

Selectarc **Inox 253 MA-AC** (AC/DC+)

STAINLESS STEEL

DESCRIPTION

Stainless electrode for high temperature. Rutile coated electrode with an austenitic stainless steel deposit resisting to scaling and oxidation up to 1100°C. Regular and stable fusion, good slag removal, nice aspect of the bead.

CLASSIFICATION

EN 1600 : E 22 12 R 3 2 ISO 3581-A : E 22 12 R 3 2

TYPICAL APPLICATIONS

Ovens, thermal equipments for heat treatment, chemical installations.

BASE MATERIALS :

| AISI | UNS | Alloy | EN 10095 | Material N° | UGINE |
|----------|---------|-------|--------------------|-------------|---------------|
| AISI 309 | S 30900 | | X15CrNiSi20-12 | 1.4828 | UGINOX R20-12 |
| | | | X12CrNi22-12 | 1.4829 | |
| | S30815 | 253MA | X8CrNiSiN21-11 | 1.4893 | |
| | | | X9CrNiSiNce21-11-2 | 1.4835 | |

PROCEDURE

Rebaking 2-3 hours at 250°C.
Interpass temperature : < 150°C.

MECHANICAL PROPERTIES

Tensile strength: > 79 770 psi (> 550 MPa)
Yield strength: > 50 763 psi (> 350 MPa)
Elongation: > 25 %

TYPICAL WELD METAL COMPOSITION (%)

| C | Mn | Si | Cr | Ni | Mo | N | Fe |
|-----|-----|-----|------|------|-----|-----|-----|
| 0.1 | 0.8 | 1.0 | 22.0 | 11.0 | 0.1 | 0.1 | Rem |

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")
Amperage: 130 A 100 A 70 A

WELDING POSITIONS



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= + ~ 70 V

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FSH WELDING Canada
Membre de / Member of SELECTARC GROUP - FRANCE

info@fsh-welding.ca
www.fsh-welding.ca

2204, 46^e avenue
Lachine (Mtl), Québec
Canada H8T 2P3

Tél : 514.631.7670
1.800.361.9097
Fax : 514.636.3339