



CEWELD 253 MA

TYPE	CEWELD 253 MA 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 W.Nr.		14343-A: G 21 10 N 1.4835									
SUITABLE FOR	Outokumpu 253 MA (1.4835) Outokumpu 153 MA (1.4818)											
APPROVALS	CE											
WELDING POSITIONS												
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu	Ce
	0.07	1.5	0.6	0.02	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)	A5 (%)	Impact Energy (J) ISO-V					Hardness	
	As Welded		440	680	38	RT					HRc	
						130						
REDRYING	Not required											
GAS ACC. EN ISO 14175	I1, I3											



CEWELD 253 MA

253 MA 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720682050200