

Exaton 22.9.3.LB

Exaton 22.9.3.LB is a chromium-nickel-molybdenum-nitrogen covered electrode with basic coating for welding of 22-23%Cr duplex (austenitic-ferritic) stainless steels (e.g. SAF 2205). The basic type of electrode combines good welding properties in all positions and high impact strength at low temperatures. The weld metal is characterized by high strength and very good pitting corrosion resistance as well as very good resistance to stress corrosion cracking in chloride containing media. Exaton 22.9.3.LB is used for welding of duplex and lean duplex stainless steels in service temperatures up to 280°C (536°F). It is also used in applications where good impact toughness properties is required below -40°C. Typical base materials to be welded are ISO: 1.4462, 1.4362, 1.4162, 1.4662, 1.4660 and 1.4417.

Specificaties

Classificaties	EN ISO 3581-A : E 22 9 3 N L B SFA/AWS A5.4 : E2209-15 Werkstoffnummer : 1.4462
Goedkeuringen	BV : E2209-15 CE : EN13479 DNV : Duplex UKCA : EN13479

Goedkeuringen zijn gebaseerd op fabriekslocatie. Neem contact op met ESAB voor meer informatie.

Lasstroom	DC+
Ferrietgehalte	FN 35-50
Legering Type	Duplex CrNiMoN
Coating Type	Basic

Typische Mechanische Eigenschappen

Conditionering	Reksgrens	Treksterkte	Rek
ISO			
Zoals gelast	670 MPa	840 MPa	27 %

Kerfslageigenschappen

Conditionering	Testtemperatuur	Kerfslagwaarde
ISO		
Zoals gelast	20 °C	110 J
Zoals gelast	-46 °C	80 J
Zoals gelast	-60 °C	67 J

Typische lasmetaalanalyse (%)

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.04	1	0.6	<=0.025	<=0.03	9	23	3.2	0.1	0.18

Typische lasmetaalanalyse (%)

PRE	FN WRC-92
>=35	44

Neersmeltgegevens

Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
2.5 x 300.0 mm	55-80 A	24 V	56 %	49 sec	0.7 kg/h
3.2 x 350.0 mm	70-115 A	24 V	60 %	61 sec	1.2 kg/h
4.0 x 350.0 mm	90-175 A	25 V	57 %	62 sec	1.6 kg/h