

Exaton 47S

Exaton 47S is a highly basic welding flux for electrosag strip surfacing. It gives excellent slag removal and bead appearance also for niobium-alloyed strip electrodes.

Flux Exaton 47S is used together with strip electrodes of steel types chromium, chromium-nickel and chromium-nickel-molybdenum with or without niobium.

The high basicity of flux Exaton 47S makes it especially suitable for duplex, super-duplex and fully austenitic stainless steel surfacings.

Классификации	EN ISO 14174 : (E) S A FB 2
Сварочный ток	1700 A (Using 60x0.5 strip)
Тип шлака	Fluoride basic CaF ₂ -Al ₂ O ₃
Плотность	nom 1.0 Kg/l
Показатель щелочности	nom 4.0

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
25 V	0.5 kg	-

Dimensions	Amps	Travel Speed
-	1250 A	9 m/h

Classifications

Wire	SFA/AWS - EN ISO
24.29.5.LCu ESW	A5.9:EQ(385)
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 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L
Exaton 22.11.L	A5.9:EQ(309L)/ 14343-A:B 22 11 L
Exaton 22.8.3.L	A5.9:EQ2209/ 14343-A:B 22 9 3 N L
Exaton 24.13.LNb	A5.9:EQ"309LNb"/ 14343-A:B 23 12 Nb
Exaton 25.22.2.LMn	A5.9:EQ"310LMo"/ 14343-A:B 25 22 2 N L

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
24.29.5.LCu ESW DC+, 1600A, 24V, 26cm/min, SO 30mm.									
0.026	1.7	0.41	0.003	0.014	24.9	20.3	4.7	1.65	-
Exaton 19.12.3.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	12	18.2	2.3	-	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"									
<=0.03	-	-	-	-	13.2	18.5	3.4	-	-
Exaton 19.13.4.L 1st layer with "22.11.L"									
<=0.03	-	-	-	-	13	18.5	3.2	-	-
Exaton 19.9.L 1st layer with "22.11.L"									
<=0.030	-	-	-	-	10	19.5	-	-	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")									
0.01	1.2	0.4	0.009	0.014	10.5	19.2	0.1	0.06	0.03
Exaton 21.11.LNb (1-layer)									
0.02	1.3	0.5	0.002	0.012	10.1	19.3	0.1	0.03	0.05
Exaton 21.13.3.L (1 layer)									
0.02	1.1	0.4	0.002	0.013	12.5	18.7	2.7	0.06	0.03
Exaton 22.11.L									
<=0.06	-	-	-	-	9.7	18.5	-	-	-
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"									
<=0.02	-	-	-	-	8.5	22.5	3.0	-	0.15
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"									

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Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.02	-	-	-	-	8.5	22.5	3.1	-	0.16
Exaton 24.13.LNb (1 layer)									
0.03	1.5	0.4	0.002	0.011	10.7	20.8	0.2	0.04	0.04
Exaton 25.22.2.LMn (2 layers)									
0.02	3.5	0.4	0.002	0.016	22.0	24.6	2.0	-	0.14

Nb	Nb+Ta	Ferrite FN	FN WRC-92
24.29.5.LCu ESW DC+, 1600A, 24V, 26cm/min, SO 30mm.			
-	-	-	-
Exaton 19.12.3.L 1st layer with "22.11.L"			
-	-	6	-
Exaton 19.13.4.L 1st layer with "21.13.3.L"			
-	-	6	-
Exaton 19.13.4.L 1st layer with "22.11.L"			
-	-	6	-
Exaton 19.9.L 1st layer with "22.11.L"			
-	-	8	-
Exaton 19.9.LNb (Layer 1 with "21.11.L" & Layer 2 with "19.9.LNb")			
-	0.3	-	8
Exaton 21.11.LNb (1-layer)			
-	0.5	-	9
Exaton 21.13.3.L (1 layer)			
-	-	-	8
Exaton 22.11.L			
-	-	6	-
Exaton 22.8.3.L Layer 1 with "22.11.L" & 2 layers with "22.8.3.L"			
-	-	45	-
Exaton 22.8.3.L Layer 1 with "22.8.3.L" & 2 layers with "22.8.3.L"			
-	-	45	-
Exaton 24.13.LNb (1 layer)			
-	0.6	-	13
Exaton 25.22.2.LMn (2 layers)			
-	-	-	0