Exaton 24.13.L

Exaton 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 Submerged Arc Welding and the recommended flux is Exaton 15W.

Specifications	
Classifications	EN ISO 14343-A : S 23 12 L SFA/AWS A5.9 : ER309L
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

Typical Tensile Properties	
Condition	**Yield Strength**
As Welded	16 MPa

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**Co**
<0.02	1.8	0.4	<0.015	<0.02	13.5	23.5	<0.3	<0.2	<0.1

Deposition Data		
Length	**Fusion time per electrode at 90% I max**	**Deposition Rate @ 90% I max**
2 mm	2 sec	2.1 kg/h

Recommended Welding Parameters		
Current	**Wire Diameter**	**TTW Dist.**
80 A	1 mm	1 mm