

Exaton 25.20.L

Exaton 25.20.L is a filler wire for joining Sandvik 2RE10 (UNS S31002) and similar grades used in heavily oxidizing media such as pipes in preheaters, coolers and condensers in the chemical industry. It is used for MIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER"310L" EN ISO 14343-A : G Z 25 20 L EN 10088-1 : 1.4335
Approvals	CE EN 13479

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

Shielding Gas	I1, M12, M13 (EN ISO 14175)
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Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	135 J
As Welded	-196 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.02	1.6	0.05	0.001	0.017	20.2	24.2	0.07	0.01	0.03

Typical Weld Metal Analysis %

Nb	Co
0.01	0.04

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.01	1.8	0.1	0.0005	0.014	20.4	24.5	0.1	0.01	0.05

Typical Wire Composition %

Nb	Co
0.01	0.05