

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.

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

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	AC, DC+
Ferrithalt	FN 0
Legeringstyp	Austenitic CrNiMo
Höljtyp	Basic Rutile

Typiska mekaniska värden			
Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	410 MPa	590 MPa	35 %

Slagseghetsdata Charpy V		
Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	20 °C	65 J

Svetsgodsanalys %									
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

Svetsgodsanalys %	
FN WRC-92	PREN
0	36

Insmältningsdata					
Diameter	Ström	Bågspänning	Verkningsgrad (%)	Smälttid per elektrod vid 90% av maxström	Insvetstal vid 90 % I max
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