

Exaton 25.22.2.LMn-15



25.22.2.LMn-15 is a chromium-nickel-molybdenum covered electrode with basic coating for welding of austenitic stainless steels for example, Sandvik 2RE69 and Sandvik 3R60 U.G used in the production of ammonium carbamate, nitric acid and inorganic acids. It is also used for surfacing on low alloyed steels.

The electrode combines good welding properties such as arc stability, low spatter and self peeling slag with very low impurity levels. The fully austenitic weld metal (maximum 0.6% ferrite) is very resistant to hot cracking.

25.22.2.LMn-15 is used for welding of Sandvik 2RE69 and Sandvik 3R60 U.G. urea grade materials. But it can also be used for the following types: ISO 1.4466, 1.4335, 1.4435, 1.4436, 1.4477, 1.4578 and 1.4585; UNS S31050, S31002, S31603 and S31600.

Classifications	SFA/AWS A5.4 : (E310Mo-15) EN ISO 3581-A : E 25 22 2 N L B 12
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Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	25Cr 22Ni 2Mo N
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	420 MPa (61 ksi)	600 MPa (87 ksi)	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	70 J (52 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
<=0.04	4.5	0.4	<=0.020	<=0.020	22	25	2.1	0.05	0.14

Typical Weld Metal Analysis %

FN WRC-92
0

Deposition Data

Diameter	Current	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
2.5 x 300.0 mm (0.098 x 11.8 in.)	60-80 A	-	-	-	0.0 kg/h (0.0 lb/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-110 A	31	55 sec	64 %	1.7 kg/h (3.7 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	110-140 A	15	75 sec	53 %	2.3 kg/h (5.1 lb/h)