



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 W.Nr.		14343-A: G 21 10 N 1.4835									
GEEIGNET FÜR	Outokumpu 253 MA (1.4835) Outokumpu 153 MA (1.4818)											
ZULASSUNGEN	CE											
SCHWEISSPOSITIONEN	      											
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	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 _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V					Hardness		
					RT							
	As Welded	440	680	38	130					HRc		
RÜCKTROCKNUNG	Not required											
GAS ACC. EN ISO 14175	I1, I3											



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253 MA 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720682050200