Exaton 22.12.HTR



Exaton 22.12.HTR is a covered electrode with rutile-acid coating. It gives a chromium-nickel weld metal that is scaling resistant in air up to 1150°C (2102°F). Spray transfer gives a bead with a finely rippled surface. There is little spatter and very good slag removal. Exaton 22.12.HTR is intended primarily for welding the high temperature steels Alleima 253MA (1) and Avesta 253MA, UNS S30815. It is also suitable for welding other high temperature steels, such as AISI 309 and EN 1.4828. The core wire used contains Ce. (1): 253MA is a trademark owned by Outokumpu Stainless.

Specifications	
Classifications	EN ISO 3581-A : E Z 23 10 N R 12
Approvals	CE : EN 13479 UKCA : EN 13479

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

Welding Current	AC, DC+
Ferrite Content	FN 4- 10
Alloy Type	CrNi stainless
Coating Type	Rutile
Min AC OCV	65

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	540 MPa	720 MPa	35 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	55 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.06	0.6	1.5	0.007	0.021	10.5	23	0.14	0.08	0.16

Typical Weld Metal Analysis %	
FN WRC-92	**PREN**
6	25

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 300 mm	50-90 A	26 V	55 %	44 sec	0.8 kg/h
3.2 x 350 mm	70-110 A	25 V	55 %	66 sec	1.0 kg/h
4.0 x 350 mm	85-150 A	26 V	56 %	77 sec	1.3 kg/h