



# CEWELD 253 MA

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                              |                      |                    |                         |    |    |     |       |          |      |      |
|------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------|----------------------|--------------------|-------------------------|----|----|-----|-------|----------|------|------|
| TYPE                                           | CEWELD 253 MA 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<br>W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 14343-A: G 21 10 N<br>1.4835 |                      |                    |                         |    |    |     |       |          |      |      |
| GEEIGNET FÜR                                   | Outokumpu 253 MA (1.4835)<br>Outokumpu 153 MA (1.4818)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                              |                      |                    |                         |    |    |     |       |          |      |      |
| ZULASSUNGEN                                    | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                              |                      |                    |                         |    |    |     |       |          |      |      |
| SCHWEISSPOSITIONEN                             | <div></div> |                              |                      |                    |                         |    |    |     |       |          |      |      |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | 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 |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | R <sub>p0,2</sub> (MPa)      | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |    |    |     |       | Hardness |      |      |
|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                              |                      |                    | RT                      |    |    |     |       |          |      |      |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 440                          | 680                  | 38                 | 130                     |    |    |     |       | HRc      |      |      |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                              |                      |                    |                         |    |    |     |       |          |      |      |
| GAS ACC. EN ISO 14175                          | I1, I3                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                              |                      |                    |                         |    |    |     |       |          |      |      |



# CEWELD 253 MA

253 MA 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720682050200 |