

## Exaton 69S

Exaton 69S is a highly basic, agglomerated flux for electroslag strip surfacing. It gives excellent slag removal and bead appearance.

Flux Exaton 69S is used together with strip electrodes of nickel alloy type, such as EQNiCr-3, EQNiCrMo-3, EQNiFeCr-1 and ERNiCrFe-7 or similar.

<b>Классификации</b>	EN ISO 14174 : ES A FB 2B
<b>Сварочный ток</b>	2500 A (Using 60x0.5 mm strip)
<b>Тип шлака</b>	Fluoride basic CaF <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub>
<b>Плотность</b>	nom 1.0 Kg/l
<b>Показатель щелочности</b>	nom 5.4

### Classifications

Wire	SFA/AWS - EN ISO
Exaton Ni41Cu	A5.14:EQNiFeCr-1/ 18274:B Ni 8065
Exaton Ni56 ESW	A5.14:EQNiCrMo-4/ 18274:B Ni6276 (NiCr15Mo16Fe6W4)
Exaton Ni60	A5.14:EQNiCrMo-3/ 18274:B Ni 6625 (NiCr22Mo9Nb)
Exaton Ni72HP	A5.14:EQNiCr-3/ 18274:B Ni 6082

### Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
<b>Exaton Ni41Cu Alloy type 825 (1 layer)</b>									
0.029	0.57	0.46	-	-	38.5	19.9	2.7	-	1.9
<b>Exaton Ni41Cu Alloy type 825 (2 layer)</b>									
0.021	0.55	0.47	-	-	41.4	21.7	2.8	-	2.1
<b>Exaton Ni56 ESW</b>									
<0.02	0.1	<0.4	<0.01	<0.02	59	15.6	15.9	<0.05	<0.1
<b>Exaton Ni60 Alloy Type 625 (2 layer)</b>									
0.019	0.08	0.46	-	-	-	21.8	9.2	-	0.05

Nb	Co	Fe	W
<b>Exaton Ni41Cu Alloy type 825 (1 layer)</b>			
0.01	-	34	-
<b>Exaton Ni41Cu Alloy type 825 (2 layer)</b>			
0.01	-	30	-
<b>Exaton Ni56 ESW</b>			
-	<0.1	5	3.8
<b>Exaton Ni60 Alloy Type 625 (2 layer)</b>			
3.3	-	2.1	-