

Exaton 31S

31S is a neutral welding flux for submerged arc welding giving good slag removal and fine bead appearance. It is suitable for surfacing with strip and wire electrodes and can also be used for joining. 31S is intended primarily for welding with strip or wire electrodes of the 310LMo type such as 25.22.2.LMn for urea applications.

Spezifikationen

Klassifikationen	EN ISO 14174 : S A AB 2
Schweißstrom	1200
Dichte	nom: 0.9 Kg/l
Basizitätsgrad	nom: 1.0

Klassifikationen

Draht	EN/ISO/AWS
Exaton 25.22.2.LMn	14343-A:B 25 22 2 N L
Exaton 25.22.2.LMn	14343-A:S 25 22 2 N L

Zulassungen/Eignungsprüfungen

Draht

*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.

Drahtzusammensetzung

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 25.22.2.LMn									
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	0.05	0.13

Drahtzusammensetzung

FN WRC-92

Exaton 25.22.2.LMn

0

Typische Schweißgutrichtanalyse %

C	Mn	Si	S	P	Ni	Cr	Mo	N
Exaton 25.22.2.LMn								
0.02	3.8	0.6	-	-	22	24.5	2	0.12

Typische mech. Eigenschaften

Draht	Zustand	Streckgrenze	Zugfestigkeit	Dehnung	Kerbschlagarbeit KV
Exaton 25.22.2.LMn	Unbehandelt	380 MPa	570 MPa	40 %	75 J @ 20 °C 40 J @ -196 °C
Exaton 25.22.2.LMn	Unbehandelt	320 MPa	560 MPa	50 %	65 J @ -196 °C