

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.

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

It is used for Submerged Arc Welding, for example in combination with Exaton flux 15W.

Классификация сварочной проволоки	SFA/AWS A5.9 : ER"310LMo" EN ISO 14343-A : S 25 22 2 N L Werkstoffnummer : (1.4466)*
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Хим. состав проволоки

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.020	4.5	<=0.2	<=0.015	<=0.015	22.0	25.0	2.1	0.05	0.13