

Exaton 27.31.4.LCuR

Exaton 27.31.4.LCuR is a covered electrode of AWS E383-17 type with rutile coating and normal metal recovery for welding of high-alloy austenitic stainless steels of UNS S08028 (e.g. Sanicro 28) and Alloy 825 type (e.g. Sanicro 41). Exaton 27.31.4.LCuR is suitable for joining highly alloyed fully austenitic stainless steels, such as EN 1.4563 (Sanicro 28) and Alloy 825 (Sanicro 41), which have high corrosion resistance in sulphuric and phosphoric acids and excellent pitting resistance in acid solutions containing chlorides and fluorides, such as sea water. This electrode can be used for surfacing mild and low alloy steels to give protection against pitting corrosion in chloride-containing solutions. Because the product is a bit sensitive for forming hotcracks, a correct welding practice is important.

Tekniska data	
Klassificeringar	EN ISO 3581-A : E 27 31 4 Cu L R SFA/AWS A5.4 : E383-17 Werkstoffnummer : 1.4563
Godkännanden	CE : EN 13749 UKCA : EN 13749

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	AC, DC+
Ferrithalt	FN 0
Legeringstyp	Austenitic CrNiMo
Höljtyp	Acid Rutile

Typiska mekaniska värden			
Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	427 MPa	612 MPa	38 %

Slagseghetsdata Charpy V		
Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	20 °C	66 J

Svetsgodsanalys %									
C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
≤0.025	0.90	0.8	0.006	0.018	32	27	3.5	0.9	0.07

Svetsgodsanalys %	
Co	
0.060	

Insmältningsdata					
Diameter	Ström	Bågspänning	Verkningsgrad (%)	Smälttid per elektrod vid 90% av maxström	Insvetstal vid 90 % I max
2.5 x 300.0 mm	40-95 A	30 V	60 %	33 sec	1.2 kg/h
3.2 x 350.0 mm	55-125 A	30 V	60 %	50 sec	1.6 kg/h
4.0 x 350.0 mm	70-185 A	31 V	61 %	48 sec	2.5 kg/h