Exaton 25.22.2.LMn (GTAW)

Exaton 25.22.2.LMn is a manganese alloyed chromium-nickel-molybdenum filler material used for welding UNS S31050, EN 1.4466, (e.g. Alleima® 2RE69). 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

Specifications	
Classifications	EN ISO 14343-A : W 25 22 2 N L SFA/AWS A5.9 : ERG Werkstoffnummer : ~ 1.4466
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 03102

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

Alloy Type	Austenitic, 25% Cr - 22% Ni - 2.2% Mo - low C
Shielding Gas	I1 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	335 MPa	580 MPa	42 %
PWHT 400 °C	225 MPa	410 MPa	29 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
As Welded	20 °C	120 J
As Welded	-196 °C	100 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.011	4.4	0.10	0.002	0.012	21.9	25.1	2.2	0.04	0.12

Typical Weld Metal Analysis %		
Nb	**Co**	**B**
0.01	0.03	0.0016

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.010	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