Exaton 22.12.HTR

Exaton 22.12.HTR is a covered electrode with rutile-acid coating. It gives a chromium-nickel weld metal that is scaling resistant in air up to 1150°C (2102°F). Spray transfer gives a bead with a finely rippled surface. There is little spatter and very good slag removal. Exaton 22.12.HTR is intended primarily for welding the high temperature steels Alleima 253MA (1) and Avesta 253MA, UNS S30815. It is also suitable for welding other high temperature steels, such as AISI 309 and EN 1.4828. The core wire used contains Ce. (1): 253MA is a trademark owned by Outokumpu Stainless.

Tekniska data	
Klassificeringar	EN ISO 3581-A : E Z 23 10 N R 12
Godkännanden	CE : EN 13479 UKCA : EN 13479

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	AC, DC+
Ferrithalt	FN 4- 10
Legeringstyp	CrNi stainless
Höljtyp	Rutile

Typiska mekaniska värden			
Villkor	**Sträckgräns**	**Brottgräns**	**Förlängning**
ISO			
Helsvetsgods	540 MPa	720 MPa	35 %

Slagseghetsdata Charpy V		
Villkor	**Provningstemperatur**	**Slagseghet**
ISO		
Helsvetsgods	20 °C	55 J

Svetsgodsanalys %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.06	6	1.5	0.007	0.021	10.5	23	0.14	0.08	0.16

Svetsgodsanalys %	
FN WRC-92	**PREN**
6	25

Insmältningsdata					
Diameter	**Ström**	**Bågspänning**	**Verkningsgrad (%)**	**Smälttid per elektrod vid 90% av maxström**	**Insvetstal vid 90 % I max**
2.5 x 300.0 mm	50-90 A	26 V	55 %	44 sec	0.8 kg/h
3.2 x 350.0 mm	70-110 A	25 V	55 %	66 sec	1.0 kg/h
4.0 x 350.0 mm	85-150 A	26 V	56 %	77 sec	1.3 kg/h