







# CEWELD 253 MA Tig

TYPE	CEWELD 253 MA Tig 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: W 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 WELD METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Nb	N	Cu	Ce
	0.07	1.5	0.6	0.01	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 RT							
	As Welded /	410	600	33	110							
REDRYING TEMPERATURE	Not required											
GAS ACCORDING EN 14175	I1											