

## Exaton 22.12.HT

Exaton 22.12.HT is an austenitic filler material for welding the high temperature steel grade Sandvik 253 MA\*, UNS S30815. It is characterized by high creep strength, good resistance to oxidation and good weldability. It is used for TIG-welding.

<b>Classifications Wire Electrode</b>	EN ISO 14343-A : W 21 10 N EN 10088-1 : 1.4835
<b>Approvals</b>	CE EN 13479

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

<b>Shielding Gas</b>	I1 (EN ISO 14175)
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### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	135 J (100 ft-lb)
As Welded	-60 °C (-76 °F)	60 J (44 ft-lb)
As Welded	-110 °C (-166 °F)	30 J (22 ft-lb)

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.07	0.6	1.6	0.0007	0.023	9.9	20.8	0.08	0.003	0.06

### Typical Weld Metal Analysis %

N	Nb	Ti	Co	B	Ce	FN deLong
0.14	0.005	0.002	0.04	0.0003	0.04	10

### Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.07	0.5	1.6	0.0007	0.020	10.2	21.0	0.1	0.01	0.1

### Typical Wire Composition %

N	Nb	Ti	Co	B	Ce	FN deLong
0.17	0.01	0.005	0.05	0.0008	0.04	9

Z Typical is 60% @ 20 °C and 65% @ 900 °C