

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.

Specifiche

Classificazioni	EN ISO 3581-A : E 25 22 2 N L B 12 SFA/AWS A5.4 : (E310Mo-15)
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Corrente di saldatura	DC+
Contenuto di ferrite	FN 0
Tipo di lega	25Cr 22Ni 2Mo N
Tipo di rivestimento	Basic

Proprietà tensili tipiche

Stato	Resistenza allo snervamento	Resistenza alla trazione	Allungamento
ISO			
Come saldato	420 MPa	600 MPa	30 %

Proprietà prova Charpy con intaglio a V

Stato	Temperatura di prova	Valore tenacità
ISO		
Come saldato	20 °C	70 J

analisi tipica del deposito

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

analisi tipica del deposito

FN WRC-92
0

Dati deposito

Diametro	Amp	Efficienza (%)	Tempo di fusione per elettrodo al 90% I max	Tasso di deposito al 90% I max
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