

## Exaton 20.25.5.LCuR



Exaton 20.25.5.LCuR is a covered electrode with type with rutile-basic coating and normal recovery, used for welding of high-alloy austenitic stainless of UNS N08904 type, also known as 904L (e.g. Sandvik 2RK65).

Exaton 20.25.5.LCuR gives a fully austenitic chromium-nickel-molybdenum weld metal with especially low carbon content and copper addition. Spray transfer gives a bead with a finely rippled surface, little spatter and good slag removal.

It is suitable for joining steels of the 20Cr/25Ni/4.5Mo/1.5Cu type such as 2RK65 and 904L used in many areas of the process industry, such as in the production of acetic acid, sulphuric acid, terephthalic or tartaric acid and vinyl chloride as well as other chloride containing media. It is also suitable for use in cooling operations involving sea water or heavily polluted river water.

Exaton 20.25.5.LCuR may also be used to join 317L where improved corrosion resistance in specific media is required. These electrodes may be used to join 2RK65, 904L, and 317L to other grades of stainless steel.

<b>Klasifikace</b>	SFA/AWS A5.4 : E385-16 EN ISO 3581-A : E 20 25 5 Cu N L R 3 2 Werkstoffnummer : 1.4519
<b>Schválení</b>	CE EN 13479 VdTUV 02805

Schválení jsou platná podle místa výroby. Prosím kontaktujte ESAB pro další informace.

<b>Svařovací proud</b>	AC, DC+
<b>Obsah feritu</b>	FN 0
<b>Typ legování</b>	Austenitic CrNiMo
<b>Typ obalu</b>	Basic Rutile

### Typické vlastnosti v tahu

Podmínky	Mez skluzu	Mez pevnosti v tahu	Prodloužení
<b>ISO</b>			
Po svaření	410 MPa	590 MPa	35 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
Po svaření	20 °C	65 J

### Typického chemického složení svarového kovu v %

C	Mn	Si	Ni	Cr	Mo	Cu
0.03	1	0.5	25	20	4.7	1.5

### Údaje ukládání

Průměr	A	V	Počet elektrod/svarový kov	Čas dohoření/elektroda	Účinnost %	Výkon odtavení při 90 % max. hodnoty proudu
2.5 x 300.0 mm	60-85 A	24 V	91	44 sec	60 %	0.9 kg/h
3.2 x 350.0 mm	85-130 A	27 V	41	60 sec	58 %	1.5 kg/h
4.0 x 350.0 mm	95-180 A	29 V	30	64 sec	51 %	1.9 kg/h