Exaton 24.13.LR



Exaton 24.13.LR is a high alloyed chromium-nickel covered electrode with rutile coating for welding of dissimilar joints between stainless steel and mild or low alloyed steels. It is also used to create buffer layers with a composition of 18%Cr/8%Ni before overlay alloys are deposited. 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, high resistance to porosity and easy post weld finishing. It provides smooth uniform beads and works in any standard weld position. Typical applications include welding of stainless steel to low alloyed steels, buffer layers on low alloy steels before overlays with 304 composition, welding of stainless steels of 23%Cr/12%Ni type, joining of ferritic/martensitic stainless steels of 12-18%Cr type.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 L R 3 2 SFA/AWS A5.4 : E309L-17 Werkstoffnummer : 1.4332
Approvals	CE : EN 13479

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

Welding Current	DC+, AC
Ferrite Content	FN 10-18
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile
Min AC OCV	55

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	480 MPa	560 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C	55 J
As Welded	-20 °C	45 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**FN WRC-92**
0.02	0.8	0.8	0.014	0.021	12.5	23	0.06	0.046	14

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300 mm	45-90 A	28 V	60 %	38 sec	1.1 kg/h
3.2 x 350 mm	65-120 A	29 V	60 %	51 sec	1.6 kg/h
4.0 x 350 mm	85-180 A	31 V	60 %	51 sec	2.5 kg/h
5.0 x 350 mm	110-250 A	32 V	60 %	58 sec	3.3 kg/h