

Exaton 22.15.3.L

22.15.3.L is an austenitic filler material for joining stainless steels to carbon steels or low-alloy steels and for overlay welding. It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER309LMo (mod) EN ISO 14343-A : W 23 12 2 L EN 10088-1 : ~1.4435
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Shielding Gas	I1 (EN ISO 14175)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	515 MPa (75 ksi)	630 MPa (91 ksi)	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	140 J (104 ft-lb)
As Welded	-196 °C (-321 °F)	30 J (22 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.01	1.4	0.30	0.002	0.02	14.6	21.1	2.6	0.05	0.1

Typical Weld Metal Analysis %

N	Nb	Co	B	FN WRC
0.06	0.01	0.05	0.0007	9

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.01	1.4	0.35	0.003	0.015	15.1	21.5	2.6	0.06	0.002

Typical Wire Composition %

Cu	N	Nb	Ti	Co	B	Ta	W	FN WRC
0.1	0.06	0.01	0.002	0.05	0.001	0.005	0.02	10