

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

Dane techniczne	
Klasyfikacje	EN ISO 3581-A : E 25 9 4 N L R SFA/AWS A5.4 : E2594-16 Werkstoffnummer : (1.4410)
Aprobaty	CE : EN 13479 UKCA : EN 13479 VdTÜV : 07378

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

Prd spawania	DC+, AC
Zawarto ferrytu	FN 35-65
Rodzaj stopu	Austenitic-Ferritic CrNiMo
Rodzaj otuliny	Rutile Basic

Typowe waciwoci mechaniczne			
Warunki	Granica plastycznoci	Wytrzymaao na rozciąganie	Wyduenie wzglдне
ISO			
Po spawaniu	730 MPa	900 MPa	25 %

Udarno Charpy V		
Warunki	Temperatura testu	Udarno KV
ISO		
Po spawaniu	20 °C	70 J
Po spawaniu	-40 °C	45 J

Typowy skad chemiczny stopiwa %									
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

Typowy skad chemiczny stopiwa %	
FN WRC-92	PREN
45	>=42

Dane wydajności stopiwa					
rednica	A	V	Sprawno (%)	Czas upalania elektrody	Wydajno stopiwa przy 90% I maks.
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