

Exaton 24.13.LSi

Exaton 24.13.LSi is suitable for joining stainless chromium-nickel steels of the ASTM 309 type, chromium steels and dissimilar metals e.g. austenitic stainless steel to carbon or low-alloyed steel. It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER309LSi EN ISO 14343-A : W 23 12 L Si
Approvals	CE EN 13479

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

Alloy Type	Austenitic (with approx. 9 % ferrite) 24 % Cr - 13 % Ni - Low C- High Si
Shielding Gas	I1 (EN ISO 14175)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.7	0.9	0.01	0.02	13.6	23.7	0.2	0.1	0.1

Typical Weld Metal Analysis %

Nb	Co	FN deLong	FN WRC-92
0.03	0.05	12	9

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.015	1.6	0.9	0.01	0.02	13.7	23.5	0.2	0.1	0.1

Typical Wire Composition %

Nb	Co	FN deLong	FN WRC-92
0.01	0.06	11	7