

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.

Specifiche	
Classificazioni	EN ISO 14174 : S A AB 2

Corrente di saldatura	1200
Densit	nom: 0.9 Kg/l
Indice di basicit	nom: 1.0

Classificazioni	
filo	SFA/AWS - EN ISO
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

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

Typical Wire Composition %									
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

Typical Wire Composition %	
FN WRC-92	
Exaton 25.22.2.LMn	
0	

analisi tipica del deposito								
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

Propriet meccaniche tipiche					
filo	Stato	Resistenza allo snervamento	Resistenza alla trazione	Allungamento	Intaglio a V Charpy
Exaton 25.22.2.LMn	Come saldato	380 MPa	570 MPa	40 %	75 J @ 20 °C 40 J @ -196 °C
Exaton 25.22.2.LMn	Come saldato	320 MPa	560 MPa	50 %	65 J @ -196 °C