

Exaton 50SW

Exaton 50SW is a basic agglomerated flux with low silicon pickup. It gives good slag removal, good tie-ins and a finely rippled surface. It is suitable for welding with either wire or strip electrodes of nickel alloy type. It is particularly suitable for surfacing with Exaton Ni72HP strip electrodes (EQNiCr-3 type).

Typical applications for flux Exaton 50SW are found in nuclear and chemical equipment fields. It is also suitable for dissimilar material welding of nickel alloy grades to stainless steel grades.

Классификации	EN ISO 14174 : S A AF 2
Сварочный ток	900 A (Using 60x0.5 mm strip)
Тип шлака	Fluoride basic CaF ₂ -Al ₂ O ₃ -(TiO ₂)-(MnO)
Плотность	nom 1.2 Kg/l
Показатель щелочности	nom 2.4

Classifications

Wire	SFA/AWS - EN ISO
Exaton Ni41Cu	A5.14:ERNiFeCr-1/ 18274:S Ni 8065
Exaton Ni72HP	A5.14:EQNiCr-3/ 18274:B Ni 6082
Exaton Ni72HP	A5.14:EQNiCr-3/ 18274:B Ni 6082

Approvals

Combined with Wire	VdTÜV
Exaton Ni72HP	•

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton Ni41Cu									
<=0.030	0.8	0.3	<=0.010	<=0.02	40.0	21.5	2.8	2.1	-
Exaton Ni72HP									
0.010	3.3	0.50	0.005	0.012	Bal	18.8	0.1	0.02	-

Nb	Ti	Co	Fe
Exaton Ni41Cu			
-	-	-	30.0
Exaton Ni72HP			
2.2	0.15	0.02	10