

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.

Specifications

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

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Ferrite Content	FN 35-55
Alloy Type	Austenitic-Ferritic CrNiMo
Coating Type	Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	750 MPa	915 MPa	26 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-50 °C	45 J
As Welded	20 °C	85 J

Typical Weld Metal Analysis %

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

Typical Weld Metal Analysis %

PRE	FN WRC-92
>=42	40

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
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