

Exaton 20.25.5.LCu (GTAW)

Exaton 20.25.5.LCu welding wire is suitable for joining stainless steels, such as UNS N08904 (e.g. Alleima® 2RK65™) used in many areas of the process industry like 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.

Specifications

Classifications	EN ISO 14343-A : W 20 25 5 Cu L SFA/AWS A5.9 : ER385 Werkstoffnummer : ~1.4519
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 02223

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

Alloy Type	Austenitic, 20% Cr, 25% Ni, 4.5% Mo, 1.5% Cu, low C
Shielding Gas	I1, I3, R1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded 0 °C	440 MPa	585 MPa	35 %
As Welded+ 00 °C	315 MPa	430 MPa	33 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	200 J
As Welded	-196 °C	160 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.02	1.8	0.3	0.001	0.014	24.8	19.8	4.3	0.01	1.4

Typical Weld Metal Analysis %

N	Nb	Co
0.06	0.01	0.1

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.01	1.8	0.3	0.002	0.013	25	20	4.3	0.02	1.5

Typical Wire Composition %

N	Nb	Ti	Co
0.05	0.01	0.003	0.1