

## Exaton 25.22.2.LMn

25.22.2.LMn is a manganese alloyed chromium-nickel-molybdenum filler material used for welding UNS S31050, 1.4466, UNS S31603, 1.4435. The weld deposit has excellent low temperature toughness that makes it suitable for joining stainless steels for cryogenic service. 25.22.2.LMn has extensively been used successfully in all critical high-pressure units of modern urea processes, such as: Stripper tubes - Stamicarbon, Montedison IDR Outerlayer of bimetallic (stripper tubes) - Saipem Ferrules - All processes Carbamate condensers - All processes Decomposers - Montedison Reactor coils - UTI 25.22.2.LMn has also found extensive use in other corrosive environments in fertilizer plants, such as: – Nitric acid cooler/condensers cooled with polluted cooling water – Heating coils and pipe in NPK plants – Norsk Hydro process It is used for Submerged Arc Welding.

### Specifications

#### Classifications

EN ISO 14343-A : S 25 22 2 N L  
 Werkstoffnummer : ~ 1.4466  
 AWS A5.9 : S 25 22 2 N L

### Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	0.05	0.13

### Typical Wire Composition %

#### FN WRC-92

0