Exaton 10SW

Exaton 10SW is a chromium-compensating agglomerated flux giving good slag removal and a fine bead appearance. It is suitable for welding with wire and strip electrodes of the chromium & chromium-nickel and chromium-nickel-molybdenum steel types either with or without niobium.

Exaton 10SW is an all round flux which can be used for many applications varying from surfacing continuous caster rolls to large components in chemical plants.

Классификации	EN ISO 14174 : S A CS 2 Cr

Сварочный ток	1200 A (Using 60x0.5 mm strip)
Тип шлака	Calcium silicate SiO2-MgO-Al2O3-(CaF2)
Плотность	nom 1.0 kg/l
Показатель щелочности	nom 1.0

Flux Consumption

Volts	kg Flux / kg Wire DC+	kg Flux / kg Wire AC
26 V	0.4 kg	-
30 V	0.55 kg	-
34 V	0.7 kg	-
38 V	0.9 kg	-

Dimensions	Amps	Travel Speed
4.0 mm	580 A	33 m/h

Classifications

Wire	SFA/AWS - EN ISO	AWS - As Welded
Exaton 19.12.3.L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F80A10-ER316L/316L
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Exaton 19.12.3.L	A5.9:ER316L/ 14343-A:S 19 12 3 L	A5.39: F80A10-ER316L/316L
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.L	A5.9:EQ308L/ 14343-A:B 19 9 L	
Exaton 19.9.LNb	A5.9:EQ347/ 14343-A:B 19 9 Nb	
Exaton 19.9.Nb	A5.9:ER347/ 14343-A:S 19 9 Nb	
Exaton 21.13.3.L	A5.9:EQ(309LMo)/ 14343-A:B 21 13 3 L	
Exaton 22.8.3.L	A5.9:EQ2209/ 14343-A:B 22 9 3 N 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	

Approvals

Combined with Wire	VdTÜV
19.9.LNb ESW	•
Exaton 19.12.3.L	•
Exaton 19.9.L	•
Exaton 19.9.LNb	•
Exaton 19.9.Nb	•
Exaton 22.8.3.L	•

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Exaton 19.12.3.L	As Welded hr	420 MPa	580 MPa	32 %	69 J @ 20°C 60 J @ -40°C 55 J @ -70°C 50 J @ -196°C
Exaton 19.9.L	As Welded hr	400 MPa	580 MPa	38 %	69 J @ 20°C 59 J @ -40°C 40 J @ -196°C
Exaton 19.9.Nb	As Welded Joining	440 MPa	625 MPa	38 %	72 J @ 20°C 61 J @ -40°C 34 J @ -196°C

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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" & Layer 2 with "19.12.3.L")									
0.02	0.8	0.7	-	-	11.5	19.0	2.2	-	0.06
Exaton 19.12.3.L 2.4mm, DC+ 400A, 28V, 50 cm/min									
0.02	1.2	0.65	-	-	11.5	18.5	2.4	0.16	0.05
Exaton 19.13.4.L Layer 1 with "21.13.3.L"									
<=0.04	-	-	-	-	13	18.5	3.3	-	-
Exaton 19.9.L 1st layer with "24.13.L"									
<=0.03	-	-	-	-	10.0	19.7	-	-	-
Exaton 19.9.LNb ASTM 347 (Layer 1 with "24.13.LNb")									
0.02	0.8	0.6	-	-	10.4	21.0	0.0	-	0.05
Exaton 19.9.Nb Layer 1 with "24.13.LHF" & 2 layers with "19.9.Nb"									
0.04	0.6	1.0	0.01	0.01	9.2	19.0	0.01	0.1	0.06
Exaton 22.8.3.L Layer 1 with "24.13.L" & 2 layers with "22.8.3.L"									
<=0.03	-	-	-	-	8.5	22.7	2.9	-	0.16
Exaton 23.11.LNb									
<=0.06	-	-	-	-	9.7	19	-	-	-
Exaton 24.13.L Layer 1 with "24.13.L"									
<=0.07	-	-	-	-	10.5	19.2	-	-	-
Exaton 24.13.LNb									
<=0.06	-	-	-	-	9.7	19.2	-	-	-

Nb	**Nb+Ta**	**Ferrite FN**	**FN WRC-92**
Exaton 19.12.3.L (Layer 1 with "24.13.L" & Layer 2 with "19.12.3.L")			
0	-	-	-
Exaton 19.12.3.L 2.4mm, DC+ 400A, 28V, 50 cm/min			
0.01	-	-	7
Exaton 19.13.4.L Layer 1 with "21.13.3.L"			
-	-	5	-
Exaton 19.9.L 1st layer with "24.13.L"			
-	-	8	-
Exaton 19.9.LNb ASTM 347 (Layer 1 with "24.13.LNb")			
0.3	-	-	-
Exaton 19.9.Nb Layer 1 with "24.13.LHF" & 2 layers with "19.9.Nb"			
0.3	0.3	-	-
Exaton 22.8.3.L Layer 1 with "24.13.L" & 2 layers with "22.8.3.L"			
-	-	40	-
Exaton 23.11.LNb			
-	-	7	-
Exaton 24.13.L Layer 1 with "24.13.L"			
-	-	6	-
Exaton 24.13.LNb			
-	-	6	-

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