

## 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.

Specifications	
<b>Classifications</b>	EN ISO 3581-A : E 25 9 4 N L B SFA/AWS A5.4 : E2594-15 Werkstoffnummer : (1.4410)
<b>Approvals</b>	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+
<b>Ferrite Content</b>	FN 35-55
<b>Alloy Type</b>	Austenitic-Ferritic CrNiMo
<b>Coating Type</b>	Basic

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As Welded	750 MPa	915 MPa	26 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
<b>ISO</b>		
As Welded	-50 °C	45 J
As Welded	20 °C	85 J

Typical Weld Metal Analysis %									
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

Typical Weld Metal Analysis %	
<b>PRE</b>	<b>FN WRC-92</b>
>=42	40

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
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