

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.

Tekniska data	
Klassificeringar	EN ISO 3581-A : E 25 9 4 N L B SFA/AWS A5.4 : E2594-15 Werkstoffnummer : (1.4410)
Godkännanden	CE : EN 13479 UKCA : EN 13479

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	DC+
Ferrithalt	FN 35-55
Legeringstyp	Austenitic-Ferritic CrNiMo
Höljtyp	Basic

Typiska mekaniska värden			
Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	750 MPa	915 MPa	26 %

Slagseghetsdata Charpy V		
Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	20 °C	85 J
Helsvetsgods	-50 °C	45 J

Svetsgodsanalys %									
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

Svetsgodsanalys %	
PRE	FN WRC-92
>=42	40

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