

Exaton 25.22.2.LMn

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.

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

Sandvik 310LMo 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

Classifications Wire Electrode	SFA/AWS A5.9 : ER [®] 310LMo [*] EN ISO 14343-A : G 25 22 2 N L Werkstoffnummer : 1.4466 [*]
Approvals	CE EN 13479 VdTUV 03102

Approvals are based on factory location. Please contact ESAB for more information.

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	105 J (78 ft-lb)
As Welded	-110 °C (-166 °F)	85 J (63 ft-lb)
As Welded	-196 °C (-321 °F)	60 J (44 ft-lb)

Typical Wire Composition %

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

Typical Wire Composition %

Nb	Co	B
0.01	0.03	0.0018

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm (0.030 in.)	40-120 A	15-19 V	4.0-8.0 m/min (157-315 in./min)
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)
1.6 mm (1/16 in.)	230-350 A	25-30 V	3.0-5.0 m/min (118-197 in./min)