MIGWELD 253MA

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 21 11 N W.Nr. : 1.4835		Power generation industry Metallurgy (Steelworks) Petrochemical and chemical industry

- Austenitic chromium-nickel wire with the addition of nitrogen and cerium, intended for welding steels operating at high temperatures, exposed to high corrosion.
- It shows excellent resistance to high temperatures (the most suitable temperature range is 850 - 1100 °C), high creep strength, very good resistance to isothermal and especially cyclic oxidation.
- Not suitable for applications subject to wet corrosion.
- High resistance to sulfides.
- Satisfactory resistance to nitriding and carburizing.
- Prior to welding, thorough brushing or grinding of carbon plates and previous weld seams is recommended.

Application

- Piece i ich części.
- Kanały spalin narażone na wysokie temperatury.
- Rekuperatory ciepła.
- Dysze spalania.

Base material

Outokumpu	SS	ASTM/UNS	W.Nr.	EN 10095	UGINE
153MA	2372	S30415	1.4818		
263MA	2368	S30815	1.4835	X9 CrNiSiNCe21 11 2	
			1.4828	X15CrNiSi20-12	Uginox R 2012
			1.4829	X12 CrNi22-12	
253MA		S30815	1.4893	X8CrNiSiN21-11	
			1.4891	X4CrNiSiN18-10	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	N
0,07	1,50	0,40	21,00	10,00	0,10	0,16

Typical mechanical properties

Yield strength Re [N/mm2]	≥ 350
Tensile strength Rm [N/mm2]	≥ 550
Elongation A5 [%]	≥ 30
Impact energy Kv [J]	~ 130 (20°C) /
Welding current	

	
Additional description	Austenitic microstructure with a controlled amount of ferrite around 5FN. The interstitch temperature should not exceed 150 [°C]
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He / M12 - Ar + 0.5 - 5% CO2 /

Welding parameters and packing

ø	Weight of packet [kg]
1,0	15,0
1,2	15,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl