

Exaton 25.22.2.LMn

Exaton 25.22.2.LMn is a manganese alloyed chromium-nickel-molybdenum filler material used for welding Sandvik 2RE69 (UNS S31050, 1.4466), Sandvik 3R60 U.G. (UNS S31603, 1.4435). The weld deposit has excellent low temperature toughness that makes it suitable for joining stainless steels for cryogenic service. It is used for MIG/MAG welding.

Exaton 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

Exaton 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

| | |
|--|--|
| Классификация сварочной проволоки | SFA/AWS A5.9 : ER"310LMo" EN ISO 14343-A : G 25 22 2 N L Werkstoffnummer : 1.4466* |
| Одобрения | CE EN 13479 VdTUV 03102 |

Одобрения на материалы выдаются с привязкой к заводу изготовителю. Подробную информацию можно получить в представительствах ESAB.

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|--------------|---------------------|--------------|
| После сварки | 20 °C | 105 J |
| После сварки | -110 °C | 85 J |
| После сварки | -196 °C | 60 J |

Хим. состав проволоки

| C | Mn | Si | S | P | Ni | Cr | Mo | Cu | N |
|-------|-----|------|-------|-------|----|----|-----|------|------|
| 0.001 | 4.6 | 0.12 | 0.003 | 0.013 | 22 | 25 | 2.2 | 0.02 | 0.14 |

Хим. состав проволоки

| Nb | Co | B |
|------|------|--------|
| 0.01 | 0.03 | 0.0018 |

Данные наплавки

| Диаметр проволоки | Current | Voltage | Wire Feed Speed |
|-------------------|-----------|---------|-----------------|
| 0.8 mm | 40-120 A | 15-19 V | 4.0-8.0 m/min |
| 1.0 mm | 60-220 A | 15-28 V | 4.0-12.0 m/min |
| 1.2 mm | 150-260 A | 24-29 V | 3.0-10.0 m/min |
| 1.6 mm | 230-350 A | 25-30 V | 3.0-5.0 m/min |