



CEWELD 253 MA Tig

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

APPLICATIONS 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.

PROPERTIES 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.

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

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

APPROVALS CE

WELDING POSITIONS

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

MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT		
	As Welded	410	600	33	110		HRC

REDRYING Not required

GAS ACC. EN ISO 14175 11