

Exaton 309LNb

309LNb is a niobium stabilized chromium-nickel strip electrode used for submerged arc welding (SAW) to deposit a buffer layer of stabilized corrosion resistant alloy of 19%Cr/9%Ni composition on carbon and low alloyed steels. In high speed electro-slag welding (ESW) it can be used for single layer deposits of 347 composition on carbon- and low alloyed steels. It can also be combined with 347L for surfacing of two layer overlays.

Specifications

Classifications

EN ISO 14343-A : B 23 12 Nb
SFA/AWS A5.9 : EQ?309LNb?

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Nb
<=0.02	2	0.3	<=0.020	<=0.020	12.5	24	<=0.3	<=0.3	0.75

Typical Wire Composition %

FN WRC-92

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