

## 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.

|                              |   |
|------------------------------|---|
| <b>Классификации</b>         | EN ISO 14174 : (E) S A FB 2                                     |
| <b>Сварочный ток</b>         | 1700 A (Using 60x0.5 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 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    |
|---|-----|------|-------|-------|------|------|-----|------|------|
| <b>24.29.5.LCu ESW DC+, 1600A, 24V, 26cm/min, SO 30mm.</b>                    |     |      |       |       |      |      |     |      |      |
| 0.026   | 1.7 | 0.41 | 0.003 | 0.014 | 24.9 | 20.3 | 4.7 | 1.65 | -    |
| <b>Exaton 19.12.3.L 1st layer with "22.11.L"</b>                              |     |      |       |       |      |      |     |      |      |
| <=0.03  | -   | -    | -     | -     | 12   | 18.2 | 2.3 | -    | -    |
| <b>Exaton 19.13.4.L 1st layer with "21.13.3.L"</b>                            |     |      |       |       |      |      |     |      |      |
| <=0.03  | -   | -    | -     | -     | 13.2 | 18.5 | 3.4 | -    | -    |
| <b>Exaton 19.13.4.L 1st layer with "22.11.L"</b>                              |     |      |       |       |      |      |     |      |      |
| <=0.03  | -   | -    | -     | -     | 13   | 18.5 | 3.2 | -    | -    |
| <b>Exaton 19.9.L 1st layer with "22.11.L"</b>                                 |     |      |       |       |      |      |     |      |      |
| <=0.030   | -   | -    | -     | -     | 10   | 19.5 | -   | -    | -    |
| <b>Exaton 19.9.LNb (Layer 1 with "21.11.L" &amp; Layer 2 with "19.9.LNb")</b> |     |      |       |       |      |      |     |      |      |
| 0.01  | 1.2 | 0.4  | 0.009 | 0.014 | 10.5 | 19.2 | 0.1 | 0.06 | 0.03 |
| <b>Exaton 21.11.LNb (1-layer)</b>   |     |      |       |       |      |      |     |      |      |
| 0.02  | 1.3 | 0.5  | 0.002 | 0.012 | 10.1 | 19.3 | 0.1 | 0.03 | 0.05 |
| <b>Exaton 21.13.3.L (1 layer)</b>   |     |      |       |       |      |      |     |      |      |
| 0.02  | 1.1 | 0.4  | 0.002 | 0.013 | 12.5 | 18.7 | 2.7 | 0.06 | 0.03 |
| <b>Exaton 22.11.L</b>   |     |      |       |       |      |      |     |      |      |
| <=0.06  | -   | -    | -     | -     | 9.7  | 18.5 | -   | -    | -    |
| <b>Exaton 22.8.3.L Layer 1 with "22.11.L" &amp; 2 layers with "22.8.3.L"</b>  |     |      |       |       |      |      |     |      |      |
| <=0.02  | -   | -    | -     | -     | 8.5  | 22.5 | 3.0 | -    | 0.15 |
| <b>Exaton 22.8.3.L Layer 1 with "22.8.3.L" &amp; 2 layers with "22.8.3.L"</b> |     |      |       |       |      |      |     |      |      |

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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 |
| <b>Exaton 24.13.LNb (1 layer)</b>    |     |     |       |       |      |      |     |      |      |
| 0.03                                 | 1.5 | 0.4 | 0.002 | 0.011 | 10.7 | 20.8 | 0.2 | 0.04 | 0.04 |
| <b>Exaton 25.22.2.LMn (2 layers)</b> |     |     |       |       |      |      |     |      |      |
| 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 |
|---|-------|------------|-----------|
| <b>24.29.5.LCu ESW DC+, 1600A, 24V, 26cm/min, SO 30mm.</b>                    |       |            |           |
| -   | -     | -          | -         |
| <b>Exaton 19.12.3.L 1st layer with "22.11.L"</b>                              |       |            |           |
| -   | -     | 6          | -         |
| <b>Exaton 19.13.4.L 1st layer with "21.13.3.L"</b>                            |       |            |           |
| -   | -     | 6          | -         |
| <b>Exaton 19.13.4.L 1st layer with "22.11.L"</b>                              |       |            |           |
| -   | -     | 6          | -         |
| <b>Exaton 19.9.L 1st layer with "22.11.L"</b>                                 |       |            |           |
| -   | -     | 8          | -         |
| <b>Exaton 19.9.LNb (Layer 1 with "21.11.L" &amp; Layer 2 with "19.9.LNb")</b> |       |            |           |
| -   | 0.3   | -          | 8         |
| <b>Exaton 21.11.LNb (1-layer)</b>   |       |            |           |
| -   | 0.5   | -          | 9         |
| <b>Exaton 21.13.3.L (1 layer)</b>   |       |            |           |
| -   | -     | -          | 8         |
| <b>Exaton 22.11.L</b>   |       |            |           |
| -   | -     | 6          | -         |
| <b>Exaton 22.8.3.L Layer 1 with "22.11.L" &amp; 2 layers with "22.8.3.L"</b>  |       |            |           |
| -   | -     | 45         | -         |
| <b>Exaton 22.8.3.L Layer 1 with "22.8.3.L" &amp; 2 layers with "22.8.3.L"</b> |       |            |           |
| -   | -     | 45         | -         |
| <b>Exaton 24.13.LNb (1 layer)</b>   |       |            |           |
| -   | 0.6   | -          | 13        |
| <b>Exaton 25.22.2.LMn (2 layers)</b>  |       |            |           |
| -   | -     | -          | 0         |