

## Exaton 27.31.4.LCu

27.31.4.LCu is a copper alloyed chromium-nickel-molybdenum filler material for welding of high-alloy austenitic stainless steels such as Sanicro 28 (UNS S08028, 1.4363) type. It is also suitable for joining Sanicro 41 (UNS N08825, 2.4858) and other similar materials. Due to its outstanding corrosion properties, 27.31.4.LCu can be used in the most diverse environments, such as phosphoric and sulphuric acid, sour gas service in the oil & gas industry and chloride bearing seawater. Typical applications are found in heat exchangers, evaporators and transport piping. It is used for MIG/MAG welding.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.9 : ER383 EN ISO 14343-A : G 27 31 4 Cu L
<b>Aprovações</b>	CE EN 13479 NAKS/HAKC 1.2MM

As aprovações são baseadas na localização da fábrica. Entre em contato com a ESAB para obter mais informações

### Propriedades mecânicas típicas

Condição	Limite de Elasticidade	Resistência à Tração	Alongamento
As Welded	360 MPa	540 MPa	65 %

### Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.01	1.7	0.1	0.001	0.012	31.0	27.0	3.5	0.04	1.0

### Typical Wire Composition %

N	Nb	Co
0.05	0.02	0.03

### Parâmetros de soldadura

Diâmetro do fio	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