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REASON FOR ISSUE

Product name changed from Sandvik to Exaton.

GENERAL

Exaton 49S is a basic, agglomerated flux for electroslag strip surfacing. This flux is particularly intended for high-speed welding. In spite of high welding speed, flux Exaton 49S gives excellent slag removal and bead appearance, also for niobium-alloyed strip electrodes.

It is used together with strip electrodes of the chromium, chromium-nickel and chromium-nickel-molybdenum steel types with or without niobium.

CLASSIFICATIONS Flux

EN ISO 14174 (E) S A FB 2

APPROVAL COMMENT

See Flux-Wire combinations

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃	20	
CaF ₂	70	
SiO ₂ +MgO	10	

Other properties:

Basicity (Boniszewski)	nom: 4.4
Bulk Density	nom: 1.0 Kg/l
Max Amperage Strip	2200 A (Using 60x0.5 mm strip)

OTHER DATA

Welding data: Direct current with electrode positive is normally used.

Flux consumption:

0.6 kg/kg strip electrode

Strip Welding Data:

Dimensions(mm)=60 x 0.50; Current(A)=1600-2200; Voltage(V)=23-26; Travel speed(mm/min)=250-450

Dimensions(mm)=90 x 0.50; Current(A)=2400-2800; Voltage(V)=23-26; Travel speed(mm/min)=250-350

Alloying vector:

The alloying vector describes the difference in chemical composition between the filler metal and the undiluted all-weld metal due to the influence of the flux. The following table presents data for flux Exaton 49S in combination with strip electrodes.

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METALLURGICAL BEHAVIOR

	19.9.LNb	24.13.LNb	19.12.3.L
C	-0.001	0	-0.001
Si	+0.2	+0.2	+0.2
Mn	-0.4	-0.4	-0.4
Cr	-0.4	-0.4	-0.3
Ni	-0.1	-0.1	0
Mo	0	0	0
Nb	-0.1	-0.1	-
N	0	0	0