



CEWELD 253 MA Tig

TYPE	CEWELD 253 MA Tig is designed for welding austenitic chromium-nickel steels such as 253MA											
TOEPASSINGEN	For use in high temperature furnaces, combustion chambers, burners etc Not suitable for applications exposed to wet corrosion. Prior to welding, it is recommended to carefully brush or ground black plates and previous weld beads.											
EIGENSCHAPPEN	Cerium combined with silicon improves the oxidation resistance and erosion-corrosion resistance in oxidizing and neutral environments, whereas the nitrogen allows superior strength at high temperatures. Therefore, this filler wire shows excellent resistance to high temperatures (most suitable temperature range is 850 - 1100 °C), high creep strength, very good resistance to isothermal and, particularly, cyclic oxidation.											
CLASSIFICATIE	EN ISO		14343-A: W 21 10 N									
	W.Nr.		1.4835									
GESCHIKT VOOR	Outokumpu 253 MA (1.4835) Outokumpu 153 MA (1.4818)											
GOEDKEURINGEN	CE											
LASPOSITIES	     											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu	Ce
	0.07	1.5	0.6	0.01	0.001	21	10	0.1	0.007	0.16	0.13	0.04
MECHANISCHE WAARDEN	Heat Treatment		R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V					Hardness	
						RT						
	As Welded		410	600	33	110					HRc	
HERDROGEN	Not required											
GAS ACC. EN ISO 14175	I1											