

Exaton 19.9.Nb

Filler metal Exaton 19.9.Nb is suitable for joining stainless steels of the 18Cr/8Ni/Nb and 18Cr/8Ni/Ti types. Due to the strengthening effect of niobium, this grade is recommended if the weld metal will be exposed to temperatures above 400°C (750°F). It is used for Submerged Arc Welding in combination with Exaton Flux 15W or Exaton Flux 10SW.

Specifications	
Classifications	EN ISO 14343-A : S 19 9 Nb SFA/AWS A5.9 : ER347
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 03771

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

Typical Wire Composition %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.04	1.3	0.35	0.012	0.015	9.5	19.5	0.03	0.11	0.06

Typical Wire Composition %				
Nb	Co	FN deLong	FN WRC	Nb+Ta
0.6	0.1	5	5	0.6