

Exaton 20.25.5.LCuR

Exaton 20.25.5.LCuR is a covered electrode with type with rutile-basic coating and normal recovery, used for welding of high-alloy austenitic stainless of UNS N08904 type, also known as 904L (e.g. Alleima 2RK65). Exaton 20.25.5.LCuR gives a fully austenitic chromium-nickel-molybdenum weld metal with especially low carbon content and copper addition. Spray transfer gives a bead with a finely rippled surface, little spatter and good slag removal. It is suitable for joining steels of the 20Cr/25Ni/4.5Mo/1.5Cu type such as 904L (e.g. Alleima 2RK65) used in many areas of the process industry, such as in the production of acetic acid, sulphuric acid, terephthalic or tartaric acid and vinyl chloride as well as other chloride containing media. It is also suitable for use in cooling operations involving sea water or heavily polluted river water. Exaton 20.25.5.LCuR may also be used to join 317L where improved corrosion resistance in specific media is required. These electrodes may be used to join Alleima 2RK65, 904L and 317L to other grades of stainless steel.

Dane techniczne

Klasyfikacje	EN ISO 3581-A : E 20 25 5 Cu N L R 3 2 SFA/AWS A5.4 : E385-16 Werkstoffnummer : 1.4519
Aprobaty	CE : EN 13479 VdTÜV : 02805

Zatwierdzenia s oparte na lokalizacji fabryki. Aby uzyska wiecej informacji, skontaktuj si z ESAB.

Prd spawania	AC, DC+
Zawarto ferrytu	FN 0
Rodzaj stopu	Austenitic CrNiMo
Rodzaj otuliny	Basic Rutile

Typowe waciwoci mechaniczne

Warunki	Granica plastycznoci	Wytrzymaao na rozciąganie	Wyduenie wzgldne
ISO			
Po spawaniu	410 MPa	590 MPa	35 %

Udarno Charpy V

Warunki	Temperatura testu	Udarno KV
ISO		
Po spawaniu	20 °C	65 J

Typowy skad chemiczny stopiwa %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.03	1	0.5	0.005	0.019	25	20	4.7	1.5	0.10

Typowy skad chemiczny stopiwa %

FN WRC-92	PREN
0	36

Dane wydajności stopiwa

rednica	A	V	Sprawno (%)	Czas upalania elektrody	Wydajno stopiwa przy 90% I maks.
2.5 x 300.0 mm	60-85 A	24 V	60 %	44 sec	0.9 kg/h
3.2 x 350.0 mm	85-130 A	27 V	58 %	60 sec	1.5 kg/h
4.0 x 350.0 mm	95-180 A	29 V	51 %	64 sec	1.9 kg/h