

Exaton 25.10.4.L

Exaton 25.10.4.L welding wire has been specially developed for welding of Alleima SAF 2507 and other super-duplex steels. The grade is characterized by excellent resistance to stress corrosion in chloride-bearing environments and excellent resistance to pitting and crevice corrosion. Exaton 25.10.4.L can also be used for welding Alleima SAF 2205 and corresponding duplex steels when the highest possible corrosion resistance is required. It is used for Submerged Arc Welding and the recommended flux is Exaton 15W.

Specifications

Classifications	EN ISO 14343-A : S 25 9 4 N L SFA/AWS A5.9 : ER2594
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.012	0.4	0.3	0.0005	0.015	9.5	25	4	0.05	0.07

Typical Wire Composition %

N	Nb	Ti	Co	PRE	FN WRC-92	W
0.25	0.01	0.003	0.04	42	50	0.01