Exaton 25.10.4.L (GTAW)

Exaton 25.10.4.L is designed for gas shielded arc welding of superduplex stainless steels, such as UNS S32750 (e.g. SAF™ 2507), UNS S32760 and UNS S31803 / S32205 (e.g. SAF™ 2205). It combines high strength with excellent ductility. Exaton 25.10.4.L can also be used for joining UNS S32750 and S32760 to carbon steel or low-alloy steels. Exaton 25.10.4.L can also be used for welding duplex stainless steels when the highest possible corrosion resistance is required. The grade is characterized by excellent resistance to stress corrosion cracking in chloride-bearing environments and excellent resistance to pitting and crevice corrosion. Its corrosion resistance is equal to UNS S31254 (e.g. Alleima® 254SMO™) in most applications.

Specifications	
Classifications	EN ISO 14343-A : W 25 9 4 N L SFA/AWS A5.9 : ER2594
Approvals	ABS : 2594 BV : Duplex CE : EN 13479 VdTÜV : 06592 DNV : 1.2 - 3.2 mm UKCA : EN 13479

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

Alloy Type	Austenitic-ferritic (duplex) with approx. 50 FN ferrite - 25% Cr - 10% Ni - 4% Mo - Low C
Shielding Gas	I1, I3, N2 (EN ISO 14175)

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	650 MPa	850 MPa	25 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
As Welded	20 °C	210 J
As Welded	-40 °C	170 J
As Welded	-46 °C	150 J
As Welded	-50 °C	140 J

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.01	0.4	0.4	0.001	0.02	9.5	25	3.9	0.1	0.24

Typical Weld Metal Analysis %			
Nb	**PRE**	**FN WRC-92**	**W**
0.01	41.7	52	0.01

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Cu**
0.012	0.4	0.3	0.0005	0.015	9.5	25	4	0.05	0.07

Typical Wire Composition %						
N	**Nb**	**Ti**	**Co**	**PRE**	**FN WRC-92**	**W**
0.25	0.01	0.003	0.04	42	50	0.01