Exaton 24.13.L

24.13.L is suitable for joining stainless Cr-Ni steels of the 309 type, Cr-steels and dissimilar steels e.g. austenitic stainless steel to carbon or low-alloyed steels for service up to 320°C (610°F). Widely used as barrier layer between carbon/low alloy steel and different stainless grades in cladding operations. It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER309L EN ISO 14343-A : W 23 12 L
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
Shielding Gas	I1 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	167 J
As Welded	-40 °C	140 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.01	1.67	0.40	0.014	0.018	13	23.5	0.04	0.03	0.04

Typical Weld Metal Analysis %

N	Nb	Co	FN WRC-92
0.08	0.01	0.03	12

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<0.02	1.8	0.4	0.01	0.01	13.5	23.5	<0.1	<0.1	0.08

Typical Wire Composition %

FN WRC-92
10

13780-en_GB-FactSheet_Main-01 2022-05-27