Exaton 25.10.4.LR

Exaton 25.10.4.LR is a covered electrode with rutile-basic coating used for welding of super-duplex (austenitic-ferritic) stainless steels of UNS S32750 and S32760 type (e.g. SAF 2507 and Zeron 100). The weld metal has excellent resistance against stress corrosion cracking, general- and pitting corrosion. It has also high resistance to erosion corrosion and corrosion fatigue. Spray transfer gives a bead with a finely rippled surface. There is little spatter and very good slag removal. The electrode has excellent arc stability and fast burn off rate with minimal stub loss. Typical applications include welding of austenitic-ferritic stainless steels such as SAF 2507, UNS S32750 (wrought) and UNS J93404 (cast) and other super-duplex steels, 25% chromium duplex stainless steels with PRE values between 37 and 40, dissimiliar joints between duplex and carbon and low-alloy steels, SAF 2205 and corresponding duplex steels where the highest corrosion resistance is required.

Specifications	
Classifications	EN ISO 3581-A : E 25 9 4 N L R SFA/AWS A5.4 : E2594-16 Werkstoffnummer : (1.4410)
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 07378

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

Welding Current	DC+, AC
Ferrite Content	FN 35-65
Alloy Type	Austenitic-Ferritic CrNiMo
Coating Type	Rutile Basic

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	730 MPa	900 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C	70 J
As Welded	-40 °C	45 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.03	1	0.5	<=0.025	<=0.03	9.5	25	4	0.09	0.25

Typical Weld Metal Analysis %	
FN WRC-92	**PREN**
45	>=42

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate @ 90% I max**
2.5 x 300.0 mm	55-85 A	22 V	65 %	41 sec	0.9 kg/h
3.2 x 350.0 mm	70-110 A	22 V	63 %	67 sec	1.1 kg/h
4.0 x 350.0 mm	110-150 A	22 V	65 %	71 sec	1.4 kg/h