

Exaton 25.22.2.LMnB

Exaton 25.22.2.LMnB is a chromium-nickel-molybdenum covered electrode with basic coating for welding of austenitic stainless steels for example, Sandvik 2RE69 and Sandvik 3R60 U.G used in the production of ammonium carbamate, nitric acid and inorganic acids. It is also used for surfacing on low alloyed steels. The electrode combines good welding properties such as arc stability, low spatter and self peeling slag with very low impurity levels. The fully austenitic weld metal (maximum 0.6% ferrite) is very resistant to hot cracking. Exaton 25.22.2.LMn is used for welding of Sandvik 2RE69 and Sandvik 3R60 U.G. urea grade materials. But it can also be used for the following types: ISO 1.4466, 1.4335, 1.4435, 1.4436, 1.4477, 1.4578 and 1.4585; UNS S31050, S31002, S31603 and S31600.

Spezifikationen

Klassifikationen	EN ISO 3581-A : E 25 22 2 N L B 12 SFA/AWS A5.4 : (E310Mo-15)
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Schweißstrom	DC+
Ferritanteil	FN 0
Legierungstyp	25Cr 22Ni 2Mo N
Umhüllungstyp	Basic

Typische Festigkeitseigenschaften

Zustand	Streckgrenze	Zugfestigkeit	Dehnung
ISO			
Unbehandelt	420 MPa	600 MPa	30 %

Typische Kerbschlagzähigkeit

Zustand	Prüftemperatur	Kerbschlagarbeit
ISO		
Unbehandelt	20 °C	70 J

Typische Schweißgutrichtanalyse %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.04	4.5	0.4	<=0.020	<=0.020	22	25	2.1	0.05	0.14

Typische Schweißgutrichtanalyse %

FN WRC-92
0

Leistungsdaten

Durchmesser	Strom	Ausbringen (%)	Abschmelzzeit / Elektrode	Abschmelzleistung bei 90 % I max
2.5 x 300.0 mm	60-80 A			0.0 kg/h
3.2 x 350.0 mm	80-110 A	64 %	55 sec	1.7 kg/h
4.0 x 350.0 mm	110-140 A	53 %	75 sec	2.3 kg/h