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, dissimiliar joints between duplex and carbon and low-alloy steels, SAF 2205 and corresponding duplex steels where the highest corrosion resistance is required.

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

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	DC+, AC
Ferrithalt	FN 35-65
Legeringstyp	Austenitic-Ferritic CrNiMo
Höljtyp	Rutile Basic

Typiska mekaniska värden			
Villkor	**Sträckgräns**	**Brottgräns**	**Förlängning**
ISO			
Helsvetsgods	730 MPa	900 MPa	25 %

Slagseghetsdata Charpy V		
Villkor	**Provningstemperatur**	**Slagseghet**
ISO		
Helsvetsgods	20 °C	70 J
Helsvetsgods	-40 °C	45 J

Svetsgodsanalys %									
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

Svetsgodsanalys %	
FN WRC-92	**PREN**
45	>=42

Insmältningsdata					
Diameter	**Ström**	**Bågspänning**	**Verkningsgrad (%)**	**Smälttid per elektrod vid 90% av maxström**	**Insvetstal vid 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