



Selectarc Inox 253MA-AC

High Temperature
Stainless Steel Electrode

Classification

ISO 3581-A : E 22 12 R 3 2

EN 1600 E 22 12 R 3 2

Description & Applications

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.

Main applications: Ovens, thermal equipments for heat treatment, chemical installations.

Base materials

UNS	Alloy	EN 10095	Material N°	UGINE
		X15CrNiSi20-12	1.4828	UGINOX R20-12
		X12CrNi22-12	1.4829	
S30815	253MA	X8CrNiSiN21-11	1.4893	
		X9CrNiSiN21-11-2	1.4835	

Typical Weld Metal Composition (%)

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

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)
>350	>550	>25

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	70	100	130

Redrying 2 hours at 250°C, if necessary. Interpass temperature: < 150°C.

Ind.12



= + ~ 70 V

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