

## Exaton 25.10.4.L

Exaton 25.10.4.L welding wire has been specially developed for welding of Alleima SAF 2507 and other super-duplex steels. The grade is characterized by excellent resistance to stress corrosion in chloride-bearing environments and excellent resistance to pitting and crevice corrosion. Exaton 25.10.4.L can also be used for welding Alleima SAF 2205 and corresponding duplex steels when the highest possible corrosion resistance is required. It is used for Submerged Arc Welding and the recommended flux is Exaton 15W.

| Especificaciones |                                                        |
|------------------|--------------------------------------------------------|
| Clasificaciones  | EN ISO 14343-A : S 25 9 4 N L<br>SFA/AWS A5.9 : ER2594 |
| Aprobaciones     | CE : EN 13479<br>UKCA : EN 13479                       |

Las aprobaciones se basan en la ubicación de la fábrica. Póngase en contacto con ESAB para obtener más información.

| % Composición hilo (valores típicos) |     |     |        |       |     |    |    |      |      |
|--------------------------------------|-----|-----|--------|-------|-----|----|----|------|------|
| C                                    | Mn  | Si  | S      | P     | Ni  | Cr | Mo | V    | Cu   |
| 0.012                                | 0.4 | 0.3 | 0.0005 | 0.015 | 9.5 | 25 | 4  | 0.05 | 0.07 |

| % Composición hilo (valores típicos) |      |       |      |     |           |      |
|--------------------------------------|------|-------|------|-----|-----------|------|
| N                                    | Nb   | Ti    | Co   | PRE | FN WRC-92 | W    |
| 0.25                                 | 0.01 | 0.003 | 0.04 | 42  | 50        | 0.01 |