

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

Typical Tensile Properties

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

Typical Charpy V-Notch Properties

Condition	Testing Temperature	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	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
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