Exaton 19.9.LR



Exaton 19.9.LR is a chromium-nickel covered electrode with acid rutile coating for welding of low carbon 18% Cr/10% Ni austenitic stainless steels. In cases where creep strength is of secondary importance Exaton 19.9.LR is suitable for welding stabilized austenitic steels, e.g. ASTM 321 and 347. When a weld metal similar to the parent metal is not required Exaton 19.9.LR can be used for welding ferritic and martensitic steels. The electrode has excellent arc stability, low spatter and fast burn off rate with minimal stub loss. It is also characterized by improved moisture resistance, self peeling slag, easy post weld finishing. Exaton 19.9.LR gives smooth uniform beads and works in any standard weld position.

Specifications	
Classifications	EN ISO 3581-A : E 19 9 L R 1 2 SFA/AWS A5.4 : E308L-17 Werkstoffnummer : 1.4316
Approvals	CE : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, AC
Ferrite Content	FN 3-10
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile
Min AC OCV	50

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	440 MPa	600 MPa	40 %

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.025	0.75	0.9	0.014	0.024	9.5	19	0.04	0.04	0.062

Typical Weld Metal Analysis %
FN WRC-92
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Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
3.2 x 350 mm	70-130 A	31 V	60 %	54 sec	1.4 kg/h
4.0 x 350 mm	90-180 A	32 V	60 %	56 sec	2.0 kg/h
5.0 x 350 mm	140-250 A	33 V	60 %	60 sec	2.8 kg/h