

Exaton 31S

31S is a neutral welding flux for submerged arc welding giving good slag removal and fine bead appearance. It is suitable for surfacing with strip and wire electrodes and can also be used for joining.

31S is intended primarily for welding with strip or wire electrodes of the 310LMo type such as 25.22.2.LMn for urea applications.

Классификации	EN ISO 14174 : S A AB 2
Сварочный ток	1200
Плотность	nom 0.9 Kg/l
Показатель щелочности	nom 1.0

Classifications

Wire	SFA/AWS - EN ISO
Exaton 25.22.2.LMn	A5.9:EQ ^{310LMo} / 14343-A:B 25 22 2 N L
Sandvik 25.22.2.LMn	A5.9:ER ^{310LMo} / 14343:25 22 2 N L

Typical Mechanical Properties

Combined with Wire	Condition	Yield Strength	Tensile Strength	Elongation	Charpy V-Notch
Exaton 25.22.2.LMn	As Welded hr	320 MPa	560 MPa	50 %	125 J @ 20°C 115 J @ -40°C 65 J @ -196°C
Sandvik 25.22.2.LMn	As Welded	380 MPa	570 MPa	40 %	75 J @ 20°C 40 J @ -196°C

Хим. состав наплавленного металла

C	Mn	Si	S	P	Ni	Cr	Mo	N
Exaton 25.22.2.LMn (2 layers)								
0.02	3.6	0.6	-	-	22	24.2	2.0	0.13
Sandvik 25.22.2.LMn								
0.02	3.8	0.6	-	-	22	24.5	2	0.12