

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.

Specificaties

Classificaties	EN ISO 14174 : S A AB 2
-----------------------	-------------------------

Lasstroom	1200
Dichtheid	nom: 0.9 Kg/l
Basiciteits Index	nom: 1.0

Normen

Draad	AWS/EN
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

Goedkeuringen

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

Typische lasmetaalanalyse (%)

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

draad samenstelling

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

draad samenstelling

FN WRC-92
Exaton 25.22.2.LMn
0

Typische mechanische eigenschappen

Draad	Conditionering	Rekgrens	Treksterkte	Rek	Charpy V-groef
Exaton 25.22.2.LMn	Zoals gelast	380 MPa	570 MPa	40 %	75 J @ 20 °C 40 J @ -196 °C
Exaton 25.22.2.LMn	Zoals gelast	320 MPa	560 MPa	50 %	65 J @ -196 °C