

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.

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

Hyväksynnät perustuvat tehtaan sijaintiin. Ota yhteyttä ESAB:iin saadaksesi lisätietoja.

Hitsausvirta	DC+
Ferriittipitoisuus	FN 35-55
Seostyyppi	Austenitic-Ferritic CrNiMo
Päällystetyyppi	Basic

Tyypilliset lujuusarvot			
Tila	Myötöraja	Murtolujuus	Venymä
ISO			
Hitsatussa tilassa	750 MPa	915 MPa	26 %

Charpy V -iskutkeys		
Tila	Testauslämpötila	Iskutkeys
ISO		
Hitsatussa tilassa	20 °C	85 J
Hitsatussa tilassa	-50 °C	45 J

Hitsiaineen Koostumus									
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

Hitsiaineen Koostumus	
PRE	FN WRC-92
>=42	40

Hitsausarvot					
Halkaisija	A	Jännite	Hyötyluku (%)	Puikon palo aika 90% maksivirralla	Sulatusnopeus 90 % I max
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