

EXATON Product Data Sheet

Exaton 25.20.L

W 'Tungsten inert gas arc welding'

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
Per-Ake Bjornstedt	P-O Oskarsson	Per-Ake Bjornstedt	EN008929	EN008279	2020-01-21	1 (2)

REASON FOR ISSUE

Product name changed from Sandvik to Exaton.

GENERAL

25.20.L is a filler wire for joining Exaton 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 TIG-welding.

CLASSIFICATIONS Wire Electrode

EN ISO 14343-A G Z 25 20 L
SFA/AWS A5.9 ER"310L"
Werkstoffnummer 1.4842

APPROVALS

Not
applicable

CHEMICAL COMPOSITION

Wire/Strip (%)

	Nom
C	<=0.020
Si	0.2
Mn	1.8
P	<=0.020
S	<=0.015
Cr	24
Ni	20
Mo	<=0.30
Co	<=0.20
Cu	<=0.10

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded
	Typ
Rp0.2 (MPa)	380
Rm (MPa)	590
Z (%)	57
Charpy V at -196°C (J)	150
	Comments: Elongation, A = 37

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OTHER DATA

CORROSION RESISTANCE: 25.20.L has very good resistance to intergranular corrosion, pitting and stress corrosion cracking due to its high chromium and nickel contents. As an example, the mean value corrosion rate in a Huey test for MIG weld metal (5 x 48 hours in boiling 65% HNO₃) after 1 h sensitization at 675°C (1245 oF), is 0.35 mm/year.

RECOMMENDED WELDING DATA:

The parameters for TIG welding depend largely upon the base metal thickness and the welding application.

Electrode negative and a shielding gas of argon or helium should be used to prevent oxidation of the weld metal.

MICROSTRUCTURE: Fully austenitic matrix.
