

Exaton 25.22.2.LMnB

Exaton 25.22.2.LMnB is a chromium-nickel-molybdenum covered electrode with basic coating for welding of austenitic stainless steels for example, Sandvik 2RE69 and Sandvik 3R60 U.G used in the production of ammonium carbamate, nitric acid and inorganic acids. It is also used for surfacing on low alloyed steels. The electrode combines good welding properties such as arc stability, low spatter and self peeling slag with very low impurity levels. The fully austenitic weld metal (maximum 0.6% ferrite) is very resistant to hot cracking. Exaton 25.22.2.LMn is used for welding of Sandvik 2RE69 and Sandvik 3R60 U.G. urea grade materials. But it can also be used for the following types: ISO 1.4466, 1.4335, 1.4435, 1.4436, 1.4477, 1.4578 and 1.4585; UNS S31050, S31002, S31603 and S31600.

Specifications

| | |
|------------------------|--|
| Classifications | EN ISO 3581-A : E 25 22 2 N L B 12 SFA/AWS A5.4 : (E310Mo-15) |
|------------------------|--|

| | |
|------------------------|-----------------|
| Welding Current | DC+ |
| Ferrite Content | FN 0 |
| Alloy Type | 25Cr 22Ni 2Mo N |
| Coating Type | Basic |

Tensile Properties

| Testing Condition | Yield Strength | Tensile Strength | Elongation |
|-------------------|----------------|------------------|------------|
| ISO | | | |
| As Welded | 420 MPa | 600 MPa | 30 % |

Charpy Testing

| Testing Condition | Testing Temp | Impact Value |
|-------------------|--------------|--------------|
| ISO | | |
| As Welded | 20 °C | 70 J |

Typical Weld Metal Analysis %

| C | Mn | Si | S | P | Ni | Cr | Mo | Cu | N |
|--------|-----|-----|---------|---------|----|----|-----|------|------|
| <=0.04 | 4.5 | 0.4 | <=0.020 | <=0.020 | 22 | 25 | 2.1 | 0.05 | 0.14 |

Typical Weld Metal Analysis %

| |
|------------------|
| FN WRC-92 |
| 0 |

Deposition Data

| Diameter | Amps | Efficiency (Per) | Fusion time per electrode at 90Per I max | Deposition rate at 90Per |
|----------------|-----------|------------------|--|--------------------------|
| 2.5 x 300.0 mm | 60-80 A | | | 0.0 kg/h |
| 3.2 x 350.0 mm | 80-110 A | 64 % | 55 sec | 1.7 kg/h |
| 4.0 x 350.0 mm | 110-140 A | 53 % | 75 sec | 2.3 kg/h |