



253 MMA

ISO 3581-A: E 22 12 R 32

DESCRIPTION

Alloy where the weld metal has a scaling temperature beyond 1100°C. The controlled carbon and ferrite levels improve microstructural stability and high temperature strength compared to the 309(L) types whereas the lower nickel content provides better resistance against sulphur attack than the 310 grade. For welding heat resistant steels such as 309(S30900), AVESTA 153MA(S30415) and AVESTA 253MA(S30815).

WELDING POSITIONS



POLARITY

DC + / AC

COATING

Rutile

BASE MATERIALS

Avesta 153MA(1.4891), Avesta 253MA(1.4893), 309(1.4828), 1.4829, 1.4835

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A₅</i> (%)	<i>KV(j)</i>
>550 Typical: 720	>350 Typical: 550	>25 Typical: 35	Typical: +20°C: 55

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Ni	N	Mo	Fe
0,1	0,8	1,0	22,0	11,0	0,1	0,1	Rest

PACKING INFORMATION AND WELDING PARAMETERS

Dimension (mm)	2,5 x 300	3,2 x 350	4,0 x 350
Box (kg)	5/15	5/15	5/15
Item code	8M253MA250	8M253MA320	8M253MA401
Ampere(A)	70	100	130

EQUIVALENT CONSUMABLES

TIG	Meltolit 253 XT
FCW	Meltolit 253 FCW-PW
MIG	Meltolit 253 XM

Redrying if necessary at 250°C for 2 hours