

Exaton 22.11.L

Exaton 22.11.L is a chromium-nickel strip electrode used for electro-slag welding (ESW) to deposit a single layer overlay of corrosion resistant alloy of 19%Cr/9%Ni composition on carbon- and low alloyed steels. It can also be combined with 19.9.L for surfacing of two layer overlays.

Specifications

Classifications	EN ISO 14343-A : B 22 11 L SFA/AWS A5.9 : EQ(309L)
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Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	FN WRC-92
<=0.015	1.8	0.2	<=0.020	<=0.020	11.5	21	<=0.3	<=0.1	13