

## Exaton 27.31.4.LCu

Exaton 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, 1.4563) 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 TIG-welding.

<b>Classifications</b>	EN ISO 14343-A : W 27 31 4 Cu L SFA/AWS A5.9 : ER383
<b>Approvals</b>	CE : EN 13479 VdTÜV : 02629

<b>Alloy Type</b>	Austenitic
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### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	360 MPa	540 MPa	65 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	200 J
As Welded	-196 °C	140 J

### 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

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.012	1.7	0.05	0.001	0.01	30.5	26.7	3.5	0.03	1.1

### Typical Weld Metal Analysis %

N	Nb	Co
0.05	0.01	0.04