

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.

Specifications

Classifications	EN ISO 3581-A : E 25 9 4 N L R SFA/AWS A5.4 : E2594-16 Werkstoffnummer : (1.4410)
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 07378

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

Welding Current	DC+, AC
Ferrite Content	FN 35-65
Alloy Type	Austenitic-Ferritic CrNiMo
Coating Type	Rutile Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	730 MPa	900 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	45 J
As Welded	20 °C	70 J

Typical Weld Metal Analysis %

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

Typical Weld Metal Analysis %

FN WRC-92	PREN
45	>=42

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
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