

Exaton 23.12.2.LR

Exaton 23.12.2.LR is a high alloyed chromium-nickel-molybdenum covered electrode with rutile coating for welding of dissimilar joints between stainless steel and mild or low alloyed steels. It is also used to create buffer layers with a composition of 18%Cr/8%Ni/2%Mo before overlay alloys are deposited. The electrode has excellent arc stability, low spatter and fast burn off rate with minimal stub loss. It is also characterized by improved moisture resistance, self peeling slag, easy post weld finishing. Exaton 23.12.2.LR gives smooth uniform beads and works in any standard weld position. Typical applications are welding of stainless steels to mild or low alloy steels, buffer layers on low alloy steels before overlays of 316 composition, welding of medium carbon hardenable steels e.g. armor plate.

Specificaties	
Classificaties	EN ISO 3581-A : E 23 12 2 L R 3 2 SFA/AWS A5.4 : E309LMo-17 Werkstoffnummer : 1.4459
Goedkeuringen	CE : EN 13479 DNV : NV 309 Mo UKCA : EN 13479 VdTÜV : 07790

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

Lasstroom	DC+, AC
Ferrietgehalte	FN 12-22
Legering Type	Austenitic CrNi
Coating Type	Acid Rutile

Typische Mechanische Eigenschappen			
Conditionering	Rek grens	Treksterkte	Rek
ISO			
Zoals gelast	560 MPa	790 MPa	30 %

Kerfslage eigenschappen		
Conditionering	Testtemperatuur	Kerfslagwaarde
ISO		
Zoals gelast	-20 °C	47 J
Zoals gelast	20 °C	57 J

Typische lasmetaalanalyse (%)									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	0.8	0.9	0.014	0.021	12.5	23	2.6	0.07	0.08

Typische lasmetaalanalyse (%)	
FN WRC-92	
18	

Neersmeltgegevens					
Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
2.5 x 300.0 mm	50-90 A	29 V	57 %	45 sec	0.9 kg/h
3.2 x 350.0 mm	60-120 A	27 V	59 %	61 sec	1.4 kg/h
4.0 x 350.0 mm	85-180 A	31 V	61 %	56 sec	2.0 kg/h