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**REASON FOR ISSUE**

Product name changed from Sandvik to Exaton.

**GENERAL**

Exaton 50SW is a basic agglomerated flux with low silicon pickup. It gives good slag removal, good tie-ins and a finely rippled surface. It is suitable for welding with either wire or strip electrodes of nickel alloy type. It is particularly suitable for surfacing with Exaton Ni72HP strip electrodes (EQNiCr-3 type).

Typical applications for flux Exaton 50SW are found in nuclear and chemical equipment fields. It is also suitable for dissimilar material welding of nickel alloy grades to stainless steel grades.

**CLASSIFICATIONS Flux**

EN ISO 14174      S A AF 2

**APPROVAL COMMENT**

See Flux-Wire combinations

**SLAG TYPE**

Fluoride basic CaF<sub>2</sub>-Al<sub>2</sub>O<sub>3</sub>-(TiO<sub>2</sub>)-(MnO)

**CHEMICAL COMPOSITION**

	Flux (%)
	Nom
Al <sub>2</sub> O <sub>3</sub> +MnO	30
CaF <sub>2</sub>	52
SiO <sub>2</sub> +TiO <sub>2</sub>	14

**Other properties:**

<b>Basicity (Boniszewski)</b>	nom: 2.4
<b>Bulk Density</b>	nom: 1.2 Kg/l
<b>Max Amperage Strip</b>	900 A (Using 60x0.5 mm strip)

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**OTHER DATA**

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

Flux consumption:

0.7-0.8 kg/kg strip electrode

Strip Welding Data:

Dimensions(mm)=60 x 0.5; Current(A)=700; Voltage(V)=29; Travel speed(mm/min)=130

Wire Welding Data:

Diameter(mm)=3.25; Current(A)=400; Voltage(V)=30; Travel speed(mm/min)=400

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 50SW in combination with strip and wire electrodes.

**METALLURGICAL BEHAVIOR**

Element	Strip electrode	Wire electrode
	Sanicro 72HP	Sanicro 72HP
C	+0.003	+0.003
Si	+0.2	+0.1
Mn	±0	±0
Cr	-0.9	-0.8
Ni	±0	±0
Nb	-0.2	-0.2
Fe	±0	±0