

## Exaton 25.10.4.LR

Exaton 25.10.4.LR is a covered electrode with rutile-basic coating used for welding of super-duplex (austenitic-ferritic) stainless steels of UNS S32750 and S32760 type (e.g. SAF 2507 and Zeron 100). The weld metal has excellent resistance against stress corrosion cracking, general- and pitting corrosion. It has also high resistance to erosion corrosion and corrosion fatigue. Spray transfer gives a bead with a finely rippled surface. There is little spatter and very good slag removal. The electrode has excellent arc stability and fast burn off rate with minimal stub loss. Typical applications include welding of austenitic-ferritic stainless steels such as SAF 2507, UNS S32750 (wrought) and UNS J93404 (cast) and other super-duplex steels, 25% chromium duplex stainless steels with PRE values between 37 and 40, dissimilar joints between duplex and carbon and low-alloy steels, SAF 2205 and corresponding duplex steels where the highest corrosion resistance is required.

| Specifiche      |                                                                                         |
|-----------------|-----------------------------------------------------------------------------------------|
| Classificazioni | EN ISO 3581-A : E 25 9 4 N L R<br>SFA/AWS A5.4 : E2594-16<br>Werkstoffnummer : (1.4410) |
| Omologazioni    | CE : EN 13479<br>UKCA : EN 13479<br>VdTÜV : 07378                                       |

Le approvazioni si basano sulla posizione della fabbrica. Si prega di contattare ESAB per ulteriori informazioni.

|                       |                            |
|-----------------------|----------------------------|
| Corrente di saldatura | DC+, AC                    |
| Contenuto di ferrite  | FN 35-65                   |
| Tipo di lega          | Austenitic-Ferritic CrNiMo |
| Tipo di rivestimento  | Rutile Basic               |

| Proprietà tensili tipiche |                             |                          |              |
|---------------------------|-----------------------------|--------------------------|--------------|
| Stato                     | Resistenza allo snervamento | Resistenza alla trazione | Allungamento |
| ISO                       |                             |                          |              |
| Come saldato              | 730 MPa                     | 900 MPa                  | 25 %         |

| Proprietà prova Charpy con intaglio a V |                      |                 |
|-----------------------------------------|----------------------|-----------------|
| Stato                                   | Temperatura di prova | Valore tenacità |
| ISO                                     |                      |                 |
| Come saldato                            | 20 °C                | 70 J            |
| Come saldato                            | -40 °C               | 45 J            |

| analisi tipica del deposito |    |     |         |        |     |    |    |      |      |
|-----------------------------|----|-----|---------|--------|-----|----|----|------|------|
| C                           | Mn | Si  | S       | P      | Ni  | Cr | Mo | Cu   | N    |
| 0.03                        | 1  | 0.5 | <=0.025 | <=0.03 | 9.5 | 25 | 4  | 0.09 | 0.25 |

| analisi tipica del deposito |      |
|-----------------------------|------|
| FN WRC-92                   | PREN |
| 45                          | >=42 |

| Dati deposito  |           |      |                |                                             |                                |
|----------------|-----------|------|----------------|---------------------------------------------|--------------------------------|
| Diametro       | Amp       | Volt | Efficienza (%) | Tempo di fusione per elettrodo al 90% I max | Tasso di deposito al 90% I max |
| 2.5 x 300.0 mm | 55-85 A   | 22 V | 65 %           | 41 sec                                      | 0.9 kg/h                       |
| 3.2 x 350.0 mm | 70-110 A  | 22 V | 63 %           | 67 sec                                      | 1.1 kg/h                       |
| 4.0 x 350.0 mm | 110-150 A | 22 V | 65 %           | 71 sec                                      | 1.4 kg/h                       |