

Prepared by Karthikeyan K.	Qualified by P-O Oskarsson	Approved by Paolo Torchiana	Reg no EN008965	Cancelling EN008372	Reg date 2020-01-21	Page 1 (2)
-------------------------------	-------------------------------	--------------------------------	--------------------	------------------------	------------------------	---------------

REASON FOR ISSUE

Product name changed from Sandvik to Exaton.

GENERAL

Exaton 47S is a highly basic welding flux for electros slag strip surfacing. It gives excellent slag removal and bead appearance also for niobium-alloyed strip electrodes.

Flux Exaton 47S is used together with strip electrodes of steel types chromium, chromium-nickel and chromium-nickel-molybdenum with or without niobium.

The high basicity of flux Exaton 47S makes it especially suitable for duplex, super-duplex and fully austenitic stainless steel surfacings.

CLASSIFICATIONS Flux

EN ISO 14174 (E) S A FB 2

APPROVAL COMMENT

See Flux-Wire combinations

SLAG TYPE

Fluoride basic CaF₂-Al₂O₃

CHEMICAL COMPOSITION

	Flux (%)	
	Nom	
Al ₂ O ₃	25	
CaF ₂	63	
SiO ₂ +MgO	8	

Other properties:

Basicity (Boniszewski)	nom: 4.0
Bulk Density	nom: 1.0 Kg/l
Max Amperage Strip	1700 A (Using 60x0.5 strip)

FLUX CONSUMPTION

Arc Voltage	(kg Flux / kg Wire/Strip)	
	DC+	AC
25	0.5	
Current (A):	1250	
Travel Speed (m/h):	9	

Prepared by Karthikeyan K.	Qualified by P-O Oskarsson	Approved by Paolo Torchiana	Reg no EN008965	Cancelling EN008372	Reg date 2020-01-21	Page 2 (2)
-------------------------------	-------------------------------	--------------------------------	--------------------	------------------------	------------------------	---------------

OTHER DATA

Welding data: Direct current with electrode positive is normally used.

Flux consumption:

0.6 kg/kg strip electrode

Strip Welding Data:

Dimensions(mm)=60 x 0.50; Current(A)=1100-1400; Voltage(V)=23-26; Travel speed(mm/min)=130-220

Dimensions(mm)=90 x 0.50; Current(A)=1650-2100; Voltage(V)=23-26; Travel speed(mm/min)=130-220
