



TIG 21/10MA

Old reference: TIG 253MA

Classification

ISO 14343-A : W Z 21 10 N

Description & Applications

High carbon content solid rod for GTAW of heat resisting stainless steels with similar chemical composition resisting to scaling and oxidation up to 1100°C. High creep resistance.

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

Base materials

Austenitic heat resisting steels

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

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co	Ce	N
Min													
Max													
Type	0.08	1.5	0.50	21.0	10.0	0.10	0.10	0.01	0.020	0.005	0.05	0.04	0.15

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	-	-	-
Max	-	-	-	-
Type	450	650	38	+20°C 120

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 l/min Back shielding: I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

Back shielding with Argon or Nitrogen gas or with copper backing support to avoid "back end" rust phenomena.

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