



FCW 253MA P

253MA type
All positions rutile flux cored wire

Classification

ISO 17633-A : T Z 22 10 N H P M 1

Description & Applications

Rutile flux cored wire for gas shielded (Ar + CO₂) arc welding for 316L stainless steel. Especially used for flat position.

Main applications: Current stainless steel joining

Base materials:

| UNS | Alloy | EN 10095 | Material N° | UGINE |
|--------|-------|--------------------|-------------|----------------|
| | | X15CrNiSi20-12 | 1.4828 | UGINOX R 20-12 |
| | | X12CrNi22-12 | 1.4829 | |
| S30815 | 253MA | X8CrNiSiN21-11 | 1.4893 | |
| | | X9CrNiSiNCe21-11-2 | 1.4835 | |

Typical Chemical Composition (%)

| | C | Si | Mn | Cr | Ni | Mo | Cu | Bi | Ce | P | S | N |
|------|------|-----|-----|------|------|---------------|-----|--------|-------|-------|-------|------|
| Min | | | | | | | | | | | | |
| Max | | | | | | Not specified | | | | | | |
| Type | 0.06 | 1.4 | 1.0 | 22.0 | 10.0 | 0.05 | 1.5 | <0.002 | 0.005 | 0.020 | 0.008 | 0.10 |

All Weld Metal Mechanical Properties

| | R _{p0.2} (MPa) | R _m (MPa) | A ₅ (%) | KV (J) |
|------|---------------------------|------------------------|----------------------|----------|
| Min | | | | |
| Max | | | | |
| Type | 490 | 600 | 32 | +20°C 50 |

Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters | | | Shielding Gas |
|--------------|-------------|--------------------|-------------|----------------|---|
| | | Current (A) | Voltage (V) | Stick out (mm) | |
| FCAW = + | 1.2 | 100 - 250 | 23 - 32 | 12 - 25 | ISO 14175: M20/M21 (Ar+CO ₂) 18-20 L/min |



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