

## Exaton 20.25.5.LCu

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. It is used for MIG/MAG welding.

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

Hyväksynät tehdaskohtaisia, lisätietoja ESABilta.

### Tyypilliset lujuusarvot

Tila	Myötöraja	Murtolujuus	Venymä
Hitsatussa tilassa	320 MPa	540 MPa	60 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
Hitsatussa tilassa	20 °C	120 J
Hitsatussa tilassa	-196 °C	100 J

### Langan Koostumus

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
<=0.020	1.8	0.4	<=0.015	<=0.015	25	20	4.5	1.5

### Hitsausarvot

Langan halkaisija	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