

Exaton 22.9.3.LR

Exaton 22.9.3.LR is a chromium-nickel-molybdenum-nitrogen covered electrode with rutile coating for welding of 22-23%Cr duplex (ferritic-austenitic) stainless steels (e.g. SAF 2205). The ferrite content in the all weld metal is approximately 40 FN according to WRC-92. The electrode provides excellent arc stability, low spatter, self peeling slag and smooth weld bead finishing. The all weld metal is characterized by high strength and very good resistance against pitting corrosion (in chloride containing media) as well as stress corrosion cracking. Exaton 22.9.3.LR is used for welding of duplex and lean duplex stainless steels in service temperatures up to 280°C (536°F). Typical base materials welded include ISO: 1.4462, 1.4362, 1.4162, 1.4662, 1.4460 and 1.4417.

Tekniska data

Klassificeringar	EN ISO 3581-A : E 22 9 3 N L R SFA/AWS A5.4 : E2209-17 Werkstoffnummer : 1.4462
Godkännanden	CE : EN 13479 CWB : E2209-17 UKCA : EN 13479 VdTÜV : 19476

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	DC+, AC
Ferrithalt	FN 30-60
Legeringstyp	Duplex CrNiMoN
Höjljtyp	Acid Rutile

Typiska mekaniska värden

Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	690 MPa	850 MPa	25 %

Slagseghetsdata Charpy V

Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	20 °C	60 J
Helsvetsgods	-40 °C	40 J

Svetsgodsanalys %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.03	0.7	0.8	<=0.025	<=0.03	9	23	3	0.1	0.18

Svetsgodsanalys %

PRE	FN WRC-92
=>35.0	37

Insmältningsdata

Diameter	Ström	Bågspänning	Verkningsgrad (%)	Smälttid per elektrod vid 90% av maxström	Insvetstal vid 90 % I max
2.5 x 300.0 mm	50-100 A	29 V	54 %	34 sec	1.1 kg/h
3.2 x 350.0 mm	70-130 A	28 V	59 %	50 sec	1.5 kg/h
4.0 x 350.0 mm	75-185 A	29 V	58 %	53 sec	2.1 kg/h