



CEWELD 4893 Kb (253MA)

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	EN ISO	3581-A: E Z 23 10 N R 12
	F-nr	5
	FM	5
	W.Nr.	1.4893

SUITABLE FOR	1.4828, 1.4829, 1.4893, 1.4835, 1.4818, 1.4825, 1.4826, 1.4832, 1.4891, 1.4893 X15CrNiSi 20-23, X12 CrNi 22-12, X8CrNiSiN21-11, X9CrNiSiN21-11-2 UNS S30815, AISI 309 (Avesta) alloy 253MA
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APPROVALS	No Approvals Found
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WELDING POSITIONS	    
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	N
	0.1	1	0.97	22	11	0.1	0.1

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	
	As Welded /	360	590	27	

REDRYING TEMPERATURE	300°C / 2 hr
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GAS ACCORDING EN 14175	
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