



# 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 14343-A: G 21 10 N  
W.Nr. 1.4835

**GEEIGNET FÜR** Outokumpu 253 MA (1.4835)  
Outokumpu 153 MA (1.4818)

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

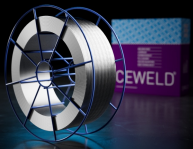
C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu	Ce
0.07	1.5	0.6	0.02	0.001	21	10	0.1	0.007	0.16	0.13	0.04

**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** 11, 13



# CEWELD 253 MA

253 MA 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720682050200