

Exaton 25.10.4.LB

Exaton 25.10.4.LB is a high alloyed chromium-nickel-molybdenum-nitrogen covered electrode with basic coating for welding of 25%Cr- and superduplex stainless steels (e.g. SAF 2507 and Zeron 100). The basic type of electrode combines good welding properties in all positions with high impact strength at low temperatures. The weld metal is characterized by high strength and very good corrosion resistance. Exaton 25.10.4.LB is used for welding of super duplex stainless steels in service temperatures up to 280°C (536°F), where good impact strength at temperatures down to -50°C is required. Common steel types include: ISO 1.4410, 1.4501 and 1.4507; UNS: S32750, S32760, S31260 and S32550. It can also be used as overmatching consumable for 21-23%Cr duplex stainless steels. The weld metals produced are not completely porosity free, but they fulfil the welding requirements described in ASME IX, Article 1 Welding Requirements- QW 191.1.

Specificaties

Classificaties	EN ISO 3581-A : E 25 9 4 N L B SFA/AWS A5.4 : E2594-15 Werkstoffnummer : (1.4410)
Goedkeuringen	CE : EN 13479 UKCA : EN 13479

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

Lasstroom	DC+
Ferrietgehalte	FN 35-55
Legering Type	Austenitic-Ferritic CrNiMo
Coating Type	Basic

Typische Mechanische Eigenschappen

Conditionering	Rekgrens	Treksterkte	Rek
ISO			
Zoals gelast	750 MPa	915 MPa	26 %

Kerfslageigenschappen

Conditionering	Testtemperatuur	Kerfslagwaarde
ISO		
Zoals gelast	20 °C	85 J
Zoals gelast	-50 °C	45 J

Typische lasmetaalanalyse (%)

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.03	0.8	0.6	<=0.025	<=0.03	10	25	4	0.07	0.25

Typische lasmetaalanalyse (%)

PRE	FN WRC-92
>=42	40

Neersmeltgegevens

Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
2.5 x 300.0 mm	50-80 A	22 V	62 %	50.2 sec	0.72 kg/h
3.2 x 350.0 mm	70-100 A	23 V	65 %	58.67 sec	1.2 kg/h
4.0 x 350.0 mm	100-150 A		73 %		2.0 kg/h