CEWELD 253 MA Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

CEWELD 253 MA Tig is designed for welding austenitic chromium-nickel steels such as 253MA

ANWENDUNGEN

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.

EIGENSCHAFTEN

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.

KLASSIFIKATION

EN ISO	14343-A: W 21 10 N
W.Nr.	1.4835

GEEIGNET FÜR

Outokumpu 253 MA (1.4835)
Outokumpu 153 MA (1.4818)

ZULASSUNGEN

CE

SCHWEISSPOSITIONEN

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 GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	410	600	33	110	HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

I1