Avesta 253 MA

Stick electrode, high-alloyed, austenitic stainless, creep resistant

Classifications

EN ISO 3581-A
E 21 10 N R

Characteristics and typical fields of application

Rutile coated electrode, designed for welding the high temperature stainless steel 253 MA®, used for furnaces, combustion chambers and burners. Both the steel and filler metal offers excellent resistance to oxidation up to 1100 °C. The chemical composition of Avesta 253 MA has a balanced ferrite content of max. 6 FN to give a crack resistant weld metal. Excellent resistance to high temperature corrosion. Not intended for applications exposed to wet corrosion.

Base materials

1.4835 X9CrNiSiNCe21-11-2, 1.4818 X6CrNiSiNCe19-10,
S30815, S30415,
253 MA®, 153 MA™

Typical analysis of all-weld metal

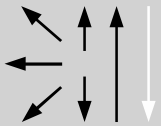
	C	Si	Mn	Cr	Ni	N
wt-%	0.08	1.50	0.70	22.00	10.50	0.18

Mechanical properties of all-weld metal – typical values (min. values)

Heat-treat-ment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation (L_0=5d_0)	Impact work ISO-V KV J	Hardness
	MPa	MPa	%	+20 °C	HB
u	535	725	37	60	215

u untreated, as-welded

Operating data



Polarity:	Electrode identification:	ø mm	L mm	Amps A
DC (+)	253 MA	2.0	300	45 – 65
AC		2.5	350	45 – 80
		3.2	350	70 – 120
		4.0	400	90 – 160
		5.0	400	150 – 200

Approvals

-