

Exaton 22.12.HT

Exaton 22.12.HT is an austenitic filler material for welding the high temperature steel grade Sandvik 253 MA*, UNS S30815. It is characterized by high creep strength, good resistance to oxidation and good weldability. It is used for MIG/MAG welding.

Classifications Wire Electrode	EN ISO 14343-A : G 21 10 N EN 10088-1 : 1.4835
Approvals	CE EN 13479

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

Shielding Gas	I1 (EN ISO 14175)
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Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	125 J (93 ft-lb)
As Welded	-110 °C (-166 °F)	40 J (30 ft-lb)
As Welded	-196 °C (-321 °F)	15 J (11 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.08	0.6	1.6	0.0009	0.024	9.9	20.7	0.08	0.003	0.06

Typical Weld Metal Analysis %

N	Nb	Ti	Co	B	Ce	FN deLong
0.17	0.005	0.002	0.04	0.0002	0.04	6

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.07	0.5	1.6	0.0007	0.020	10.2	21.0	0.1	0.01	0.1

Typical Wire Composition %

N	Nb	Ti	Co	B	Ce	FN deLong
0.17	0.01	0.005	0.05	0.0008	0.04	9

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)