

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.

Specificaties

Classificaties	EN ISO 3581-A : E 25 22 2 N L B 12 SFA/AWS A5.4 : (E310Mo-15)
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Lasstroom	DC+
Ferrietgehalte	FN 0
Legering Type	25Cr 22Ni 2Mo N
Coating Type	Basic

Typische Mechanische Eigenschappen

Conditionering	Rekgrens	Treksterkte	Rek
ISO			
Zoals gelast	420 MPa	600 MPa	30 %

Kerfslageigenschappen

Conditionering	Testtemperatuur	Kerfslagwaarde
ISO		
Zoals gelast	20 °C	70 J

Typische lasmetaalanalyse (%)

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 lasmetaalanalyse (%)

FN WRC-92
0

Neersmeltgegevens

Diameter	Ampère	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
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