

Exaton 23.12.2.LR

Exaton 23.12.2.LR is a high alloyed chromium-nickel-molybdenum covered electrode with rutile coating for welding of dissimilar joints between stainless steel and mild or low alloyed steels. It is also used to create buffer layers with a composition of 18%Cr/8%Ni/2%Mo before overlay alloys are deposited. The electrode has excellent arc stability, low spatter and fast burn off rate with minimal stub loss. It is also characterized by improved moisture resistance, self peeling slag, easy post weld finishing. Exaton 23.12.2.LR gives smooth uniform beads and works in any standard weld position. Typical applications are welding of stainless steels to mild or low alloy steels, buffer layers on low alloy steels before overlays of 316 composition, welding of medium carbon hardenable steels e.g. armor plate.

Tekniska data

Klassificeringar	EN ISO 3581-A : E 23 12 2 L R 3 2 SFA/AWS A5.4 : E309LMo-17 Werkstoffnummer : 1.4459
Godkännanden	CE : EN 13479 DNV : NV 309 Mo UKCA : EN 13479 VdTÜV : 07790

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	DC+, AC
Ferrithalt	FN 12-22
Legeringstyp	Austenitic CrNi
Höjljtyp	Acid Rutile

Typiska mekaniska värden

Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	560 MPa	790 MPa	30 %

Slagseghetsdata Charpy V

Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	20 °C	57 J
Helsvetsgods	-20 °C	47 J

Svetsgodsanalys %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	0.8	0.9	0.014	0.021	12.5	23	2.6	0.07	0.08

Svetsgodsanalys %

FN WRC-92
18

Insmälningsdata

Diameter	Ström	Bågspänning	Verkningsgrad (%)	Smälttid per elektrod vid 90% av maxström	Insvetstal vid 90 % I max
2.5 x 300.0 mm	50-90 A	29 V	57 %	45 sec	0.9 kg/h
3.2 x 350.0 mm	60-120 A	27 V	59 %	61 sec	1.4 kg/h
4.0 x 350.0 mm	85-180 A	31 V	61 %	56 sec	2.0 kg/h