Exaton 25.10.4.LB

Exaton 25.10.4.LB is a high alloyed chromium-nickel-molybdenum-nitrogen covered electrode with basic coating for welding of 25%Cr- and superduplex stainless steels (e.g. SAF 2507 and Zeron 100). The basic type of electrode combines good welding properties in all positions with high impact strength at low temperatures. The weld metal is characterized by high strength and very good corrosion resistance. Exaton 25.10.4.LB is used for welding of super duplex stainless steels in service temperatures up to 280°C (536°F), where good impact strength at temperatures down to -50°C is required. Common steel types include: ISO 1.4410, 1.4501 and 1.4507; UNS: S32750, S32760, S31260 and S32550. It can also be used as overmatching consumable for 21-23%Cr duplex stainless steels. The weld metals produced are not completely porosity free, but they fulfil the welding requirements described in ASME IX, Article 1 Welding Requirements- QW 191.1.

Dane techniczne	
Klasyfikacje	EN ISO 3581-A : E 25 9 4 N L B SFA/AWS A5.4 : E2594-15 Werkstoffnummer : (1.4410)
Aprobaty	CE : EN 13479 UKCA : EN 13479

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

Prd spawania	DC+
Zawarto ferrytu	FN 35-55
Rodzaj stopu	Austenitic-Ferritic CrNiMo
Rodzaj otuliny	Basic

Typowe waciwoci mechaniczne			
Warunki	**Granica plastycznoci**	**Wytrzymao na rozciganie**	**Wyduenie wzgldne**
ISO			
Po spawaniu	750 MPa	915 MPa	26 %

Udarno Charpy V		
Warunki	**Temperatura testu**	**Udarno KV**
ISO		
Po spawaniu	20 °C	85 J
Po spawaniu	-50 °C	45 J

Typowy skad chemiczny stopiwa %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.03	0.8	0.6	<=0.025	<=0.03	10	25	4	0.07	0.25

Typowy skad chemiczny stopiwa %	
PRE	**FN WRC-92**
>=42	40

Dane wydajnoci stopiwa					
rednica	**A**	**V**	**Sprawno (%)**	**Czas upalania elektrody**	**Wydajno stopiwa przy 90% I maks.**
2.5 x 300.0 mm	50-80 A	22 V	62 %	50.2 sec	0.72 kg/h
3.2 x 350.0 mm	70-100 A	23 V	65 %	58.67 sec	1.2 kg/h
4.0 x 350.0 mm	100-150 A		73 %		2.0 kg/h