

## Exaton 22.8.3.L

Exaton 22.8.3.L is used for welding of duplex stainless steels such as Sandvik SAF 2205 and SAF 2304. It can also be used for welding of duplex stainless steels to carbon steel. It can be used for plasma welding and overlay welding using hot wire TIG and mechanical TIG.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.9 : ER2209 EN ISO 14343-A : G 22 9 3 N L EN ISO 14343-B : 2209
<b>Approvals</b>	CE EN 13479 DNV-GL Stainless steel* VdTÜV 19479

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

<b>Alloy Type</b>	Austenitic-ferritic (duplex) with approx. 55 FN ferrite - 22.5% Cr - 8% Ni - 3% Mo - Low C
<b>Shielding Gas</b>	M12, M13 (EN ISO 14175)

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	110 J
As Welded	-20 °C	105 J
As Welded	-40 °C	100 J
As Welded	-46 °C	95 J
As Welded	-50 °C	90 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.014	1.5	0.45	0.001	0.017	8.5	23	3.0	0.09	0.15

### Typical Weld Metal Analysis %

Nb	W	PRE	FN WRC-92
0.01	0.01	35.3	52

### Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.012	1.5	0.5	0.0007	0.018	8.6	23	3.2	0.05	0.09

### Typical Wire Composition %

N	Nb	Ti	Co	W	PRE	FN WRC-92
0.15	0.01	0.003	0.04	0.01	37	55

### Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm	40-120 A	15-19 V	4.0-8.0 m/min
1.0 mm	60-220 A	15-28 V	4.0-12.0 m/min
1.2 mm	150-260 A	24-29 V	3.0-10.0 m/min
1.6 mm	230-350 A	25-30 V	3.0-5.0 m/min