

Exaton 49S

Exaton 49S is a basic, agglomerated flux for electroslag strip surfacing. This flux is particularly intended for high-speed welding. In spite of high welding speed, flux Exaton 49S gives excellent slag removal and bead appearance, also for niobium-alloyed strip electrodes.

It is used together with strip electrodes of the chromium, chromium-nickel and chromium-nickel-molybdenum steel types with or without niobium.

Классификации	EN ISO 14174 : (E) S A FB 2
Сварочный ток	2200 A (Using 60x0.5 mm strip)
Тип шлака	Fluoride basic CaF ₂ -Al ₂ O ₃
Плотность	nom 1.0 Kg/l
Показатель щелочности	nom 4.4

Classifications

Wire	SFA/AWS - EN ISO
Exaton 19.12.3.L	A5.9:EQ316L/ 14343-A:B 19 12 3 L
Exaton 19.13.4.L	A5.9:EQ317L/ 14343-A:B 19 13 4 L
Exaton 19.9.L	A5.9:EQ308L/ 14343-A:B 19 9 L
Exaton 19.9.LNb	A5.9:EQ347/ 14343-A:B 19 9 Nb
Exaton 21.11.LNb	A5.9:EQ"309LNb"/ 14343-A:B 22 11 L Nb
Exaton 22.11.L	A5.9:EQ(309L)/ 14343-A:B 22 11 L
Exaton 23.11.LNb	A5.9:EQ"309LNb"/ 14343-A:B 23 12 L Nb
Exaton 24.13.L	A5.9:EQ309L/ 14343-A:B 23 12 L
Exaton 24.13.LNb	A5.9:EQ"309LNb"/ 14343-A:B 23 12 Nb

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 19.12.3.L Layer 1 with "24.13.L"									
<=0.03	-	-	-	-	12.0	17.7	2.2	-	-
Exaton 19.13.4.L Layer 1 with "24.13.L"									
<=0.03	-	-	-	-	13.0	18.5	2.7	-	-
Exaton 19.9.L Layer 1 with "24.13.L"									
<=0.03	-	-	-	-	10	19.2	-	-	-
Exaton 19.9.LNb (Layer 1 with "24.13.L" & Layer 2 with "19.9.LNb")									
0.02	1.3	0.3	-	-	10.6	19.5	0.1	-	0.03
Exaton 19.9.LNb (Layer 1 with "24.13.LNb" & Layer 2 with "19.9.LNb")									
0.02	1.4	0.3	-	-	10.5	19.6	0.1	-	0.03
Exaton 21.11.LNb (1 layer)									
0.02	1.4	0.4	-	-	9.7	18.9	0.1	-	0.05
Exaton 23.11.LNb 1 layer with "23.11.LNb"									
<=0.05	-	-	-	-	9.7	-	-	-	-
Exaton 24.13.L									
<=0.07	-	-	-	-	10.2	19	-	-	-
Exaton 24.13.LNb									
<=0.06	-	-	-	-	9.7	18.5	-	-	-

Nb	Ferrite FN	FN WRC-92
Exaton 19.12.3.L Layer 1 with "24.13.L"		
-	6	-
Exaton 19.13.4.L Layer 1 with "24.13.L"		
-	6	-
Exaton 19.9.L Layer 1 with "24.13.L"		
-	8	-
Exaton 19.9.LNb (Layer 1 with "24.13.L" & Layer 2 with "19.9.LNb")		
0.3	-	-
Exaton 19.9.LNb (Layer 1 with "24.13.LNb" & Layer 2 with "19.9.LNb")		
0.4	-	-
Exaton 21.11.LNb (1 layer)		
0.5	-	-

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Nb	Ferrite FN	FN WRC-92
Exaton 23.11.LNb 1 layer with "23.11.LNb"		
-	-	6.5
Exaton 24.13.L		
-	6	-
Exaton 24.13.LNb		
-	5	-