



# CEWELD 253 MA

**TYPE** CEWELD 253 MA is designed for welding austenitic chromium-nickel steels such as 253MA

**APPLICATIONS** 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.

**PROPERTIES** 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.

**CLASSIFICATION** EN ISO 14343-A: G 21 10 N  
W.Nr. 1.4835

**SUITABLE FOR** Outokumpu 253 MA (1.4835)  
Outokumpu 153 MA (1.4818)

**APPROVALS** CE

**WELDING POSITIONS**

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

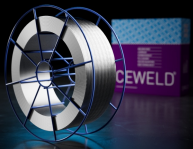
C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu	Ce
0.07	1.5	0.6	0.02	0.001	21	10	0.1	0.007	0.16	0.13	0.04

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V
As Welded /	440	680	38	RT 130

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** I1, I3



# CEWELD 253 MA

253 MA 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720682050200