

Exaton SX

Exaton SX is a high silicon containing austenitic stainless steel wire for joining Sandvik SX steel (UNS S32615). The wire is developed for use in concentrated sulfuric acid.

Classifications Wire Electrode	EN ISO 14343-A : G Z 18 13 L
Approvals	CE EN 13479

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

Alloy Type	Austenitic - 19%Cr 13%Ni 5%Si 2%Cu - Low C
Shielding Gas	I1 (EN ISO 14175)

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.7	4.9	0.002	0.011	13.5	18.5	0.02	2.0	0.06

Typical Wire Composition %

Nb	Co
0.01	0.02

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)