

Exaton 19.9.L

Exaton 19.9.L is a filler material for TIG welding austenitic stainless steels, e.g. ASTM 304, 304L (18Cr/8Ni/ELC) and ferritic or martensitic stainless steels with maximum 19% Cr. It is also suitable for joining stainless steels of 18Cr/8Ni/Nb types, e.g. ASTM 347, for service temperatures up to 350°C (660°F).

The product is approved by TÜV for use at cryogenic temperatures down to 4K (-269°C (-452°F)). Typical cryogenic applications: manufacturing of dewars, containers, tanks, cryostats and transfer systems for transportation and storage of LNG, LPG, liquid nitrogen and liquid helium. Exaton 19.9.L meets the requirements of ASME Section VIII, Division 1, UHA 51 ((a) (3) (-a) (-1)) and others.

The chemical composition is optimized for cryogenic applications in terms of impact strength and other characteristics. It has a controlled chemical composition and ferrite content for resistance to microfissuring, and balanced minor additions of certain elements for optimum arc stability, fluidity and low spatter.

Classifications Wire Electrode	SFA/AWS A5.9 : ER308L EN ISO 14343-A : W 19 9 L Werkstoffnummer : 1.4316
Approvals	CE EN 13479 VdTUV 00064

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

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Low C
Shielding Gas	I1 (EN ISO 14175)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.011	1.9	0.3	0.008	0.018	10.1	19.6	0.3	0.15	0.06

Typical Weld Metal Analysis %

Nb	Ti	Co	FN WRC-92
0.01	0.003	0.05	6

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.010	1.8	0.4	0.009	0.020	10.8	19.8	0.2	0.2	0.05

Typical Wire Composition %

Nb	Ti	Co	FN WRC-92
0.01	0.003	0.10	6