

Exaton 35WF

Exaton 35WF is a basic welding flux for submerged arc welding giving good slag removal and a fine bead appearance. Its relatively high basicity makes it suitable for joining of the austenitic and duplex stainless steel when high impact strength is desired. Due to its low niobium content burn-off it can be used advantageously with stabilized wire electrodes.

Exaton 35WF is a high performance welding flux in many joining applications in the chemical, petrochemical and oil & gas industry. It is particularly suited for Exaton range of duplex wire electrodes (e.g. 22.8.3.L/25.10.4.L) due to the highly neutral behavior, which ensures an optimal balanced microstructure.

Specifications

Classifications	EN ISO 14174 : S A AF 2
Welding Current	1200 A (Using 60x0.5 mm strip)
Slag Type	Fluoride basic CaF ₂ -Al ₂ O ₃ -SiO ₂
Density	nom: 1.0 Kg/l
Basicity Index	nom: 1.9 %

Flux Consumption

Volts	kg Flux / kg Wire DC+
34 V	0.8 kg
30 V	0.6 kg
26 V	0.5 kg
38 V	1.0 kg

Condition : Dimension 4.0 mm , Amps 580 A , Travel speed 33 m/h

Classifications

Wire	AWS/EN
Exaton 19.12.3.LCRYO	A5.9:ER316L/ 14343-A:S 19 12 3 L
Exaton 19.9	A5.9:ER308/308H/ 14343-A:S 19 9 H

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	S	P	Ni	Cr	Mo	N	Ferrite FN
Exaton 19.12.3.LCRYO									
0.021	1.5	0.5	0.003	0.023	12.8	18	2.3	0.06	3

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Exaton 19.12.3.LCRYO	As Welded	415 MPa (60 ksi)	560 MPa (81 ksi)	34 %	88 J @ -60 °C (65 ft-lb @ -76 °F) 70 J @ -110 °C (52 ft-lb @ -166 °F) 46 J @ -196 °C (34 ft-lb @ -320.8 °F)