

Exaton 20.25.5.LCu

Exaton 20.25.5.LCu welding wire is suitable for joining steels of the 20Cr/25Ni/4.5Mo/1.5Cu type - for example Sandvik 2RK65 used in many areas of the process industry, such as in the production of acetic acid, sulfuric acid, terephthalic or tartaric acid and vinyl chloride. It is also suitable for use in cooling operations involving sea water or heavily polluted river water.

Classifications Wire Electrode	SFA/AWS A5.9 : ER385 EN ISO 14343-A : G 20 25 5 Cu L Werkstoffnummer : ~1.4519
Approvals	CE EN 13479 VdTUV 03941

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

Alloy Type	Austenitic, 20% Cr, 25% Ni, 4.5% Mo, 1.5% Cu, low C
Shielding Gas	M12, M13 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	320 MPa	540 MPa	60 %

Typical Charpy V-Notch Properties

Condition
As Welded
As Welded
As Welded

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.02	1.8	0.3	0.001	0.014	24.8	19.8	4.3	0.01	1.4

Typical Weld Metal Analysis %

N	Nb	Co
0.06	0.01	0.1

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.01	1.8	0.3	0.002	0.013	25	20	4.3	0.02	1.5

Typical Wire Composition %

N	Nb	Ti	Co
0.05	0.01	0.003	0.1

Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
0.8 mm	40-120 A	15-19 V	4.0-8.0 m/min
1.0 mm	60-220 A	15-28 V	4.0-12.0 m/min
1.2 mm	150-260 A	24-29 V	3.0-10.0 m/min
1.6 mm	230-350 A	25-30 V	3.0-5.0 m/min