

4893 Kb (253MA)

CATEGORY SMAW Stick Electrodes

TYPE Rutile coated electrode for heat resistant stainless steel SMAW welding.

APPLICATIONS Joining and cladding high heat resistant CrNi-steels of the same kind such as heat treatment equipment and chemical installations.

PROPERTIES High corrosion resistance and excellent weldability on both AC and DC+. The weld deposit is scale and oxidation resistant up to 950°C. Interpass temperature should be kept below 150°C.

CLASSIFICATION

AWS	A 5.4:
EN ISO	1600: E 22 12 R 32
DIN: W.Nr.	1.4893
DIN	8555:

SUITABLE FOR 1.4828, 1.4829, 1.4893, 1.4835, UNS S30815, (Avesta) alloy 253MA, X15CrNiSi 20-23, X12 CrNi 22-12, X8CrNiSiN21-11, X9CrNiSiN21-11-2

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	N	Mo	Fe
0,10	0,800.9-1.1	1,00	22,00	11,00	0,10	0,10	Rem

ALL WELD MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	360	590	27				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-70	2.5	15	21
3.2	350	90-110	2.8	16.8	39
4.0	350	120-140	3.0	18	70

REDRYING TEMPERATURE 250°C/2hr .