Exaton 27.31.4.LCuR

Exaton 27.31.4.LCuR is a covered electrode of AWS E383-17 type with rutile coating and normal metal recovery for welding of high-alloy austenitic stainless steels of UNS S08028 (e.g. Sanicro 28) and Alloy 825 type (e.g. Sanicro 41). Exaton 27.31.4.LCuR is suitable for joining highly alloyed fully austenitic stainless steels, such as EN 1.4563 (Sanicro 28) and Alloy 825 (Sanicro 41), which have high corrosion resistance in sulphuric and phosphoric acids and excellent pitting resistance in acid solutions containing chlorides and fluorides, such as sea water. This electrode can be used for surfacing mild and low alloy steels to give protection against pitting corrosion in chloride-containing solutions. Because the product is a bit sensitive for forming hotcracks, a correct welding practice is important.

Specificaties	
Classificaties	EN ISO 3581-A : E 27 31 4 Cu L R SFA/AWS A5.4 : E383-17 Werkstoffnummer : 1.4563
Goedkeuringen	CE : EN 13749 UKCA : EN 13749

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

Lasstroom	AC, DC+
Ferrietgehalte	FN 0
Legering Type	Austenitic CrNiMo
Coating Type	Acid Rutile

Typische Mechanische Eigenschappen			
Conditionering	**Rekgrens**	**Treksterkte**	**Rek**
ISO			
Zoals gelast	427 MPa	612 MPa	38 %

Kerfslageigenschappen		
Conditionering	**Testtemperatuur**	**Kerfslagwaarde**
ISO		
Zoals gelast	20 °C	66 J

Typische lasmetaalanalyse (%)									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
<=0.025	0.90	0.8	0.006	0.018	32	27	3.5	0.9	0.07

Typische lasmetaalanalyse (%)
Co
0.060

Neersmeltgegevens					
Diameter	**Ampère**	**Volt**	**Rendement (%)**	**Smelttijd per elektrode bij 90% I max**	**Neersmelt**
2.5 x 300.0 mm	40-95 A	30 V	60 %	33 sec	1.2 kg/h
3.2 x 350.0 mm	55-125 A	30 V	60 %	50 sec	1.6 kg/h
4.0 x 350.0 mm	70-185 A	31 V	61 %	48 sec	2.5 kg/h