basicity Index	nom: 0.85

Classifications

Wire	AWS/EN
Exaton 19.9.LQ	A5.9:EQ308L/ 14343:B 19 9 L
Exaton 24.13.LQ	A5.9:EQ309L/ 14343:B 23 12 L

Approvals

Combined with Wire

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

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
Exaton 19.9.LQ					
0.02	1.3	0.8	9.2	20.5	0.1
Exaton 24.13.LQ					
0.02	1.3	0.8	12.1	23.5	0.1

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.9.LQ									
<0.025	1.8	0.4	<0.015	<0.025	10	19.5	-	<0.10	<0.06
Exaton 24.13.LQ									
<=0.015	1.8	0.35	<=0.015	<=0.015	13	23.5	<=0.3	<=0.1	-

Typical Wire Composition %

Co	Ferrite FN
Exaton 19.9.LQ	
<0.05	-
Exaton 24.13.LQ	
-	15