Exaton 19.9.L

Exaton 19.9.L is suitable for joining stainless steels of the 18Cr/8Ni/ELC and 18Cr/8Ni/Nb types for service temperatures up to 350°C (660°F). It is also suitable for welding in cryogenic applications, typically: manufacturing of dewars, containers, tanks, cryostats, and transfer systems for transportation and storage of LNG, LPG, liquid nitrogen and liquid helium. The chemical composition is also optimized for cryogenic applications in terms of impact strength and other characteristics. It has a controlled chemical composition and ferrite content for resistance to microfissuring, and balanced minor additions of certain elements for optimum arc stability, fluidity and low spatter. It is intended for Submerged Arc Welding in combination with Exaton Flux 15W or Exaton Flux 10SW.

Specifications	
Classifications	EN ISO 14343-A : S 19 9 L SFA/AWS A5.9 : ER308L Werkstoffnummer : ~1.4316
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 03771

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**	**N**
<0.025	1.8	0.4	<0.015	<0.025	10.0	20	<0.5	<0.3	<0.08

Typical Wire Composition %
Co
<0.20