

Exaton 31S

31S is a neutral welding flux for submerged arc welding giving good slag removal and fine bead appearance. It is suitable for surfacing with strip and wire electrodes and can also be used for joining. 31S is intended primarily for welding with strip or wire electrodes of the 310LMO type such as 25.22.2.LMn for urea applications.

Dane techniczne

Klasyfikacje	EN ISO 14174 : S A AB 2
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Prd spawania	1200
Gsto	nom: 0.9 Kg/l
Wskanik zasadowoci	nom: 1.0

Klasyfikacje

Drut	AWS/EN
Exaton 25.22.2.LMn	14343-A:B 25 22 2 N L
Exaton 25.22.2.LMn	14343-A:S 25 22 2 N L

Dopuszczenia

Drut
*Selected production units only. Please contact ESAB for more information. Visit esab.com to download specific flux/wire combination fact sheets for more details.

Skad drutu %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
Exaton 25.22.2.LMn									
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	0.05	0.13

Skad drutu %

FN WRC-92
Exaton 25.22.2.LMn
0

Typowy skad chemiczny stopiwa %

C	Mn	Si	S	P	Ni	Cr	Mo	N
Exaton 25.22.2.LMn								
0.02	3.8	0.6	-	-	22	24.5	2	0.12

Typowe waciwoci mechaniczne

Drut	Warunki	Granica plastycznoci	Wytrzymaao na rozciąganie	Wyduenie wzglдне	Udarno KV
Exaton 25.22.2.LMn	Po spawaniu	380 MPa	570 MPa	40 %	75 J @ 20 °C 40 J @ -196 °C
Exaton 25.22.2.LMn	Po spawaniu	320 MPa	560 MPa	50 %	65 J @ -196 °C