

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.

Tekniset tiedot	
Luokitukset	EN ISO 14174 : S A AB 2

Hitsausvirta	1200
Tiheys	nom: 0.9 Kg/l
Emäksisyys	nom: 1.0

Luokittelut	
Lanka	AWS / EN
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

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

Langan Koostumus									
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

Langan Koostumus	
FN WRC-92	
Exaton 25.22.2.LMn	
0	

Hitsiaineen Koostumus								
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

Tyypilliset mekaaniset ominaisuudet					
Lanka	Tila	Myötöraja	Murtolujuus	Venymä	Charpy V -iskusitkeys
Exaton 25.22.2.LMn	Hitsatussa tilassa	380 MPa	570 MPa	40 %	75 J @ 20 °C 40 J @ -196 °C
Exaton 25.22.2.LMn	Hitsatussa tilassa	320 MPa	560 MPa	50 %	65 J @ -196 °C