

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.

Tekniska data	
Klassificeringar	EN ISO 14174 : S A AB 2

Svetsström	1200
Densitet	nom: 0.9 Kg/l
Basisitets index	nom: 1.0

Klassificering	
Tråd	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

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

Trådens sammansättning %									
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

Trådens sammansättning %	
FN WRC-92	
Exaton 25.22.2.LMn	
0	

Svetsgodsanalys %								
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

Mekaniska egenskaper					
Tråd	Villkor	Sträckgräns	Brottgräns	Förlängning	Charpy V-Notch
Exaton 25.22.2.LMn	Helsvetsgods	380 MPa	570 MPa	40 %	75 J @ 20 °C 40 J @ -196 °C
Exaton 25.22.2.LMn	Helsvetsgods	320 MPa	560 MPa	50 %	65 J @ -196 °C