

Exaton 22.9.3.LR

Exaton 22.9.3.LR is a chromium-nickel-molybdenum-nitrogen covered electrode with rutile coating for welding of 22-23%Cr duplex (ferritic-austenitic) stainless steels (e.g. SAF 2205). The ferrite content in the all weld metal is approximately 40 FN according to WRC-92. The electrode provides excellent arc stability, low spatter, self peeling slag and smooth weld bead finishing. The all weld metal is characterized by high strength and very good resistance against pitting corrosion (in chloride containing media) as well as stress corrosion cracking. Exaton 22.9.3.LR is used for welding of duplex and lean duplex stainless steels in service temperatures up to 280°C (536°F). Typical base materials welded include ISO: 1.4462, 1.4362, 1.4162, 1.4662, 1.4460 and 1.4417.

Specifications

Classifications	EN ISO 3581-A : E 22 9 3 N L R SFA/AWS A5.4 : E2209-17 Werkstoffnummer : 1.4462
Approvals	CE : EN 13479 CWB : E2209-17 UKCA : EN 13479 VdTÜV : 19476

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

Welding Current	DC+, AC
Ferrite Content	FN 30-60
Alloy Type	Duplex CrNiMoN
Coating Type	Acid Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	690 MPa	850 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	40 J
As Welded	20 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.03	0.7	0.8	<=0.025	<=0.03	9	23	3	0.1	0.18

Typical Weld Metal Analysis %

PRE	FN WRC-92
=>35.0	37

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	50-100 A	29 V	54 %	34 sec	1.1 kg/h
3.2 x 350.0 mm	70-130 A	28 V	59 %	50 sec	1.5 kg/h
4.0 x 350.0 mm	75-185 A	29 V	58 %	53 sec	2.1 kg/h